



**SHERWIN
WILLIAMS®**

Product Finishes

PermaSwade 9411

Silk..... F63VC29

Catalyst..... V66VC507

PRODUCT DESCRIPTION

PermaSwade 9411 Silk, F63VC29, is a two component water based urethane technology designed to give a silk feel to various plastics.

Advantages

- Low odor/ Low VOC
- Apply using conventional or HVLP spray methods.
- Free of lead and chrome.
- Adheres directly to ABS.
- Excellent Mar.
- Excellent appearance over metal or plastic.
- Maximum 4 ounces of Kem Aqua® Colorants 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:

0.76 lb/gal, 90.6 g/L

Catalyzed and Reduced :

0.75 lb/gal, 90.6 g/L

Gloss at 60°: 5 maximum

Volume Solids: 31.4 ± 1%

Weight Solids: 36.6 ± 1%

Viscosity (agitated):
65-75 Krebs Units at 25° C (77° F)

Recommended Film Thickness:
Dry: 1.0 – 1.3 mils
Wet: 3.2 – 4.1 mils

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

Flash Point: 230° F

Mixing Ratio (by volume):
26 Parts F63VC29
1 Part 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

Baking Schedule: 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.

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: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

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 9411 Silk is not a high gloss coating.
- Kem Aqua Colorants are not to exceed 4 ounces per gallon.

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

APPLICATION

Typical Setups

May be applied by:

Conventional Spray
HVLP

Conventional Spray:

Air Pressure 45 psi
Fluid Pressure 15 psi
Cap/Tip 30/070
Reduction rate up to 5 % with water

HVLP:

Air Pressure at the cap 10 psi
Fluid Pressure 28 psi
Cap/Tip 507/SP 200S-1.4
Reduction Rate up to 5% with water

Cleanup:

Clean tools/equipment immediately after use with water.

PERFORMANCE TESTING

Adhesion to substrate:

ABS	Excellent
PC	Excellent
PC-ABS	Excellent
HIPS	Failure
B1000 Steel	Excellent
Aluminum	Failure
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	Excellent
Catsup	Excellent
Cola	Excellent
Lipstick	Stain
Formula 409	Excellent
Pledge	Excellent
Hand Cream	Excellent
Margarine	Excellent
Saliva	Excellent
10% HCL	Excellent
Lemon Juice	Excellent
Artificial Perspiration	Excellent
Anti-Static Cleaner	Excellent
Dish Soap	Excellent
Saturated Cleaner	Excellent
Household Ammonia	Excellent
Windex	Excellent
Spic & Span	Excellent
Ball Point Pen	Stain
70% IPA	Excellent
Coffee	Excellent
Tap Water	Excellent
Citrus Based Cleaner	Excellent
Nivea Hand Lotion	Excellent

CHEMICAL RESISTANCE (24 Hours Spot Test)

Ammonium Hydroxide	Excellent
IPA	Excellent
Banana Boat	Excellent
Acetone	Failure
Coffee	Stain
Lipton Tea	Excellent
Cola	Excellent
Wax Pencil	Stain
Formula 409	Excellent
Liquid Detergent 50%	Excellent
Mustard	Stain
Ethanol	Excellent
Lipids	Excellent
Felt Tip Pen	Stain
Critic Acid (50%)	Excellent

ENVIRONMENTAL TESTING

Temp. and Humidity Cycling:	No Effect
Settings:	High 65° C, 90% RH, Low -20° C (14 cycles)

Heat Soak:	No Effect
Settings:	65° F/90% RH (168 hrs)

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Sherwin-Williams facility. Please direct any questions or comments to your local Sherwin-Williams facility.

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.

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application, which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.

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