



Product Finishes

PermaSwade® 9411 Velvet

VELVET.....F63VC28
CATALYST.....V66VC507
CUSTOM BLEND.....F63ZW

PRODUCT DESCRIPTION

PermaSwade® 9411 Velvet is a two component water based urethane technology designed to give a velvet feel to various plastics.

Advantages

- Low odor
- Apply using conventional or HVLP spray methods.
- Free of lead and chromate hazards
- Adheres directly to ABS, PC-ABS, B1000
- Excellent mar resistance.
- Excellent appearance over metal or plastic.
- Maximum 4 ounces of Kem Aqua® Black can be used to make transparent colors.
- Can be used as a topcoat over metallic or pigmented Kem Aqua® Colorline EP, Kem Aqua® 600, Polane® G Plus and Acrylic Lacquer EP®..

CHARACTERISTICS

Volatile Organic Compounds(VOC)*
as packaged, less exempts.
1.94 lb/gal, 233 g/L
Catalyzed and Reduced :
1.72 lb/gal, 207 g/L

Gloss at 60°: 5 maximum
Volume Solids: 29.34 ± 1%
Weight Solids: 34.34 ± 1%
Viscosity: (agitated)
Zahn #3 25-35 sec at 25°C (77°F)

Recommended Film Thickness:
Wet: 3.4 – 4.4 mils
Dry: 1.0 – 1.3 mils

Spreading Rate:
Catalyzed and Reduced
501 sq.ft./gal. at 1.0 mil DFT

Flash Point: 230°F Pensky-
Martens Closed Cup

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

CHARACTERISTICS (Cont.)

Mixing Ratio: (by volume)

18 Part A : F63VC28
1 Part B : V66VC507
Should be mixed mechanically (air mixer) for at least three minutes.

Drying: (Room Temperature)

To Touch 2-3 hours
Tack Free 3-4 hours
To Handle 6-8 hours
Recoat 30-60 minutes

Force Dry:

15 minute flash
30 minutes at 180°F

Pot Life : 4 Hours

Package Life: 12 months unopened

Good air movement and humidity control is necessary for proper drying of water reducible coatings.

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

SPECIFICATIONS

Plastics: 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.

Metal: Consult Metal Preparation Brochure CC-T1 for additional details.

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.

APPLICATION

Typical Setups

May be applied by:

Conventional Spray
HVLP

Conventional Spray:

Air Pressure.....40-50 psi
Fluid Pressure.....10-15 psi
Tip.....0.055-0.070
Reduction rateup to 5 % with water**

HVLP:

Air Pressure at the cap10 psi
Fluid Pressure.....6-10 psi
Cap/Tip0.055-0.070
Reduction Rate.....up to 5% with water**

**To ensure optimal coating performance and stability, it is recommended to use deionized water for reduction.

Cleanup:

Clean tools/equipment immediately after use with water.

SPECIFICATIONS

Product Limitations:

- Avoid Freezing. Store at temperatures of 50 °F to 100 °F.
- Do not apply with electrostatic bell or turbodisk.
- Not intended for long term exterior applications.
- The practical upper limit for gloss is 5 units. PermaSwade® Water Reducible Velvet is not a high gloss coating.
- Kem Aqua® Black is the only pigment allowed. Do not exceed 4 ounces per gallon.

PERFORMANCE TESTING

Adhesion to substrate:

ABS	Excellent
PC	Fail
PC-ABS	Excellent
Acrylic	Pass
B1000 Steel	Excellent
Aluminum	Excellent

Linear Abrasion: 2 rating

CS-17, 1 kg, 50 cycles

Taber Abrasion: Pass

CS-10, 1 kg, 1000 cycles

Mar resistance Recovered with warm water

Steel Wool Micro Scratch Recovered with warm water

25 Double MEK Rubs Pass

50 Double Alcohol Rubs Pass

CHEMICAL RESISTANCE

(30 minutes spot test)

Lipids	Good
Catsup	Excellent
Cola	Excellent
Formula 409®	Excellent
Pledge®	Excellent
Hand Cream	Excellent
Margarine	Excellent
Saliva	Excellent
10% HCL	Excellent
Lemon Juice	Excellent
Artificial Perspiration	Excellent
Anti-Static Cleaner	Fail
Dish Soap	Excellent
Saturated Cleaner	Excellent
Household Ammonia	Excellent
Windex®	Excellent
Spic & Span®	Excellent
Ball Point Pen	Stain
70% IPA	Fail
Coffee	Excellent
Tap Water	Excellent
Lipstick	Stain
Citrus Based Cleaner	Excellent
Nivea® Hand Lotion	Excellent

CHEMICAL RESISTANCE

(24 hours spot test)

Ammonium Hydroxide	Good
IPA	Fail
Banana Boat®	Good
Lipton Tea®	Stain
Cola	Excellent
Wax Pencil	Good
Formula 409®	Good
Liquid Detergent 50%	Excellent
Mustard	Stain
Ethanol	Good
Coffee	Stain
Lipids	Good
Felt Tip Pen	Stain
Citric Acid (50%)	Excellent
Black Stamp Ink	Stain
Ball Point Pen	Stain
Acetone	Fail

ENVIRONMENTAL TESTING

Thermal Cycling

(-20°C to 65°C) 50 cycles No Effect

Heat Soak

65°C 90% RH 168 Hours No Effect

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review 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.

CAUTIONS (Cont.)

Catalyst CONTAINS ISOCYANATES. People who have chronic (long-term) lung or breathing problems or have had a reaction to isocyanates, must not be in the area where this product is being applied. Where overspray is present, a positive pressure air-supplied respirator should be worn. If unavailable, a properly fitted organic vapor/particulate respirator may be effective. Consult catalyst MSDS and product label for complete handling instructions.

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WKM 8/2016