

Repaired Metal Part Refinishing

Ultra 7000
PREMIUM AUTOMOTIVE REFINISH PRODUCTS

Best Demonstrated Practices

Area: Body Repair

STEP 1:

Solvent test OE coating by the repair area. If insoluble, proceed to Step 2. If soluble, either remove coating or prepare to prime the complete panel.

STEP 2:

All bodywork must be finished with P180 grit sandpaper.

STEP 3:

Featheredge the repair area with P220 grit DA sandpaper, followed by P320 grit DA sandpaper. Extend the sanded area around the repair with P400 sandpaper to accommodate the primer application.

Note: Thoroughly clean the part with [R7K158](#) Surface Cleaner or [SC155](#) Low VOC Cleaner and wipe dry with a clean cloth.

Area: Paint Prep

STEP 4:

Treat all large areas of bare metal (5" X 5" or larger) with [PE995](#) or [E2G970](#) Corrosion Shield® Primer. Refer to PDS for application instructions.

STEP 5:

Apply 2–3 coats of [P27](#) or [P30](#) SpectraPrime® Color Primer Surfacer making sure that primer is not applied beyond P400 sand scratches. If using [P27](#), allow a 1-5 minute flash between coats. If using [P30](#), no flash necessary — not to exceed 2 minutes.

Note: If using short wave infra-red, use full power at 36" for 10 minutes

STEP 6:

Apply a dry guide coat before block sanding. Block-sand with P400 grit sandpaper and re-apply dry guide to repair area.

STEP 7:

Finish sand repair area with P600 grit sandpaper. If using a DA to finish sand, an interface pad may be used.

Area: Spray Booth

STEP 8:

Apply [Ultra 7000® basecoat](#) with RHF reducer. Allow the [Ultra 7000® basecoat](#) color to flash 10-20 minutes or until a uniform dull finish is achieved before clearcoating.

STEP 9:

Apply one of the Sherwin-Williams Automotive Finishes [Premium Clearcoats](#) - check local VOC regulations. Follow all mixing and application recommendations on the Product Data Sheets.

See Safety Data Sheet and Labels for additional safety information and handling instructions. Safety Data Sheets for the products contained on this Product Data Sheet can be located at www.sherwin-automotive.com. Products shall not be repackaged, modified, blended, or tinted except as specifically instructed by Sherwin-Williams, including but not limited to the incorporation of non Sherwin-Williams products or the use or addition of products in proportions not specified by Sherwin-Williams. Before opening the packages, **READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.**

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. For additional product information, please contact (216) 566-2917.



I-CAR recommends following the paint manufacturer's recommendations for paint preparation, mixing and application of automotive refinishing products.

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