

PRODUCT DESCRIPTION:

ULTRA ONE^{HPU}™ 3.5 is an acrylic urethane, single-stage system designed for repair of OEM single-stage finishes. ULTRA ONE^{HPU}™ 3.5 provides the ultimate in speed and performance! ULTRA ONE^{HPU}™ 3.5 has excellent durability and outstanding urethane performance properties, and offers fast dry times. ULTRA ONE^{HPU}™ 3.5 reduces cycle times and improves productivity while providing superior gloss and distinction of image. ULTRA ONE^{HPU}™ 3.5 meets requirements of 3.5 lbs/gal for single stage topcoats.

TECHNICAL DATA:

- Air Pressure at Gun

Conventional	50-55 psi	
HVLP/LVLP	9-10 psi cap pressure	
- Viscosity (sprayable) #2 Zahn

	18-22 sec.	
--	------------	--
- Mixing Ratio by Volume See Mixing Section Below
- Recommended Dry Film Thickness 2.0-3.0 mils
- VOC Max (sprayable) 3.5 lbs/gal

SURFACE PREPARATION:

(Refer to respective product labels or data pages for complete information.)

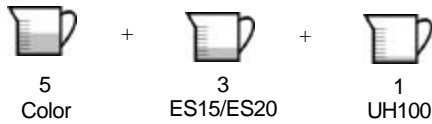
1. Final sand repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer surfacer, final sand repair area with P600 or finer sandpaper. Sanding can be done either wet or dry.
2. Solvent clean area to be refinished with appropriate Sherwin-Williams surface cleaner. Wipe dry with a clean cloth.
3. Treat sand throughs to bare metal with appropriate Sherwin-Williams metal treatment system.
4. If a sealer is required, use any ULTRA-FILL® II 3.5 VOC Sealers, S65 2K Basecoat Transparent / Adhesion Promoter, or S28 ULTRA-FILL® HS.

MIXING:

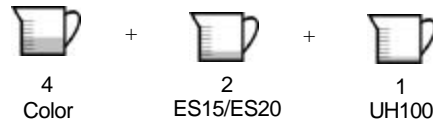
Stir or shake ULTRA ONE^{HPU}™ 3.5 Color thoroughly before mixing.

▪ **Mixing ULTRA ONE™ 3.5:**

If VOC of color is 4.20 lbs/gal or lower:



If VOC of color is 4.21 lbs/gal or higher:



For flexible parts, mix 4 parts ULTRA ONE^{HPU}™ 3.5 Color, to 2 parts ES15/ES20, stir, then add 1 part Urethane Hardener UH100 and 1 part MULTI-FLEX™ Urethane Flexible Additive V6V299.

▪ **Pot life at 75°F:** 90 minutes. With MULTI-FLEX™ V6V299 – 1 hour.

NOTE: If fisheyes are a problem, add ½ ounce of V3K780 Fisheye Eliminator per sprayable quart at mixing ration 4:2:1.

APPLICATION:

1. Adjust air pressure to 9-10 psi at the cap for HVLP/LVLP. Refer to spray gun recommendations listed below.
2. Apply 2 – 3 wet coats at a gun distance of 5-7 inches allowing each coat to become hand slick before applying the next coat.

Wet-on-wet Limited Flash Application – please consult your technical representative for training on the Wet-on-Wet, single application (limited flash) technique. This technique enhances shop productivity once the technician has been trained. For single or two-panel repair: Apply even medium light first coat to entire surface with gun distance of 4 to 6 inches. Allow flashing 2 – 5 minutes before second coat. For multi-panel (3 or more panels) repair; follow first coat immediately with second coat. First coat should even out without missed areas but not heavy and wet. Flash time between coats is not necessary. Check for proper atomization.

3. Blending procedures – Final sand/prepare the blend area with 2500-3000 grit sandpaper. For blending of ULTRA ONE^{HPU}™ 3.5 over reduce the ready-to-spray color at 2:1 with ULTRASOLV® Reducer, tapering out the color into the blend area, but keeping it contained well within the sanded area. Using the 2-Gun Method, apply BS10 in light coats until overspray edge is sufficiently melted in. Best results are obtained by keeping BS10 within the sanded area. After observing the recommended drying schedule, buff/polish the blend edge as necessary.

RECOMMENDED GUNS:

<u>Spray Gun Type</u>	<u>Manufacturer</u>	<u>Spray Gun Model</u>	<u>Nozzle</u>	<u>Air Cap</u>	<u>Gun Pressure</u>
HVLP Gravity Feed	Sata	NR2000	1.3 mm	Use one supplied	*9-10 psi at cap
HVLP Gravity Feed	Sata	NR95	1.3 mm	Use one supplied	*10 psi at cap
HVLP Gravity Feed	DeVilbiss	GTI Millennium	1.3 mm	#2000	*10 psi at cap
HVLP Gravity Feed	Sharpe	Titanium T1	1.4-1.5 mm	Use one supplied	*10 psi at cap
Conv. Gravity Feed	Sata	Jet 90	1.3 mm	Use one supplied	40-50 psi

**Use specific spray gun manufacturer air cap test kit to verify the appropriate air cap pressure for proper atomization.*

**Adjust fluid control for proper delivery and atomization.*

Note: 1.4 mm and 1.5 mm nozzle sets can be used if desired.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 2.0-3.0 mils, thicker films will extend drying times.

• **Air dry times** at 75°F and 50% R.H.:

Dust free	60 minutes
To buff	Overnight

• **Force Dry:**

Short Bake	30 minutes at 140°F Surface Temperature
Full Bake	45 minutes at 140°F Surface Temperature
To Buff	2 hours after cool down

NOTE: Booth ramp up time needed to reach this desired surface temperature should be factored into the total bake cycle.

Bake times are based on actual surface temperature of 140° F. The time to reach this surface temperature is booth dependent. Additional time should be allowed for surface to reach the desired temperature. Use surface temperature gauge to insure proper surface temperature is being obtained.

RECOAT:

ULTRA ONE_{HPU}TM 3.5 can be recoated with itself at any time without a recoat lift. Scuff sand after 24 hours.

BUFFING:

- If buffing of ULTRA ONE_{HPU}TM 3.5 is needed due to dirt:
 1. Allow ULTRA ONE_{HPU}TM 3.5 to cure according to drying schedule before sanding and buffing.
NOTE: Drying schedule is based on 50% relative humidity. Variances in film build, temperature, humidity and application may speed up or slow down the actual time that ULTRA ONE_{HPU}TM is ready to buff.
 2. Sand with 2000 grit sandpaper followed by cross-sanding with 3000 grit sandpaper, checking frequently to ensure that the 2000 scratches are being removed.
 3. Buff by machine with polishing pad using a quality microfinishing compound, and follow with a microfinishing glaze. For ultimate appearance, hand glaze with a soft clean cloth.

PRODUCT AT-A-GLANCE

PRODUCT **ULTRA ONE™ 3.5 VOC 2K Acrylic Urethane Single-Stage System**

Prefix U1

USE

- Available in solid colors.
- An easy-to-apply, acrylic urethane, single-stage system with excellent durability.
- Matches single-stage OEM colors.

SUITABLE SUBSTRATES

- OEM topcoats
- Aged refinishes
- G.B.P.® Etching Filler
- ULTRA -FILL® NP2100
- COLOR-SEAL® 3.5 VOC
- NP75 SqueegeePrime™
- ULTRA -FILL® HS Primers and Sealers
- S65 2K BC Transparent Adhesion Promoter

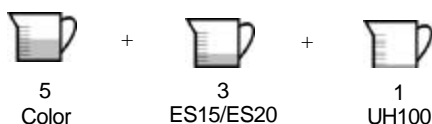
SURFACE PREPARATION

- **Final Sand** repair area when sealing with P400 grit or finer sandpaper. When directly topcoating over primer, final sand repair area with P600 grit or finer sandpaper. Sanding can be done either wet or dry.
- **Solvent clean** with appropriate Sherwin-Williams surface cleaner and wipe dry with a clean cloth.
- **Treat** sand throughs to bare metal with appropriate metal treatment system.
- **Seal** with any ULTRA -FILL® II 3.5 VOC Sealers, S65 2K Basecoat Transparent / Adhesion Promoter, or S28 ULTRA -FILL® HS.

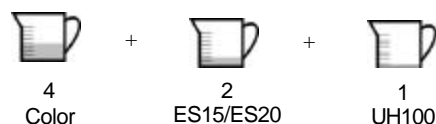
MIXING

- Stir or shake ULTRA ONE^{HPU}™ 3.5 thoroughly before mixing.

If VOC of color is 4.20 lbs/gal or lower:



If VOC of color is 4.21* lbs/gal or higher:



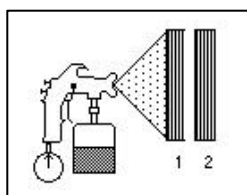
Pot life: 90 minutes

*As indicated on label or microfiche formula

APPLICATION

Siphon Feed – Apply 2 medium wet coats.

Allow each coat to flash until hand slick before next coat.



10 psi at cap

RECOAT

- ULTRA ONE^{HPU}™ 3.5 may be recoated at any time without recoat lift. After 24 hours scuff sand before recoating.

NOTES

- If fisheyes are a problem, add ½ ounce of V3K780 Fisheye Eliminator per sprayable quart at mixing ratio 4:2:1.
- For flexible substrates use MULTIFLEX™ V6V299

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, respirator and latex gloves when using product.

**P
R
O
D
U
C
T

D
A
T
A**

To learn more about Sherwin-Williams Automotive Products, visit our Web site at www.sherwin-automotive.com