



SHERWIN-WILLIAMS
Automotive Finishes

HP Process™ Clearcoat

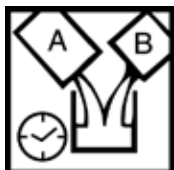
HPC15

With AIR-BAKE™ Technology
SPOT REPAIR (1-3 panels) OPTION






SUITABLE SUBSTRATES

- OEM Topcoats
- Aged Refinishes
- ULTRA 7000® Basecoat Colors
- Properly Prepared Flexible Plastics



MIXING - Spot Repair Option (1- 3 panels)

 +  + 

5 HP Process™ Clearcoat HPC15

1 ULTRA SYSTEM® Reducers US2, US3, or US4

1 ULTRA SYSTEM® Hardener UH80

See **NOTES** section below - alternative mixing ratio exists for Multi-panel repairs.

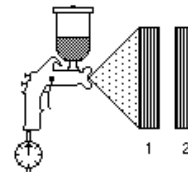
REDUCER	AIR-BAKE™
US2 – Cool	50°F - 70°F
US3 – Moderate	70°F - 85°F
US4 – Warm	80°F - 95°F

Note: If above 90°F, limit to vertical panels or use the multi-panel mix ratio option.



SPEED/PRODUCTIVITY APPLICATION

- 7-8 psi at air cap - HVLP.
- 18-30 psi inlet - Compliant spray guns.
- Recommended fluid nozzle is 1.3-1.4 mm.
- Recommended dry film thickness is 1.4-1.8 mils.
- Gun distance of 5-7 inches.
- Panel by panel application is recommended.
- Apply 2 wet coats with no flash between coats (one double wet coat).

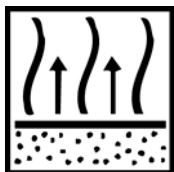


Please consult your technical representative for training on the speed/productivity application technique. This technique is preferred and enhances shop productivity once the technician has been trained. Best results will be achieved by using 7-8 psi at air cap, which is slightly less psi than for most high solids clearcoats.

TO BLEND CLEARCOAT EDGE

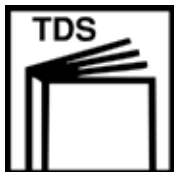
For in-panel blends, apply the second coat of the double wet coat application slightly beyond your first coat completely covering the overspray edge from the first pass. Immediately following this, melt in the overspray edge using Sherwin-Williams® Ure-Blend® 1K Urethane Blending Solvent BS11 (Aerosol). Apply only enough blending solvent necessary to melt blend edge.

DRYING SCHEDULE



	AIR-BAKE™
Dust Free	5-7 minutes
To Sand / Buff*	15-30 minutes
*15 minutes = 1.4-1.8 mils at 75°F	
Applying higher film builds <u>will</u> extend the time to sand and buff.	

NOTES



- Pot life: 2 hours at 75° F.
- If a second application (double wet coat) is desired, the first application must be fully cured (45 minutes at 75°F). Scuff sand with P800 grit or finer sandpaper on a DA with interface pad. Remove sanding dust, and tack clean before applying more clearcoat.
- If fisheyes are a problem, add ½ ounce of Sherwin-Williams® Fisheye Eliminator V3K780 per sprayable quart of clearcoat. Do not use fisheye eliminator in Basecoat Color.
- For Multi-panel (3 or more) repair option see page 2.

PRODUCT DATA SHEET



SHERWIN-WILLIAMS®
Automotive Finishes

HP Process™ Clearcoat

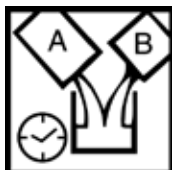
HPC15

With AIR-BAKE™ Technology
MULTI-PANEL OPTION



SUITABLE SUBSTRATES

- OEM Topcoats
- Aged Refinishes
- ULTRA 7000® Basecoat Colors
- Properly Prepared Flexible Plastics



MIXING - Multi-Panel Option (3 or more panels)

See **NOTES** section below - alternative mixing ratio exists for repairs over AWX®

4 HP Process™ Clearcoat HPC15
1 ULTRA SYSTEM® Reducers US3, US4*, or US5*
1 ULTRA SYSTEM® Hardeners UH80 or UH90**

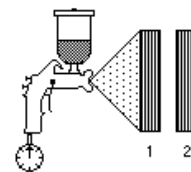
REDUCER	AIR-BAKE™
US3 – Moderate	70°F - 80°F
*Preferred: US4 – Warm	80°F - 90°F
*Preferred: US5 – Hot	90°F - 100°F

** Use UH90 only in HPC15 multi-panel option, if 90°F or higher.

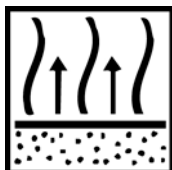


SPEED/PRODUCTIVITY APPLICATION

- 7-8 psi at air cap - HVLP.
- 18-30 psi inlet - Compliant spray guns.
- Recommended fluid nozzle is 1.3-1.4 mm.
- Recommended dry film thickness is 1.4-2.0 mils.
- Gun distance of 5-7 inches.
- Panel by panel application is recommended.
- Apply 2 wet coats with no flash between coats (one double wet coat).



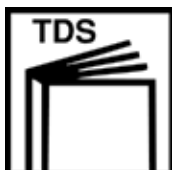
Please consult your technical representative for training on the speed/productivity application technique. This technique is preferred and enhances shop productivity once the technician has been trained. Best results will be achieved by using 7-8 psi at air cap, which is slightly less psi than for most high solids clearcoats.



DRYING SCHEDULE

	AIR-BAKE™
Dust Free	10 minutes
To Sand / Buff*	25-40 minutes
* 25-40 minutes = 1.4-2.0 mils at 75°F	
Applying higher film builds <u>will</u> extend the time to sand and buff.	

NOTES



- Pot life: 2 hours at 75° F.
- If a second application (double wet coat) is desired, the first application must be fully cured (45 minutes at 75°F). Scuff sand with P800 grit or finer sandpaper on a DA with interface pad. Remove sanding dust, and tack clean before applying more clearcoat.
- If fisheyes are a problem, add ½ ounce of Sherwin-Williams® Fisheye Eliminator V3K780 per sprayable quart of clearcoat. Do not use fisheye eliminator in Basecoat Color.
- For AWX Performance Plus™ Waterborne Basecoat option see page 3.

PRODUCT DATA SHEET



SHERWIN-WILLIAMS®
Automotive Finishes

HP Process™ Clearcoat

HPC15

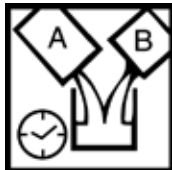
With AIR-BAKE™ Technology

(AWX PERFORMANCE PLUS™ WATERBORNE BASECOAT OPTION)






SUITABLE SUBSTRATES

- OEM Topcoats
- Properly Prepared Flexible Plastics
- Aged Refinishes
- AWX Performance Plus™ Waterborne Basecoat Colors



MIXING - AWX PERFORMANCE PLUS™ WATERBORNE BASECOAT OPTION

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4 HP Process™ Clearcoat HPC15 + 1 ULTRA SYSTEM® Reducers US2, US3, US4, or US5 + 1 ULTRA SYSTEM® Hardeners UH80 or UH90**

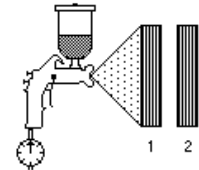
REDUCER	AIR-BAKE™
US2 – Cool	50°F - 70°F
US3 – Moderate	70°F - 80°F
US4 – Warm	80°F - 90°F
US5 – Hot	90°F - 100°F

** Use UH90 only in HPC15 as a multi-panel Option, if 90°F or higher.



SPEED/PRODUCTIVITY APPLICATION

- 7-8 psi at air cap - HVLP.
- 18-30 psi inlet - Compliant spray guns.
- Recommended fluid nozzle is 1.3-1.4 mm.
- Recommended dry film thickness is 1.8-2.5 mils.
- Gun distance of 5-7 inches.
- Panel by panel application is recommended.
- Apply 2 wet coats with no flash between coats (one double wet coat).



Please consult your technical representative for training on the speed/productivity application technique. This technique is preferred and enhances shop productivity once the technician has been trained. Best results will be achieved by using 7-8 psi at air cap, which is slightly less psi than for most high solids clearcoats.

Alternate application over AWX Performance Plus™ Waterborne Basecoat Colors:

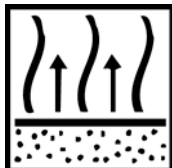
- § Apply 1 single wet coat over the Basecoated areas only.
- § Allow this to flash for 60-seconds.
- § Apply two wet coats with no flash between coats over the entire panel.

SPECIAL NOTE FOR COLDER CLIMATES WITH HIGH HUMIDITY

When using Sherwin-Williams® HP Process™ Clearcoat HPC15 over AWX Performance Plus™ Waterborne Basecoat it is recommended to perform an Infra Red (IR) "After-Bake" prior to placing the vehicle out into a cold, damp environment. IR "After-Bake" application should be done outside the booth to avoid slowing booth productivity. We recommend allowing the HP Process™ Clearcoat HPC15 to "Air-Bake" for 15-20 minutes inside the booth then move the vehicle to an area of the shop where a 5-minute IR "After-Bake" at 120°F can be applied to the repair area. This will ensure that the AWX Performance Plus™ Waterborne Basecoat Color and the HP Process™ Clearcoat HPC15 are sufficiently cured to safely go out into a cold, damp environment.

TO BLEND CLEARCOAT EDGE

For in-panel blends, apply the second coat of the double wet coat application slightly beyond your first coat completely covering the overspray edge from the first pass. Immediately following this, melt in the overspray edge using Sherwin-Williams® Ure-Blend® 1K Urethane Blending Solvent BS11 (Aerosol). Apply only enough blending solvent necessary to melt blend edge.

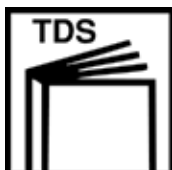


DRYING SCHEDULE

	AIR-BAKE™
Dust Free	10 minutes
To Sand / Buff*	25-40 minutes
* 25-40 minutes = 1.8-2.5 mils at 75°F	
Applying higher film builds <u>will</u> extend the time to sand and buff.	

NOTES

- Pot life: 2 hours at 75° F.
- If a second application (double wet coat) is desired, the first application must be fully cured (45 minutes at 75°F). Scuff sand with P800 grit or finer sandpaper on a DA with interface pad. Remove sanding dust, and tack clean before applying more clearcoat.
- If fisheyes are a problem, add ½ ounce of Sherwin-Williams® Fisheye Eliminator V3K780 per sprayable quart of clearcoat. Do not use fisheye eliminator in Basecoat Color.





SHERWIN-WILLIAMS®
Automotive Finishes

HP Process™ Clearcoat

HPC15

With AIR-BAKE™ Technology

PRODUCT DATA SHEET

PRODUCT DESCRIPTION

Sherwin-Williams® HP Process™ Clearcoat HPC15 with AIR-BAKE™ Technology is an extremely productive clearcoat designed for a range of speed applications from single to multi-panel repairs. As one of the premium clearcoat offerings from Sherwin-Williams Automotive Finishes, HP Process™ Clearcoat HPC15 offers outstanding application properties, gloss, appearance, and buffability. HP Process™ Clearcoat HPC15 offers an extremely fast cycle time for increased productivity and does not require the use of a high temperature bake cycle, which generates substantial energy savings. It meets National Rule VOC Regulations.

SURFACE PREPARATION

Sherwin-Williams® HP Processä Clearcoat HPC15 is designed for use over AWX Performance Plus™ Waterborne Basecoat Colors and/or ULTRA 7000® Basecoat Colors, and properly prepared OE clearcoat in the case of blending.

1. For spot repairs 1-3 panels - See page 1 of product data sheet.
2. For multi-panel repairs (3 or more) - See page 2 of product data sheet.
3. For repairs over AWX Performance Plus™ Waterborne Basecoat Colors - See page 3 of product data sheet.

Preparation for Blending Panels

1. Clean with appropriate Sherwin-Williams® surface cleaner* and wipe dry with a clean cloth.
2. Blend panel should be sanded with P800 grit or finer paper, or scuff sanded with a gray scuff pad and ULTRA SYSTEM® Liquid Scuffing Agent USP90 and water. Rinse thoroughly and dry with a clean cloth.
(Only sand with P800 grit paper for AWX Performance Plus™ Waterborne Basecoat Colors. Do Not use USP90 with AWX Performance Plus™ Waterborne Basecoat Colors.)
3. Repeat step one, and then thoroughly tack surfaces with a clean tack cloth.

*Check local regulations regarding the use of surface cleaners.

- Allow AWX Performance Plus™ Waterborne Basecoat Color to flash 10-20 minutes or completely dehydrate before applying clearcoat.
- Allow ULTRA 7000® Basecoat Color to flash 10-20 minutes before applying clearcoat.



PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

REGULATORY DATA

	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	7.75	928	7.86	941
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	60.7	67.3	59.4	66.2
Water	0	0	0	0
Exempt Compounds	22.7	26.7	15.0	17.8
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	2.94	352	3.49	418
VOC Less Exempt	4.01	481	4.25	509
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.00	0.14	0.017



SHERWIN-WILLIAMS®
Automotive Finishes

HP Process™ Clearcoat

HPC15

With AIR-BAKE™ Technology

LABEL CAUTION INFORMATION

Sherwin-Williams® HP Processä Clearcoat HPC15

DANGER! FLAMMABLE! HARMFUL IF INHALED - MAY AFFECT THE BRAIN OR NERVOUS SYSTEM, CAUSING DIZZINESS, HEADACHE OR NAUSEA. IRRITATES EYES, SKIN AND RESPIRATORY TRACT. Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. VAPOR HARMFUL. Use only with adequate ventilation. This product must be used with an appropriate catalyst. Follow the respirator requirement and instructions on the catalyst. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage. FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing, Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately. DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE. Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. This product must be mixed with other components before use. 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. DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR PROFESSIONAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET.

ULTRA SYSTEM® Reducers US2, US3, US4, and US5

DANGER! FLAMMABLE! HARMFUL IF INHALED - MAY AFFECT THE BRAIN OR NERVOUS SYSTEM, CAUSING DIZZINESS, HEADACHE OR NAUSEA. IRRITATES EYES, SKIN AND RESPIRATORY TRACT. CAN BE ABSORBED THROUGH THE SKIN. MAY CAUSE BLOOD DAMAGE. Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. VAPOR HARMFUL. Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage. FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing, Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately. DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE. Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. Contains Ethylene Glycol Monobutyl Ether Acetate which may cause blood damage. DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR PROFESSIONAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET.



SHERWIN-WILLIAMS®
Automotive Finishes

HP Process™ Clearcoat

HPC15

With AIR-BAKE™ Technology

ULTRA SYSTEM® Hardener UH80 and UH90

DANGER! FLAMMABLE! VAPOR AND SPRAY MIST HARMFUL, OVEREXPOSURE MAY CAUSE LUNG DAMAGE. MAY CAUSE ALLERGIC RESPIRATORY AND SKIN REACTION, EFFECTS MAY BE PERMANENT. CAUSES EYE IRRITATION. HARMFUL IF INHALED - MAY AFFECT THE BRAIN OR NERVOUS SYSTEM, CAUSING DIZZINESS, HEADACHE OR NAUSEA. Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. VAPOR AND SPRAY MIST HARMFUL. Gives off harmful vapor of solvents and isocyanates. DO NOT USE IF YOU HAVE CHRONIC (LONGTERM) LUNG OR BREATHING PROBLEMS, OR IF YOU HAVE EVER HAD A REACTION TO ISOCYANATES. USE ONLY WITH ADEQUATE VENTILATION. WHERE OVERSPRAY IS PRESENT, A POSITIVE PRESSURE AIR SUPPLIED RESPIRATOR (NIOSH approved) SHOULD BE WORN TO PREVENT EXPOSURE. IF UNAVAILABLE, AN APPROPRIATE PROPERLY FITTED APPROVED NIOSH VAPOR/PARTICULATE RESPIRATOR MAY BE EFFECTIVE. Follow directions for respirator use. Wear the respirator for the whole time of spraying and until all vapors and mists are gone. If you have any breathing problems during use, LEAVE THE AREA and get fresh air. If problems remain or happen later, IMMEDIATELY call a doctor - If not available get emergency medical treatment. Have this label with you. IRRITATES SKIN AND EYES. Avoid contact with eyes and skin. In case of eye contact, flush immediately with plenty of water for 15 minutes and call a doctor - If not available get emergency medical treatment. In case of skin contact, wash thoroughly with soap and water. Clothes contaminated by a spill should be removed and laundered. Keep container closed when not in use. Reacts with water in closed container to produce pressure which may cause container to burst. Do not transfer contents to other containers for storage. FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing, Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately. DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE. Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. This product must be mixed with other components before use. Before opening the packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS. DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR PROFESSIONAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET.