



**SHERWIN
WILLIAMS**

General Industrial Coatings

CC-D32

Polane® 8880 Acrylic Polyurethane

High Gloss Jet Black.....F63B284	Low Gloss Black.....F63B285	High Gloss Custom Blend...F63HG Series
High Gloss Clear Base.....F63C281	Low Gloss Clear Base.....F63T283	Low Gloss Custom blend F63VC Series
High Gloss White Base.....F63W280	Low Gloss White Base.....F63W282	Catalyst.....V66V280

DESCRIPTION

POLANE® 8880 Acrylic Polyurethane is a 2.8 two component, aliphatic acrylic topcoat with fast dry and flexible application characteristics.

Advantages:

- Less than 2.8 VOC* as applied
- Available in a broad range of colors
- Quick tack free time
- High abrasion resistance
- Chemically resistant
- Available in a full gloss range
- Good performance over multiple substrates including steel, aluminum, ABS, PC-ABS, PVC and Polycarbonate
- Compatible with a wide range of 2.8 VOC primers including D61H75, E61A280 and E61A510

CHARACTERISTICS

Gloss: 15-90 (60°)

Volume Solids:

As packaged	55 ± 2 %
Catalyzed and reduced	52 ± 2 %

Viscosity (at 77° F):

Catalyzed and reduced, varies by color	
High Gloss	12-17 secs., #3 Zahn Cup
Low Gloss	15-19 secs., #3 Zahn Cup

Recommended Film Thickness:

Mils Wet	1.9-5.8
Mils Dry	1.0-3.0

Mix Ratio		
High Gloss - F63HG		
Polane 8880	5 parts	-
Polane 8880 +	-	5 parts
*V6V768 Accelerator	-	-
V66V280 Catalyst	1 part	1 part
Reducer	1.2-1.5 parts	1.2-1.5 parts
Low Gloss - F63VC		
Polane 8880	6 parts	-
Polane 8880 +	-	6 parts
*V6V768 Accelerator	-	-
V66V280 Catalyst	1 part	1 part
Reducer	1.4-1.8 parts	1.4-1.8 parts

*Add up to 1 ounce of General Industrial Accelerator V66V768 per gallon. Accelerator use may impact gloss.

Potlife (mixed as listed): 2 hours

Spreading Rate: (no application loss)
834 ft.²/gal. at 1.0 mil DFT

Drying:

(1.5 mils DFT, 77° F, 50% RH)	
To Touch	40 minutes
Tack Free	2 hours
To Handle	6-8 hours
To Recoat w/ Itself	No critical recoat

Cure:

Air Dry	or
Force Dry	30 mins. at 180° F

Flash Point (Pensky Martens Closed Cup): 85-92° F

Package Life: 2 years, unopened

APPLICATION

Typical Setups

Reduction: Reduce with Oxsol® 100 (R2KS1), T-Butyl Acetate (R6K38), Acetone (R6K9), High Solids Compliant Thinner (R7K111) or dimethyl carbonate (DMC, R7K7).

Airless Spray:

Fluid Pressure	1,800-2,600 psi
Tip	0.011-0.013 in.
Reduction	20-25% (vol.)

Air Assisted Airless Spray:

Air Assist Pressure	25 psi
Fluid Pressure	1,500-1,800 psi
Tip	0.011-0.013 in.
Reduction	20-25% Oxsol 100 (R2KS1, vol.)

Conventional Spray:

Air Pressure	45-55 psi
Fluid Pressure	7-10 psi
Reduction	20% (vol.)

HVLP Spray:

Air Pressure	7-10 psi at cap
Fluid Pressure	5-10 psi
Reduction	20% (vol.)

Air Quality Data (theoretical):

- Non-photochemically Reactive
- Volatile Organic Compounds (VOC):
 - As packaged, maximum, less exempt solvents: 3.33 lbs/gal, 399 g/L
 - Catalyzed and reduced, as listed: 2.79 lbs/gal, 334 g/L

*VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com.

Cleanup: Clean tools/equipment immediately after use with T-Butyl Acetate (R6K38) or Acetone (R6K9)

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

General: Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and Surface passivation treatments to ensure optimum adhesion and coating Performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.

Aluminum (untreated): Prime with Industrial Wash Primer, P60G2, RoHS Compliant Wash Primer, P60G10, or Kem Aqua® Wash Primer, E61G522.

Galvanized Steel (untreated): Prime with Industrial Wash Primer, P60G2, RoHS Compliant Wash Primer, P60G10, or Kem Aqua® Wash Primer, E61G522.

Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Plastic: Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. A filler or primer/barrier coat may be required. Please consult your Sherwin-Williams Product Finishes Sales Representative for system recommendations.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

ADDITIONAL INFORMATION

- Polane® 8880 coatings must be catalyzed. **Do not vary catalyst ratio.** The catalyst ratio has been established for optimum hardness, flexibility, gloss, chemical and solvent resistance. Slight over or under catalyzation will not seriously affect performance.

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- Do not blend with any other polyurethane. No other catalysts or reducers are recommended because foreign materials such as alcohols and glycols destroy performance properties. Lacquer thinners and alcohol containing solvent blends should not be used with Polane® enamels.
- Polane® coatings are not recommended for exterior use on wood.
- Do not spray hot, heat shortens pot life. Do not pump catalyzed material from drums into circulating systems. Friction heat developed by pumps and circulation will shorten pot life.
- Protect Polane® enamels, catalyst and reducer from moisture as water affects pot life and properties. Store indoors.
- Do not package Polane® coated products in airtight plastic bags unless completely cured. Since Polane® Enamels continue to cure for several weeks, the buildup of organic solvents and reaction by-product could cause improper cure and adhesion failure in use.
- Blend with Phoenix® Colorants only. Do not exceed the maximum tint load of 24 ounces per gallon for Clear or 14 ounces per gallon for White
- Do not exceed the recommended amount of V6V768 per sprayable gallon of paint. If using more than the recommended amount of accelerator, pot life, recoat time, adhesion, VOC and other properties may be negatively affected. Coating performance must be thoroughly checked prior to implementing this strategy.
- Clean application equipment thoroughly before and after use

Performance Tests

Substrate: 24 gauge Bonderite® 1000 P99X cold rolled steel panels
Coating: F63W280:V66V280, catalyzed 5:1
Reduced: 25% (vol.) with R2KS1
Dry Film Thickness: 1.5 mils
Cure: 14 Days, Air Dry

Impact Resistance, Direct	60 in lb
Impact Resistance, Indirect	40 in lb
Pencil Hardness	H*
*Pencil Hardness may vary depending on dry film thickness, substrate and tester.	
Conical Mandrel, 1/8"	Pass
Water Immersion	24 hours
Adhesion	5B
QUV-A	1000 hours
Salt spray (on Bonderite®)	300 hours
Salt spray (on Bonderite® and primed)	1200 hours
Heat resistance, Dry	300° F

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.

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