

APPLICATION

Typical Setups

Reduction: Reduce with R6K30 (MAK). Maximum total reduction is 5% (vol.) to maintain 2.8 lbs./gal. VOC. Using other Polane reducers (R7K74, R7K84, R7K95) will change the VOC and may affect viscosity and gloss. For better flow, R7K216 may partially replace reducer but will change the VOC.

Smooth Coat: Apply using airless spray or conventional spray equipment.

Texture Coat: Allow 15 minutes smooth coat flash off time before applying texture coat. The texture may be varied by balancing the atomizing and fluid pressures. Lower atomizing pressure gives a larger pattern, higher atomizing pressure reduces texture size.

Dip coating, flow coating and brushing are not recommended.

May be applied by: Conventional Spray
Airless Spray (smooth coat)

Conventional Spray:

Air Pressure	45-55 psi
Fluid Pressure	8-12 psi
Tip	0.055-0.070 in.

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R7K95 (Polane HAPS Free Reducer) or R6K30 (MAK). Polane reducers, R6K10 (MEK) and MIBK may also be used but are not HAPS compliant.

Follow manufacturer's safety recommendations when using any solvent.

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ADDITIONAL INFORMATION

- This product must be properly catalyzed before using. DO NOT VARY CATALYST RATIO.** The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical & solvent resistance.
- Polane Catalyst V66V47 is recommended for interior use only. Polane 2.8T Plus is not recommended for extended exterior exposure because of chalking and loss of gloss.
- Do not spray hot. Heat shortens pot life. Do not pump catalyzed material from drums into circulation system. Friction heat developed by pumps and circulation will shorten pot life.
- Protect Polane Coatings, Catalyst, and Reducer from moisture as water affects potlife and film properties. Store indoors. Keep containers closed at all times.
- Do not package Polane coated products in airtight plastic bags unless completely cured. Since Polane coatings continue to cure for several weeks, the buildup of organic solvents and reaction by-products could cause improper cure and adhesion failure in use.
- Do not blend with any other polyurethane quality. No other catalysts, colorants, or reducers are recommended because foreign materials such as alcohols, glycols, and lacquer thinners affect film performance properties.
- If recoating after more than 7 days cure, sand lightly to ensure intercoat adhesion.
- Blend with Phoenix® Color Express® or GIS colorants only. Maximum colorant tint load is shown in the table below:

	F63F77	F63W76
Phoenix	21 oz/gal	4 oz/gal
Color Express	21 oz/gal	4 oz/gal
GIS	21 oz/gal	4 oz/gal
- Gloss levels may be adjusted by using F63V68 in the Phoenix system.

	F63V68
Phoenix	21 oz/gal
Color Express	21 oz/gal
GIS	-
- Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
- Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.

Performance Tests*

Substrate:	24 gauge Bonderite® 1000 Cold rolled steel panels
Topcoat:	1.8 mils DFT
Cure:	30 mins. at 140° F
Post-cure:	10 days

Salt Spray Test	100 hours
(ASTM B117)	1/8" creep
Humidity Resistance (100 F, 100% RH)	100 hours
Impact Resistance, Direct	80 in lb
Impact Resistance, Reverse	40 in lb
Pencil Hardness	2H-3H*
Taber Abrasion (CS 17 wheel, 1000 g)	
1000 cycles	100 mg
Adhesion	5B (Excellent)

*Performance test results may vary depending on dry film thickness, substrate tested and post-cure duration.

Stain Resistance (after 30 mins. spot test):

Catsup	Excellent
Coca-Cola®	Excellent
Coffee	Excellent
Gasoline	Excellent
Lipstick	Excellent
Motor oil	Excellent
Vaseline®	Excellent

Chemical Resistance (after 30 mins. spot test and 1 hr. recovery):

Ammonia	Excellent
Clorox Formula 409®	Excellent
Drano®	Excellent
Ethyl Acetate	Excellent
10% HCl	Excellent
1 N H ₂ SO ₄	Excellent
Isopropanol	Excellent
Ivory® Liquid	Excellent
MEK (spot test)	Excellent
MEK (50 double rubs)	Slight Burnishing
10% NaOH	Excellent
5% Tide® solution	Excellent
Toluene	Excellent
1,1,1-Trichloroethane	Excellent

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

Please direct any questions or comments to your local Sherwin-Williams facility.

Note:

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