

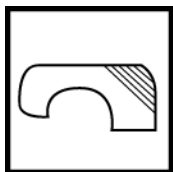


**SHERWIN-WILLIAMS**  
Automotive Finishes

# ULTRA® MB Motor Coach Basecoat

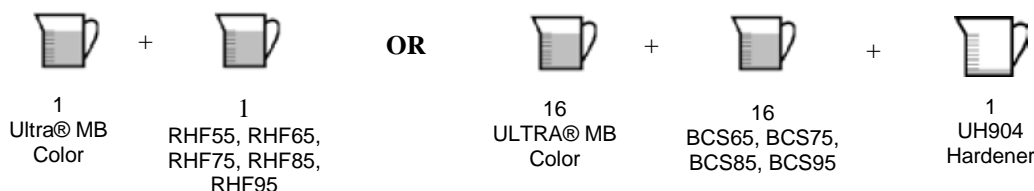
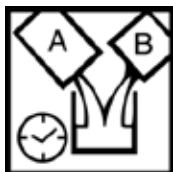
PRODUCT AT-A-GLANCE

## SUITABLE SUBSTRATES



- Sanded Gelcoat
- OEM Enamels
- Aged Finishes
- ULTRA-FILL® HS
- Primer Surfacers/Sealers
- E2A819 Primer
- NP75 Sealer
- GBP® Etching Filler
- COLOR-PRIME™ Tintable Primer
- ULTRA-FILL II® Undercoats
- ULTRA-FILL® CP Primer-Surfacer
- S64 Adhesion Promoter
- S65 2K Sealer
- SpectraPrime™ / SpectraSeal™
- 988 Etch primer (for small sand-throughs)

## MIXING



**Note:** RHF55 is recommended for stripe colors only.

**Note:** Stir or shake MB Color thoroughly before mixing. Stir thoroughly after mixing and strain mixed product before use.

**Note:** Reduced Pot Life is 5 days.

## APPLICATION

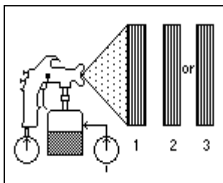


### Pressure Feed / Siphon Feed

Apply 2-3 medium coats. Allow each coat to flash until hand slick before next coat.

**45 psi**

-Use a 25 to 30 psi low-pressure mist coat to even out metallic/mica colors and for blending

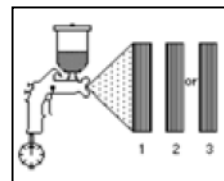


### HVLP

Apply 2-3 medium coats. Allow each coat to flash until hand slick before next coat.

**8-10 psi @ cap**

-Use a low-pressure (4-5 psi) mist coat to even out metallic/mica colors and for blending



## RECOAT

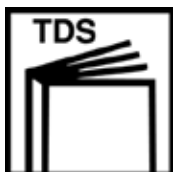
- Clear coat ULTRA® MB color with ULTRA 7000® Clear coat. See Clear coat data sheet for specific instructions.
- Recoat basecoat color before 14 days or remove basecoat color.

## NOTES

- Basecoat will develop satin finish when dry.
- Do not use fisheye eliminators in basecoat color.
- If dirt or contaminant must be removed, light scuff sanding with P500 grit sandpaper over sufficiently cured basecoat is acceptable.
- Basecoat must be re-applied to scuff sanded areas before clear coating.
- Do not solvent clean basecoat.

## PERSONAL PROTECTION

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





## PRODUCT DESCRIPTION:

ULTRA® MB is an easy-to-apply, fast drying basecoat developed specifically for the Motor Coach and Recreational Vehicle Market. ULTRA® MB uses state of the art resin technology that gives improved flash times, tape track resistance and excellent basecoat/clear coat performance. ULTRA® MB can be taped over in as little as 10 minutes. ULTRA® MB offers exceptional clear coat gloss hold out and distinction of image, while providing excellent system performance. ULTRA® MB utilizes special stabilizers that make the blending of colors easier and locks metallic / mica flakes into position enhancing mottle resistance. ULTRA® MB meets MACT compliance standards for coating plastic on over the road vehicles.

## SURFACE PREPARATION:

1. Final sand repair area with P400 -P800 grit sandpaper. When directly top coating over primer, final sand with P600-P800 sandpaper.
2. Solvent clean with appropriate Sherwin-Williams surface cleaner and wipe dry with a clean cloth.
3. Treat sand-throughs to bare metal with self-etching primer (988 aerosol).

### *Preparation for Blending Panels (Prior to Basecoat Application):*

1. Solvent clean with appropriate Sherwin-Williams surface cleaner and wipe dry with a clean cloth.
2. Blend panel should be sanded with P800 – P1000 grit sand paper on a random orbital sander or with USP90 scuffing gel and water using a gray nylon-scuffing pad. Rinse surface thoroughly and wipe dry with a dry clean cloth.
3. Repeat step one - then thoroughly tack the surface to be painted with a clean tack cloth.

## APPLICATION:

1. Adjust air pressure at gun to 45 psi for siphon feed or pressure feed (adjust pot pressure to 8-10 psi). Use 20 psi for small repairs to minimize over spray. Set air cap psi at 8-10 pounds for HVLP.
2. Apply 2-3 medium wet coats at a gun distance of 8-10 inches; spray to hiding, allowing each coat to become hand slick before applying the next coat.
  - a. For Metallics – Low Pressure Mist Coat: After hiding is achieved and the basecoat has been allowed to flash to a dull appearance, apply a low pressure mist coat at 25 to 30 psi for a conventional gravity feed gun by increasing gun distance to 10 – 12 inches to achieve a wet droplet appearance. This will help keep metallic / mica particles uniform. The low-pressure mist coat is also used when blending into the original finish.
  - b. For small repairs, apply basecoat at 20 –30 psi to minimize over spray; a low-pressure mist coat is not required in this situation.

## BLENDING:

1. To maximize blending ULTRA MB basecoat, mix ready to spray (RTS) basecoat color with RTS S65 Basecoat Transparent 2K Adhesion Promoter 25% (1 part RTS S65 to 4 parts RTS basecoat) and up to 100% (1 part RTS S65 to 1 part RTS basecoat) for final blending application. (For complete product usage regarding S65, refer to S65 Product Data Sheet.)

## DRYING SCHEDULE:

	BCS/RHF65 or RHF55 – Cool Weather	BCS/RHF75 – Standard	BCS/RHF85 – Warm Weather	BCS/RHF95 – Hot Weather
<b>Dust Free</b>	5 minutes	5 minutes	6 minutes	7 minutes
<b>Tape Time</b>	8-10 minutes	8-10 minutes	10-15 minutes	15-20 minutes
<b>Recoat Time</b>	15-20 minutes	20-30 minutes	25-35 minutes	30-40 minutes

Note: Times are based on the recommended dry film thickness of .3 – 1.5 mils for basecoat color. Thicker film will extend drying schedule. Air dry times at 75° and 50% Relative Humidity.

## REGULATORY DATA:

	As Packaged		As Applied	
	G/L	Lbs/Gal	G/L	Lbs/Gal
<b>VOC Total</b>	676	5.64	743	6.20
<b>VOC Less Exempt</b>	726	6.05	769	6.42
	<b>Lbs/Gal Solids</b>	<b>Lbs/Lbs Solids</b>	<b>Lbs/ Gal Solids</b>	<b>Lbs/Lbs Solids</b>
<b>HAPS</b>	15.11	1.43	10.45	1.04
	<b>Wt. %</b>	<b>Vol. %</b>	<b>Wt. %</b>	<b>Vol. %</b>
<b>Volatiles</b>	73.3%	78.0%	85.4%	89.0%
<b>Water</b>	NA	NA	NA	NA
<b>Exempt Compounds</b>	5.8%	6.8%	3.0%	3.4%
	<b>G/L</b>	<b>Lbs/Gal</b>	<b>G/L</b>	<b>Lbs/Gal</b>
<b>Density</b>	922	7.70	902	7.53