

GENERAL INFORMATION

P540B Ultra System Prime Universal - Black offers excellent curing times at all temperatures with outstanding sandability. It is available in 3 shades that can be mixed to create the grey shades included in the Color Retrieval System. It can be applied on e-coat primed parts. A guide coat is not needed due to its glossy appearance after drying.

This TDS is about the Sanding version.

MIXING RATIO



6 : 1 Prime Universal Black : Activator
+ max 15% Reducer

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,6	2/29
HE	1,4-1,6	1,6-2,0/23-29

APPLICATION



2 - 3 coat 60-180 µm

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	10 - 15 minutes	10 - 15 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	1.5 - 4 hours	45 - 60 minutes	20 - 30 minutes
Dry to polish	-	-	-

SUBSTRATES



P540B Ultra System Prime Universal - Black should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium. Well sanded and degreased GRP, polyester fillers and old paint systems in good condition. Well cleaned and degreased non-sanded OEM primer.

Bare metal not exceeding 10 cm² (P588 Ultra System Prime Corrosion Protector recommended).

On bare steel and aluminium use P588 Ultra System Prime Corrosion Protector for maximum durability and rust protection.

COMPONENTS



AC23 Ultra System Activator Extra Short
AC24 Ultra System Activator Short
AC25 Ultra System Activator Medium
AC26 Ultra System Activator Long
R24 Ultra System Reduce Short
R25 Ultra System Reduce Medium
R26 Ultra System Reduce Long

ADDITIVES



AD850 Ultra System Additive Elastify
Check TDS of AD850. Add before Activator.

SUBSTRATES PLASTIC



Substrate	P540 Sanding
ABS	It has good direct to ABS adhesion, no need to use the P580 Prime Plastic Adhesion.
PP	It is possible to replace the reducer with the P580 Prime Plastic Adhesion. It is also possible to spray the P580 Prime Plastic Adhesion first.
PP/EPDM	It is possible to replace the reducer with the P580 Prime Plastic Adhesion. It is also possible to spray the P580 Prime Plastic Adhesion first.

POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
AC23-AC26 Ultra System Activators	18 - 22 min

INFRARED DRYING



After full flash off and at proper distance	
Half-bake	8 min 50°C
Full-bake	7 min 65°C
See IR Manufacturer information	

SURFACE PREPARATION



Preclean the surface with CL790 Ultra System Clean Surface Solvent. Wipe on and wipe dry. Sand surface with P180-P240 grit abrasive. Remove all sanding debris with compressed air. Sanding vacuum and clean with CL790 Ultra System Clean Surface Solvent. Wipe on and wipe dry. Final sanding before application P280-P320 feather-edge and GPR P400. Plastic surface preparation refer to the P580 Ultra System Prime Plastic Adhesion TDS for full details on the recommended preparation for plastic parts.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



U9001 - U9999 Ultra 9K
Ultra TC1

PHYSICAL DATA

EU REGULATIONS P540B Ultra System Prime Universal - Black		
VOC Code	2004/42/IIIB(c)(540)540	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	15 - 19 Dincup 4 / 20°C
	Specific Gravity (kg/l)	With AC23-AC26 Ultra System Activators: 1,37 (Black)
	Flash Point Closed Cup	33°C / 91,4°F
	Volume % Solids	With AC23-AC26 Ultra System Activators: 44 (Black)
	Economy	With AC23-AC26 Ultra System Activators: 8 m ² (Black) (with 60 µm layer thickness)
	Gloss	Egg Gloss
	Colour	Black

PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

For more detailed information please visit the following link for the Safety Data Sheet:

<https://sds.sherwin-automotive.com/en>

CLEANUP



CL780 Ultra System Clean Gun Solvent

STORAGE/SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).