

ULTRA-FILL® HS 2K Primer-Surfacer P50 is a premium quality two-component acrylic urethane primer-surfacer designed for high build and fast filling of repair areas. P50 provides excellent gloss holdout, resistance to sand scratch swelling, and sands easily. At either the maximum or normal build ratios, P50 meets the U.S. National Rule requirement of 4.8 lbs/gal maximum ready-to-spray VOC (volatile organic compound).

TECHNICAL DATA:

• Color	Gray	• Sandability	Excellent
• Recommended Dry Film Thickness after sanding	2.0-6.0 mils	• Gloss Holdout	Excellent
		• Humidity Resistance at 500 hours	No effect
	<u>Maximum Build</u>	<u>Normal Build</u>	
• Volume Solids Sprayable	42.1	38.6	
• Sprayable Viscosity #2 Zahn	22-55	16-18	
• VOC Total	4.2 lbs/gal (503.2 g/l)	4.5 lbs/gal (539.1 g/l)	
• VOC Less Exempt	4.2 lbs/gal (503.2 g/l)	4.5 lbs/gal (539.1 g/l)	

SURFACE PREPARATION:

Bare Substrates: Properly treated Steel, Galvanized Steel*, Aluminum, or Fiberglass.

**Note: With the inconsistencies of galvanized steel, consult your local Sherwin-Williams representative for system recommendations and substrate testing.*

- Solvent clean with SC155 Low VOC Surface Cleaner, followed by R7K158 UltraClean™ Fast Surface Cleaner*, and wipe dry with a clean, dry cloth.
**Check local regulations regarding the use of solvent cleaners.*
- Apply 2-3 medium coats of G.B.P.® LCF Etching Filler PE990 or one double coat of CORROSION SHIELD™ E2G973.

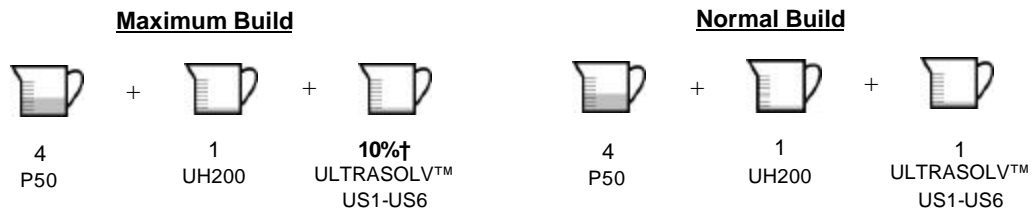
Prepainted Substrates:

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
- Solvent clean with SC155 Low VOC Surface Cleaner, followed by R7K158 UltraClean™ Fast Surface Cleaner*, and wipe dry with a clean, dry cloth.
- Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper (or P-grade equivalent) on a random orbital sander. Use UltraClean™ Surface Cleaner R7K158 to remove sanding residue before recoating.
- Apply 2-3 medium coats of G.B.P.® LCF Etching Filler PE990 or CORROSION SHIELD™ E2G973 to bare metal and body filler. Treat bare aluminum with DUAL-ETCH® Metal Cleaner and Conditioner W4K263.

(For the above products refer to the appropriate product label or data page for complete information.)

MIXING:

- Shake then stir ULTRA-FILL® HS P50 thoroughly before mixing.
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- Pot Life: 1.5 hours at 70°F, 1 hour at 80°F, 30 minutes at 90°F
- †10% of the 5 part mix
- Use mixing stick A718.

Notes:

- For temperatures under 80°F, AS8 Accelerating Reducer can be used in place of ULTRASOLV™ Reducers. Mix 4 parts P50 to 1 part UH200 to 1 part AS8. As temperatures approach 80°F, pot life will be significantly decreased.
- For extra flow/leveling, use the next higher ULTRASOLV™ Reducer (ie. if you are using US1 substitute with US2).

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3. **Flexible Parts:** Mix by volume, 4 parts P50 with 1 UH200, stir, then add 10% ULTRASOLV™ Reducer and 1 part MULTI-FLEX™ Urethane Flexible Additive V6V299.
Note: When repairing flexible bumpers, Plastic Adhesion Promoter UPO7226/UPO7227 must be used under flexibilized P50.
Pot Life: 1.5 hours at 70°F, 1 hour at 80°F, 30 minutes at 90°F.
4. Stir thoroughly and strain before using.

APPLICATION:

1. Adjust air pressure to 25-40 psi for conventional gravity or siphon feed and 4-9 psi at the cap for HVLP. (Note: Higher pressures will speed dry and sand times.)
2. Spray 2-3 medium coats at a gun distance of 8"-10" allowing each to flash to a dull finish.
 Note: Recommended dry film thickness over treated bare steel after sanding is 2.0-2.5 mils minimum.
3. Clean spray gun with Gun and Equipment Cleaner R7K105, R7K106 or quality lacquer thinner immediately after use.
4. Refer to the following Gun and Equipment recommendations for application of P50 Primer-Surfacer:

GUN TYPE	MANUFACTURER	MODEL	NOZZLE	AIR CAP
Siphon Feed	DeVilbiss	JGA 503	EX (.070)	80
Siphon Feed	Sharpe	975	.070/1.8 mm	#10 Red
Gravity Feed	Sharpe	SGF	1.6 mm	#10 Red
Gravity Feed	SATA	MCB	1.7 mm	Supplied
HVLP	DeVilbiss	GTI	1.6 mm	Supplied
HVLP	SATA	MCB	1.7 mm	Supplied
HVLP	Sharpe	Titanium T1	1.4/1.5 mm	Supplied

DRYING SCHEDULE:

1.5 hours at 70°F	AS8
2-3 hours at 70°F	ULTRASOLV® Reducers
20 minutes high setting, 20 inches distance	Short wave infrared. 4:1:1 with US5 only
10 minutes flash, 10 minutes high setting, 36 inches distance	Short wave infrared 4:1:10% with US5 only

RECOATING:

<u>Final Sanding</u>	<u>Sandpaper Grit</u>
To Seal	P400*
To Topcoat	P600*
	* or equivalent

Topcoat with: See Product at a Glance on next page.

Edging new parts: After P50 flashes dull, it may be directly recoated with color or sealer without sanding for up to 4 hours. After 4 hours, P50 must be sanded before recoating.

Maximum recoat time after sanding: 7 days. After 7 days, solvent clean and scuff sand using a gray nylon pad.

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