



SHERWIN-WILLIAMS®

Automotive Finishes

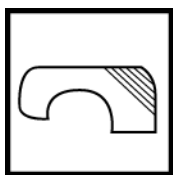
0.5 VOC DTM Urethane

HS Urethane Primer-Sealer

E2W805 – White & E2B806 - Black

PRODUCT OVERVIEW

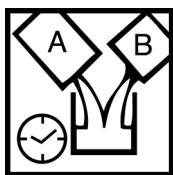
High Solids Urethane Primer is an air dry or low bake, direct-to-metal, high performance urethane primer designed for Fleet, Truck, and Original Equipment Manufacturers that are under strict VOC regulations. High Solids Urethane Primer has a VOC of 0.5 pounds per gallon.



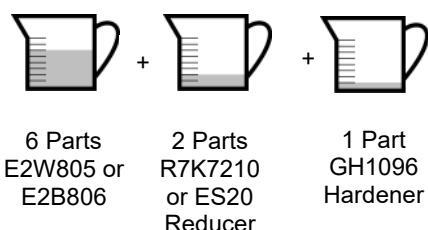
SUITABLE SUBSTRATES

- Cold rolled steel
- Hot rolled steel
- Galvanized steel
- Galvaneal
- SMC (Sheet Molding Compound)
- Aluminum
- Fiberglass

NOTE: Not for use for immersion services. Not for use on surfaces with extended surface temperatures of 250°F or more.



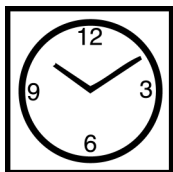
MIXING



APPLICATION

For Pressure/Siphon feed, apply 2 medium coats at a gun distance of 8-10 inches. Spray to hiding. For HVLP, apply 1 full wet coat with 50% overlap, then apply a second coat in a cross-coat method. Recommended dry film thickness is 2.0-2.5 mils.

1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
3. Conventional: For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.



DRYING SCHEDULE

	<u>Unaccelerated</u>	<u>With 2 oz. GA1097 Accelerator</u>
Hand Slick	30 minutes	15 minutes
Topcoatable	45 minutes	20 minutes
Dust Free	2 hours	1 hour
Tack Free	2 hours 15 minutes	1.5 hours
Tape Free	2-3 hours	1.5 hours
Dry to Sand	4 hours	2 hours



PERSONAL PROTECTION

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



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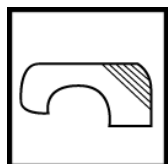
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PRODUCT DATA SHEET



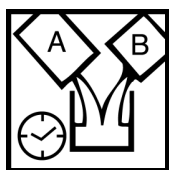
- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
- **Solvent clean** with the appropriate Sherwin-Williams® solvent cleaner and wipe dry with a clean cloth.
- **Scuff sand** with 180- to 320- grit sandpaper.
- **Reclean** with appropriate Sherwin-Williams® solvent cleaner to remove sanding residue, and wipe dry with a clean cloth.



SUITABLE SUBSTRATES

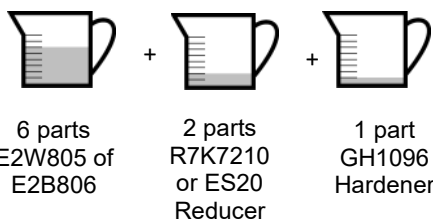
- Cold rolled steel
- Hot rolled steel
- Galvanized steel
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- SMC (Sheet Molding Compound)
- Aluminum
- Fiberglass

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MIXING

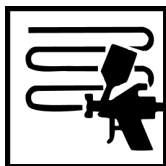
- Mix thoroughly before applying.
- Mix 6 parts E2W805/E2B806 with 2 parts R7K7210 Reducer and 1 part GH1096 Hardener.
- Stir thoroughly and strain before mixing.
- Pot life at 70-80°F is 2 hours.



NOTES:

- For increased temperatures, Reducer ES20 can be used for improved overspray acceptance and melt-in.
- Up to 2 ounces of GA1097 can be used per ready to spray gallon. Pot life with GA1097 is 1-1.5 hours. See Drying Schedule section for dry times.

REDUCER	TEMPERATURE RANGE
R7K7210	50-75°F
ES20	70-85°F

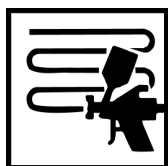


APPLICATION

1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
3. Conventional: For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
4. For Pressure/Siphon Feed: Apply 2 medium coats at a gun distance of 8-10 inches. Spray to hiding. For HVLP, apply 1 full wet coat with 50% overlap, then apply a second coat in a cross-coat method. Recommended dry film thickness is 2.0-2.5 mils.



PRODUCT DATA SHEET



EQUIPMENT

Gun Type

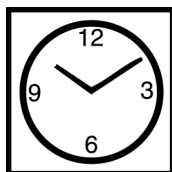
Conventional Siphon Feed
Conventional Gravity Feed
Conventional Pressure Feed
HVLP Gravity Feed
HVLP Pressure Feed

Nozzle

1.3-1.5 mm
1.3-1.5 mm
0.8-1.1 mm at 8-12 oz/min
1.3-1.5 mm
0.8-1.1 mm at 8-12 oz/min

Air Pressure

50-55 psi
50-55 psi
50-55 psi
10 psi at cap
10 psi at cap



DRYING SCHEDULE

Air dry at 75°F and 2.0 mils. Dry times will be extended by thicker films, low temperature, or high humidity.

	<u>Unaccelerated</u>	<u>With 2 oz. GA1097 Accelerator</u>
Hand Slick	30 minutes	15 minutes
Topcoatable	45 minutes	20 minutes
Dust Free	2 hours	1 hour
Tack Free	2 hours 15 minutes	1.5 hours
Tape Free	2-3 hours	1.5 hours
Dry to Sand	4 hours	2 hours

Bake: 45 minutes at 180°F unaccelerated.

Dry to sand – after 15 minutes cool down.

Dry to recoat – after 15 minutes cool down and a thorough sanding using 320- or 400-grit paper.

RECOATING

- Topcoats may be applied without sanding within the specified times below.
- When the maximum topcoat time has been exceeded, sanding becomes mandatory.

	Unaccelerated	Unaccelerated	Accelerated	Accelerated
	Min topcoat time	Max topcoat time	Min topcoat time	Max topcoat time
GENESIS® 3.5/2.8 SS	45 minutes	7 days	15 minutes	3 days
GENESIS® Basecoat	45 minutes	7 days	15 minutes	3 days
Dimension® 3.5 SS	45 minutes	7 days	15 minutes	3 days
Ultra 7000®™ Basecoat	45 minutes	7 days	15 minutes	3 days

SUITABLE TOPCOATS

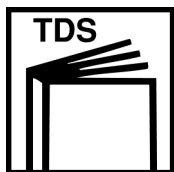
- Genesis® Basecoat/Clearcoat
- Genesis® 2.8/3.5 Low VOC Acrylic Urethane
- Genesis® 0.5 VOC Acrylic Urethane
- 3rd Dimension® Urethane Enamels
- ULTRA 7000® Basecoat



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TECHNICAL DATA

Mixing Ratio by Volume	6:2:1	Physical Properties:	
Max VOC @ 6:2:1	0.5 lbs/gal	Humidity - 100 hours	Pass
Ready to Spray Volume Solids	53.7-54.3 %	Impact Resistance (direct at 80 in-lbs.)	Pass
Coverage @ 1 mil dry	862-872 FT ² /gal	Flexibility (1/8" conical mandrel)	Pass
Pot Life	2 hours at 70-80°F	Salt Spray – 240 hours	Pass
Viscosity (sprayable) Gardener #2 Zahn Cup (ISO calibrated)	17-23 sec	Gloss Holdout *(at 15 minute recoat)	Good
Recommended Dry Film Thickness	2.0-2.5 mils		

0.5 VOC DTM Urethane E2W805	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	13.84	1658	12.01	1439
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	20.1	41.1	32.5	53.0
Solids	79.9	58.9	67.5	47.0
Water	0	0	0	0
Exempt Compounds	17.9	36.5	30.8	50.0
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	0.31	0.38	0.21	0.25
VOC Less Exempt	0.50	0.59	0.42	0.50
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.000	0.00	0.000

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

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