



ULTRA 9K

U9001 - U9999

GENERAL INFORMATION

Ultra 9K is an easy to apply waterbased, clear over base system with a wide range of toners that can match all OEM colours currently available in the market.

MIXING RATIO



Reducer is implemented in the colour formulation
Custom made formulas add 10-20% U9R1 Ultra System Standard Reducer.



Shake lightly.

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3	Please see appendix attached
HE	1,3	Please see appendix attached

APPLICATION



Re-coat with suitable clear coat within 8 hours.
After 8 hours scuff and re-apply base coat.
Please see attached Best Practice on page 3.

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	Until dry	Flash off	-
Dust free	-	Dust free	-
Dry to handle	-	Dry to handle	-
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

SUBSTRATES



U9001 - U9999 Ultra 9K should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable primer/surfacer by checking the TDS of the primer/surfacer.

POTLIFE



6 months

Potlife mentioned is only for ready to spray colours that are not activated with U9A44 Ultra System Activator WB.

Potlife for activated colours is 30 - 60 minutes.

COMPONENTS



U9R1 Ultra System Standard Reducer
U9A44 Ultra System Activator WB

Please refer to best practice on the next pages, this activator is only suitable in combination with HS420 clear coats.

ADDITIVES



U9A1 Ultra System Underhood Additive UFX1 /.../ UFX7 FX Series

When adding UFX1 /.../ UFX7 FX Series shake the small bottle intensively for 2 minutes before use.

SURFACE PREPARATION



Pre clean the surface with CL710 Ultra System Clean Surface Water wipe on and wipe dry. Sand surface with P400 or finer grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with CL710 Ultra System Clean Surface Water wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



All U9001 - U9999 Ultra 9K applicable clear coats.

INFRARED DRYING



After full flash off and at proper distance	
Half-bake	5 min 60°C
Full-bake	-
See IR Manufacturer information	



ULTRA 9K

U9001 - U9999

PHYSICAL DATA

EU REGULATIONS ULTRA 9K U9001 - U9999		
VOC Code		2004/42/II B(d)420)418
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		II B/d. Topcoat - All types. EU limit values: 420 g/l. (2007) This product contains a maximum of 418 g/l VOC.
Chemical Base	Acrylic dispersion	
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	1.008
	Flash Point Closed Cup	61°C / 141,8°F
	Volume % Solids	14
	Economy	7 m²/L/20 µm 280 ft²/Gal/0,8 mil
	Gloss	-
	Colour	-

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



CCL720 Ultra System Clean Gun Water

After cleaning the spray gun thoroughly blow dry the spray gun with compressed air

STORAGE/SHELF LIFE



Minimum 1 - 3 years; (Under normal storage conditions 5°C - 30°C / 40°F - 85°F) (unopened container).

To prevent freezing, do not expose the product to temperatures below 10°C / 50°F during transportation and storage.

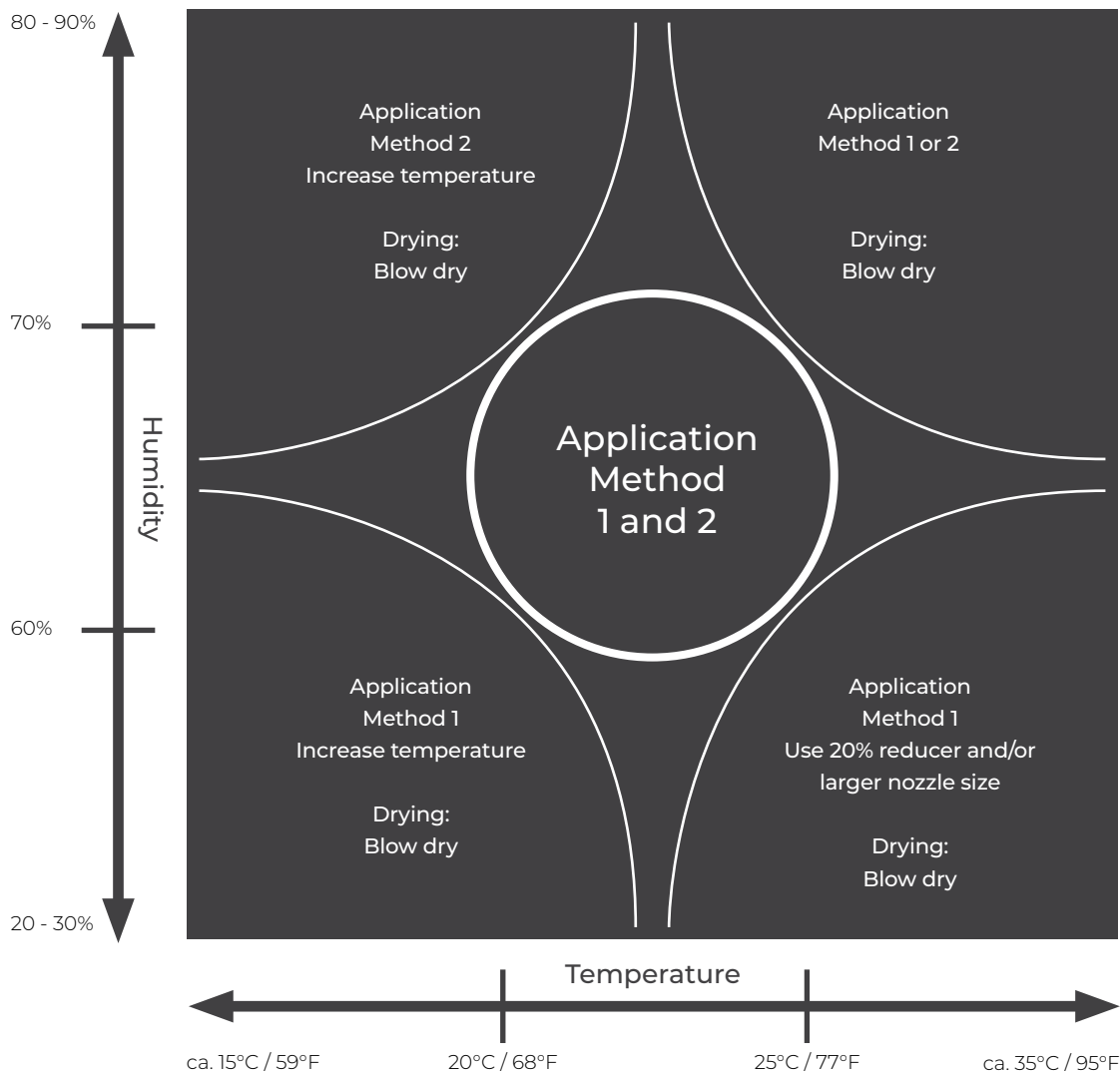
NOTES



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BEST PRACTICES

Water Basecoat Application



APPLICATION METHOD 1:

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	Two singles wet coats, wet on wet to cover	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	
STEP 3	Drop coat (effect colours only)	1 bar / 14,5 psi
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	



Note:

Surface must be carefully cleaned.
If necessary, first apply a mist coat and blow dry.

APPLICATION METHOD 2: *

	DESCRIPTION	AIR PRESSURE (BAR / PSI)
STEP 1	First single wet coat	2 bar / 29 psi
STEP 2	Blow dry untill matt at 30 - 35°C / 85 - 95°F	
STEP 3	Second single wet coat	2 Bar / 29 PSI
STEP 4	Blow dry untill matt at 30 - 35°C / 85 - 95°F	
STEP 5	Drop coat (effect colours only)	1 Bar / 14,5 PSI
STEP 6	Blow dry untill matt at 30 - 35°C / 85 - 95°F	

At temperatures between 20 - 25°C and a relative humidity between 60 - 70%, both application methods 1 and 2 are recommended.
* Application 2 is preferred for deep black solid colours to achieve the darkest shade.

PREPARATION



Colour check

Always determine the right colour and/or colour variant. This should be done at the earliest stage possible, preferably when estimation of the repair is done. Creating a spray-out at this stage is best practice.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



Cleaning

Clean with CL790 Ultra System Clean Solvent and/or CL710 Ultra System Clean Water

STEP 1 Prepare blending area



Dry sanding

Prepare the blending area by dry sanding with DA sander orbit 3-5 grit P1500. Prevent sand from entering through edges.



Wet sanding

Prepare the blending area by wet sanding using grit P2000/P3000.



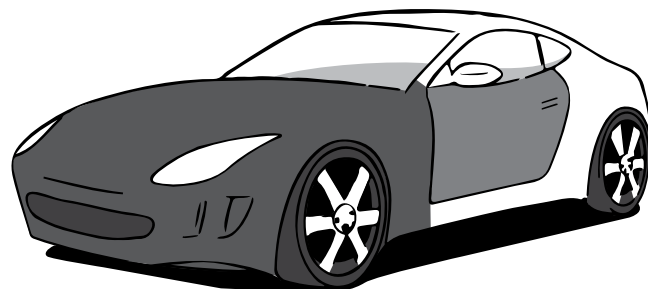
Scuffing

Prepare the blending area by using an ultra-fine scuffing pad.



Cleaning

Clean with CL790 Ultra System Clean Solvent and/or CL710 Ultra System Clean Water



STEP 2 Mixing & application of U9020



Blending additive

Mix U9020 Ultra 9K Base Additive with U9R1 Ultra System Reduce Standard

Mixing Ratio

U9020 Ultra 9K Base Additive + 10-20% U9R1 Ultra System Reduce Standard



Application

Apply one flowing coat off U9020 Ultra 9K Base Additive on 2/3 off the blending area.



Gun Setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1.1-1.3	2,0 bar / 29 psi
HE	1.1-1.3	2,0 bar / 29 psi



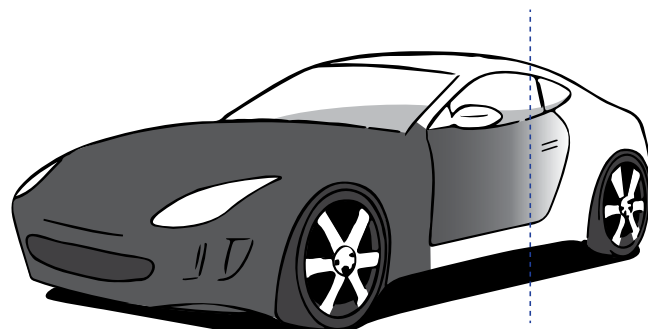
Flash-off

Until achieving a uniform matt surface.



Note

It is also possible to carry out this process in reverse order. Apply Ultra9K for full coverage on the repair area. Dry the Ultra9K then apply the U9020 Ultra 9K Base Additive mix to the blending area dry and finish the blending process as described.



STEP 3 Application of Ultra9K



Application Color
Ultra9K colour formula + 10% U9R1 Ultra System
Reduce Standard
See option in Colour Retrieval System.



Application
Apply 2-3 coats or until covered arcing into blending area. Do not apply color beyond area 3 (See picture).

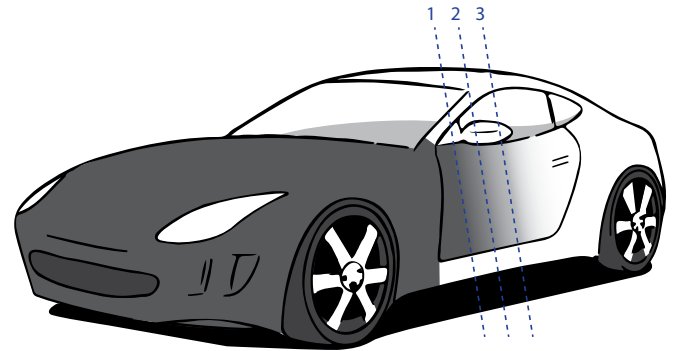


Gun Setup

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1.1-1.3	2,0 bar / 29 psi
HE	1.1-1.3	2,0 bar / 29 psi



Flash-off
Until achieving a uniform matt surface.



STEP 4 Application of Ultra9K drop coat



Application of drop coat
Apply drop coat at double distance at 1 bar.
Stay within the blending area.
Do not apply color beyond area 3 (See picture).



Gun Setup

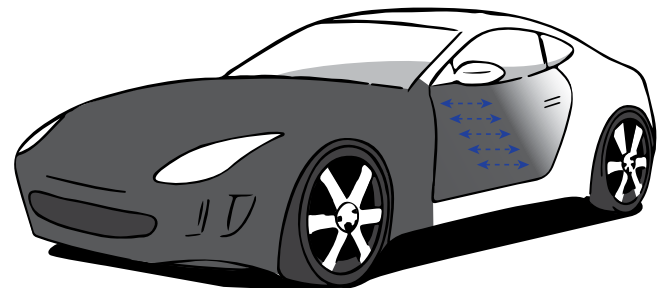
	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1.1-1.3	1.0bar / 14.5 psi
HE	1.1-1.3	1.0bar / 14.5 psi



Flash-off
Until achieving a uniform matt surface.



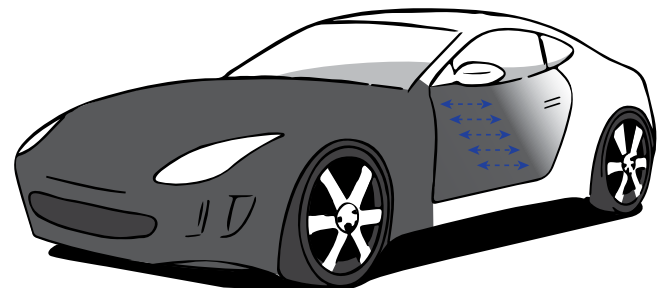
The drop coat must be applied for color and effect, this will also assist color blending.



STEP 5 Application of clear coat



Select a suitable Ultra System Clear and follow the technical information on the TDS.



PREPARATION



Colour check

Always determine the right colour and/or colour variant. This should be performed at the earliest stage possible, preferably when estimation of the repair is performed. Creating a spray-out at this stage is best practice.



Protection

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



Cleaning

Clean with CL790 Ultra System Clean Surface Solvent and/or CL710 Ultra System Clean Surface Water.



Surface preparation

Use sanding paper grit P500 or finer on repair area, and P1500 on blending area.

STEP 1



Mixing Ultra 9K (step 1)

Add 2% of U9A44 Ultra System Activator WB by weight to the mixed and thinned colour formula.



Mixing Ultra 9K (step 2)

Add 15 - 20% of the U9R1 Ultra System Standard Reducer, Mix thoroughly without incorporating air.



Note:

After adding the hardener, the activated basecoat should be applied within:

30 minutes for effect colours
60 minutes for solid colours

Clean spray-gun immediately after use.

STEP 2



Application

Apply colour @ 2,0 bar, drop-coat @ 1 bar.
For gun set-up see table below.
Blend into the adjacent panel if needed.

	NOZZLE (MM)	AIR PRESSURE (PSI)
HVLP	1.2 - 1.3	2 / 29
HE	1.2 - 1.3	2 / 29



Flash-off

Until a uniform matt surface.

FINISHING PRODUCTS



CL790 Ultra System Clean Surface Solvent
CC130 Ultra System Clear Multi Dry
CC140 Ultra System Clear Elite Gloss
CC110 Ultra System Clear Universal
CC133 Ultra System Clear Production
CC144 Ultra System Clear Speed Elite
U9R1 Ultra System Standard Reducer
CL710 Ultra System Clean Surface Water
U9A44 Ultra System Activator WB