



**AUTOMOTIVE FINISHES**

# G.B.P.<sup>®</sup> Etching Filler

**Olive Drab E2-G980 / Neutral Green (Chromate Free) E2-G983**

## PRODUCT DESCRIPTION

G.B.P.<sup>®</sup> is a two-component, self-etching filler that etches the surface of bare metal substrates to provide excellent paint adhesion and corrosion resistance. G.B.P.<sup>®</sup> has good filling properties, sprays smoothly, and dries fast. G.B.P.<sup>®</sup> Etching Filler is available in two versions:

- E2-G980, olive drab, lead free version
- E2-G983, neutral green, lead and chromate free version for compliance in areas with heavy metal restrictions.

## TECHNICAL DATA

• Color	E2-G980	Olive Drab	• Induction time	None
	E2-G983	Neutral Green	• Viscosity (Sprayable)	
• Wt/Gal	E2-G980	8.84	1:1 #4 Ford Cup	14-16 seconds
	E2-G983	9.20	#2 Zahn Cup	16-19 seconds
• Mixing ratio by volume: with R7-K981 or R7-K982		1:1	2:1 #4 Ford Cup	20-23 seconds
with R7-K985		2:1	#2 Zahn Cup	23-26 seconds
• VOC as applied E2-G980 at 1:1 with	6.00 lbs./gal		• Salt spray resistance	Excellent (500 hours)
R7-K981 or R7-K982			• Flash point	E2-G980
E2-G983 at 1:1 with	5.83lbs./gal		E2-G983	45°F P-M
R7-K981 or R7-K982			R7-K981	48°F P-M
E2-G980 at 2:1 with	5.78 lbs/gal		R7-K982	45°F P-M
R7-K985			R7-K985	33°F P-M
E2-G983 at 2:1 with	5.53 lbs/gal		<u>E2-G980</u>	<u>E2-G983</u>
R7-K985			• Lead free	Yes
• Volume Solids	1:1	11%	• Chromate free	No
	2:1	15%		Yes

## SURFACE PREPARATION

### Bare Substrates:

\* Note: With the inconsistencies of galvanized steel, contact your local SHERWIN-WILLIAMS Representative for system recommendations and substrate testing.

1. Solvent clean thoroughly with SHER-WILL-CLEAN<sup>®</sup> Solvent Cleaner R7-K156, AQUA-MATE<sup>™</sup> Low VOC Surface Cleaner W4-K157, or UltraClean<sup>™</sup> Surface Cleaner R7-K158. Wipe dry with clean cloth.

### Prepainted Substrates:

1. Wash surfaces thoroughly with mild detergent and water. Rinse well and wipe dry with clean cloth.
2. Solvent clean enamel substrates with UltraClean<sup>™</sup> Surface Cleaner R7-K158, SHER-WILL-CLEAN<sup>®</sup> Solvent Cleaner R7-K156 or AQUA-MATE<sup>™</sup> Low VOC Surfacer Cleaner W4-K157. Solvent clean lacquer substrates with UltraClean<sup>™</sup> Surface Cleaner R7-K158 or R1-K213. Wipe dry with clean cloth.
3. Grind off paint and remove all rust. Fill as needed using SHERWIN-WILLIAMS body filler. Allow body filler to tack up and shape as needed. Note: Body filler must be cured before applying G.B.P.<sup>®</sup> Etching Filler. If topcoat is to be clearcoated, use Sherwin-Williams No-Stain body filler.
4. Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander.
5. If metal surface is badly pitted or rusted, the rust must be removed. Remove by grinding or sanding and treat any remaining rust with MET-L-ETCH<sup>®</sup> Steel Cleaner W4-K288 per label directions.

## MIXING

1. Stir G.B.P.<sup>®</sup> Etching Filler thoroughly before using.
2. Mix 1 part G.B.P.<sup>®</sup> E2-G980 or E2-G983 with 1 part G.B.P.<sup>®</sup> Reducer Activator R7-K981 Fast or R7-K982 Slow **or** mix 2 parts G.B.P.<sup>®</sup> E2-G980 or E2-G983 with 1 part G.B.P.<sup>®</sup> HS Reducer R7-K985. **Mix in plastic containers only.** Do not use metal containers. **Useable pot life**
  - 7 days for E2-G980 with R7-K981
  - 1 day for: E2-G980 with R7-K982 or R7-K985
  - E2-G983 with R7-K981, R7-K982 or R7-K985
3. In hot and/or humid conditions, G.B.P.<sup>®</sup> may be retarded with up to 5% by volume with Universal Urethane Retarder R7-K6252.
4. When using R7-K985 reducer, for more leveling and less texture, add **up to** 25% of US-3 or US-4 depending on temperature.

**Note** - For VOC Rule 1151: To obtain a VOC level less than 6.5 lbs/gal and be 16% solids or less by weight, mix 1 part G.B.P. E2-G983 to 1 part R7-K981/R7-K982 to 1 parts R7-K6248.

- For VOC Rule 1107 Misc. Metal Parts: To obtain a VOC level less than 6.5 lbs/gal and be 12% solids or less by weight, mix 1 part E2-G983 to 1 part R7-K981/R7-K982 to 3 parts R7-K6248.

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## APPLICATION

**Note:** Use a teflon coated or plastic gun cup. Do not store mixed G.B.P.® Etching Filler in the gun.

1. Adjust air pressure at the gun to **30-35 psi** for siphon or gravity feed application.
2. Apply **2-3 medium coats** of G.B.P.® Etching Filler to bare metal and featheredge. Allow a **2-3 minute flash time** between coats. *Note: Do not apply G.B.P.® Etching Filler over large areas of previously painted surfaces.*
3. A **minimum** dry film thickness of **1.0 mil** is required for corrosion protection. **Maximum** dry film thickness is **2.5 mils** after sanding. *Note: Do not wet sand E2-G980. E2-G983 (chromate free) may be wet sanded.*
4. Clean application equipment immediately with Gun and Equipment Cleaner R7-K105.
5. **For improved productivity, E2-G983 reduced with R7-K985 can be used for jamps, trunk lids and other applications where wet-on-wet color coating is desired.**
  - Apply 2 coats of E2-G983 with a wet-on-wet technique @ 35 psi at the gun.
  - Allow each coat to flash - initial solvent release, before applying the second coat. After the final coat of G.B.P. has flashed, apply the basecoat, or single-stage, to all edges.
  - If a basecoat color, apply CC-648 1K Kut-In™ Clear, or CC-649 or your choice of ULTRA 7000® clearcoats, over basecoat areas. 2 coats, flash time between coats. Flash time of basecoat before clearcoat is 10 minutes.
  - The part can be wet sanded with 400 grit or finer in 60 minutes or anytime during the repair process before final finishing.
  - If more than 24 hours elapses before final finish is applied, sanding is required to ensure topcoat adhesion.

## GUN AND EQUIPMENT RECOMMENDATIONS

<i>Spray Gun Type</i>	<i>Manufacturer</i>	<i>Spray Gun Model</i>	<i>Nozzle</i>	<i>Air Cap</i>	<i>Gun Pressure</i>
Siphon Feed	DeVilbiss	JGA Series	1.8 mm/ .070 /EX	80	30-35 PSI
Siphon Feed	Sharpe	971/975	1.8 mm / .070	#10 Red	30-35 PSI
Gravity Feed	SATA	SATA Jet 90	1.6 mm	*	30-35 PSI

<i>Spray Gun Type</i>	<i>Manufacturer</i>	<i>Spray Gun Model</i>	<i>Nozzle</i>	<i>Cap Pressure</i>	<i>Gun Pressure</i>
HVLP	DeVilbiss	GTI	1.4-1.6 mm	7-10 PSI	38-50 PSI
HVLP	Sharpe	SGF98	1.5 mm	7-10 PSI	40-45 PSI
HVLP	SATA	MC-93	1.7 mm	*	43 PSI

\*Use one supplied

## RECOATING

1. Allow G.B.P.® Etching Filler to dry a **minimum of 30 minutes** at 75°F, 50% relative humidity, and at **1.0 mil** dry film thickness before recoating.
2. If G.B.P.® Etching Filler is allowed to **dry for over 24 hours**, scuff sand with 320 grit or finer treated sandpaper for optimum intercoat adhesion. Repriming is not required.
3. When using G.B.P.® HS Reducer R7-K985 at 2:1 mixing ratio, dry sanding or priming is recommended due to higher levels of texture.
4. Recoat with any SHERWIN-WILLIAMS Automotive Finish, Primer-Surfacer, Sealer, or additional G.B.P.® Etching Filler if required.
5. **Do not recoat** G.B.P.® Etching Filler with CORROSION SHIELD® E2-G973 or two-component *polyester-based* primer-surfacers.

**Note:** If sanding of G.B.P.® is desired, wait a minimum of 30 minutes for E2-G980 and 60 minutes for E2-G983.

## NOTES

1. Do not place activated material back into unactivated primer.
2. Store activated material in an acid-resistant container (preferably plastic).
3. Keep container of activated material tightly closed when not in use.
4. Always stir or shake previously activated material before re-use.
5. Do not use G.B.P.® Etching Filler as a sealer on crazed/cracked surfaces or large areas of previously painted surfaces.
6. Do not wet sand E2-G980. E2-G983 (chromate free) may be wet sanded.
7. When directly topcoated, G.B.P.® Etching Filler E2-G980 may show a light stain due to some pigment bleeding into color coat. For best results, prime or seal before topcoating.
8. For maximum corrosion protection, MET-L-MATE® W4-K289 may be used as a pretreatment prior to spraying E2-G983 (only for chromate free E2-G983). W4-K289 is best applied with a gray nylon scuff pad.

# PRODUCT AT-A-GLANCE

**PRODUCT**      **G.B.P.® Etching Filler**                      **Olive Drab E2-G980**                      **Neutral Green E2-G983**

*E2-G980 is lead free. E2-G983 is lead and chromate free.*

## USE

- Self-etches bare metal for excellent paint adhesion and corrosion resistance.
- Fills minor surface imperfections.
- Sprays smoothly and can be directly topcoated for quick and easy repairs.
- Dries fast, within 30 minutes.

## SUITABLE SUBSTRATES

- Steel
  - Galvanized steel\*
  - Aluminum
  - Fiberglass
  - OEM enamels
  - Cured Body Filler
  - ED Primer
- \* See Surface Preparation

## SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with SHERWIN-WILLIAMS solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and featheredge all broken painted edges.
- For **heavily pitted steel**, grind or sand all rust and pretreat any remaining rust with MET-L-ETCH™ W4-K288.

## MIXING

Stir or shake G.B.P.® Etching Filler thoroughly before mixing.



1  
E2-G980  
or E2-G983

+

1  
R7-K981  
or R7-K982



2  
E2-G980  
or E2-G983

+

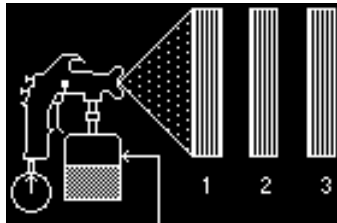
1  
R7-K985

\*Note: For more leveling and less texture, add up to 25% of US-3 or US-4 depending on temperature

## APPLICATION

### Siphon feed

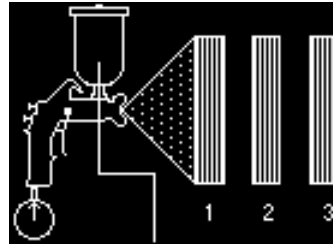
Apply 2-3 medium coats.  
Allow each coat to flash 2-3 mins.



30-35 psi

### Gravity feed

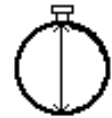
Apply 2-3 medium coats.  
Allow each coat to flash 2-3 mins.



30-35 psi

### Time to Recoat

E2-G980 - 30 mins  
E2-G983 - 30 mins.



### Time to Sand

E2-G980 - 30 mins  
E2-G983 - 60 mins.

## RECOAT

- ULTRA® Topcoats
- SUNFIRE®, BC/CC, & Low VOC
- ACRYLYD PLUS® Polyurethane Enamel
- ACRYLYD® Acrylic Enamel
- KEM TRANSPORT® Synthetic Enamel
- ULTRA-FILL II® Surfacer and Sealer
- AQUA-SEAL™ Waterborne Sealer
- ULTRA-FILL® HS/NP Primers
- GENESIS® Topcoats
- JET SEAL® Primer-Sealer
- High Build Epoxy Primer
- Super COMBO® Primer-Surfacer
- AQUA-FILL® Primer-Surfacer
- AQUA II® Undercoats

## NOTES

- Maximum dry film thickness is 2.5 mils. Minimum dry film thickness is 1.0 mil.
- **Store** in an acid resistant container after activation.
- Sealing of E2-G980 is recommended due to some minor chromate pigment bleed under light colors.
- Use **only** G.B.P.® Reducer R7-K981, R7-K982, or R7-K985. Do not use any substitutes.
- Scuff sand with 320 grit or finer treated sandpaper after 24 hours dry. Repriming is not required.
- Do not use G.B.P.® on crazed/cracked surfaces or large areas of previously painted surfaces.
- Do not wet sand E2-G980. E2-G983 (chromate free) may be wet sanded.
- When using HS Reducer R7-K985 at 2:1 mixing ratio, dry sanding or priming is recommended due to higher levels of texture. Wet sanding of E2-G983 (chromate free) is acceptable.
- Pot life:
  - 7 days for E2-G980 with R7-K981
  - 1 day for: E2-G980 with R7-K982 or R7-K985; E2-G983 with R7-K981, R7-K982 or R7-K985

## PERSONAL PROTECTION

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

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# **P R O D U C T D A T A**