



ULTRA TC1

U1001 - U1999

GENERAL INFORMATION

Ultra TC1 is a VOC compliant high-quality 2-pack polyurethane top coat system with high UV resistance and gloss retention. It has been specifically developed for passenger cars and commercial vehicles.

MIXING RATIO



2 : 1 Ultra TC1: AC15 Activator + 20% Reducer
 2 : 1 Ultra TC1: AC15 Activator + 20%
 AD890 Ultra System Additive Masking

GUN SETUP



| | NOZZLE (MM) | AIR PRESSURE (BAR / PSI) |
|------------------|-------------------|--------------------------|
| HVLP | 1,2-1,3 | 2/29 |
| HE | 1,2-1,3 | 2,0-2,5/29-36 |
| Pressure tank | 0,85-1,1 | - |
| Airless / Airmix | 0,009"-0,011"/40° | 180-200 |

APPLICATION



1,5 - 2 coats 50 - 75 µm (2,0 - 3,0 mil)
 3 - 12 minutes flash off.

FLASH OFF AND DRY TIMES



| TYPE OF REPAIR | ACTIVATOR | REDUCER | TIME (AT 60°C) | TONER |
|--|-----------|---------|----------------|-----------|
| High temp. total respray objects (van) | AC15 | R16 | 40 minutes | Ultra TC1 |
| Normal temp. total respray high temp. panel repair | AC15 | R15 | 30 minutes | Ultra TC1 |
| Normal temp. panel repair | AC15 | R14 | 20 minutes | Ultra TC1 |

SUBSTRATES



Ultra TC1 should only be applied over well sanded/ scuffed and degreased primed bare steel, primed aluminum and primed plastic. Well sanded GRP, OEM primer and old paint systems in good condition.

Please make sure you choose a suitable Ultra Prime product by checking the TDS of these products.

POT LIFE AT 20°C (68°F)



30 minutes - 60 minutes

COMPONENTS



AC15 Activator TC1 Medium
 R14 Ultra System Reduce TC1 Short
 R15 Ultra System Reduce TC1 Medium
 R16 Ultra System Reduce TC1 Long
 R30 Ultra System Reduce TC1 Dissolver
 AD890 Ultra System Additive Masking

ADDITIVES



AD820 Ultra System Additive Texture Fine
 AD830 Ultra System Additive Texture Coarse
 AD850 Ultra System Additive Elastify
 AD880 Ultra System Additive Matte

Add before activator.

SURFACE PREPARATION



Pre clean the surface with CL790 Ultra System Clean Surface Solvent 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 CL790 Ultra System Clean Surface Solvent wipe on and wipe dry.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



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INFRARED CURE



| After full flash off and at proper distance | |
|---|------------|
| Half-Bake | 4 min 60°C |
| Full-bake | 8 min 80°C |
| See IR Manufacturer information | |

PHYSICAL DATA

| EU REGULATIONS | | |
|--|--|--------------------------------|
| VOC Code | 2004/42/IIIB(d)(420)420 | |
| Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product. | IIB/d. Topcoat - All types. EU limit values: 420 g/l. (2007) This product contains a maximum of 420 g/l VOC. | |
| Chemical Base | 2K Polyurethane Topcoat | |
| Physical Properties | Viscosity (RTS) | 16 - 17 Dincup 4 / 20°C |
| | Specific Gravity (kg/l) | 1.034 |
| | Flash Point Closed Cup | 28,5°C / 83,3°F |
| | Volume % Solids | 54 |
| | Economy | 11 m ² /L/50 µm |
| | | 440 ft ² /Gal/2 mil |
| | Gloss | High 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



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).

NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.