



Product Finishes

VITRASIL® 4000 - 3.0 VOC SILICONE POLYESTER ENAMEL

White.....	H56W3	Iron Red.....	H56R15
Black.....	H56B5	Violet.....	H56R16
Blending Clear.....	H56V10	Bright Red.....	H56R17
Exotic Clear.....	H56VC3	PC Blue.....	H56L7
Yellow Buff.....	H56Y16	PC Green.....	H56G9
Bright Yellow.....	H56Y17	Chrome Green.....	H56G10

DESCRIPTION

VITRASIL® 4000 Silicone Polyester Enamel is a single component thermoset baking enamel offering outstanding exterior durability and performance properties for the aluminum extrusion market. VITRASIL® is designed to meet the performance parameters of AAMA 2604-13. It is an excellent product for architectural aluminum products such as extrusions, windows, doors, railing, solariums, store and building facades, and other building components.

Advantages:

- Complies with 3.0 VOC solvent emissions.
- Meets the performance parameters of AAMA 2604-13.
- Excellent exterior color and gloss retention.
- Can be applied over approved non-chrome pretreatment.
- Excellent hardness, toughness and flexibility.
- Exceeds 3000 hours salt spray and humidity on pretreated aluminum.
- Can be used with or without primer.
- Application by conventional and HVLP spray, electrostatic guns, bells and disc.
- Excellent recoatability
- Excellent non-yellowing and overbake resistance.

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

CHARACTERISTICS

Weight/Gallon:	9.56 ± 0.3 lbs. May vary by color
60° Gloss:	37 - 43 May vary by color
Volume Solids:	49.43± 2.0% May vary by color

CHARACTERISTICS (cont.)

Recommended film thickness:

Wet	2.4 - 2.8 mil May vary by color
Dry	1.2 - 1.4 mil

Package Viscosity: 15 – 20 sec Zahn #3

VOC: 3.0 Lbs/ Gal

Spreading Rate: (no application loss)
793 sq. ft./gal. @ 1 mil DFT
May vary by color

Flash Point: 38°F Pinsky-Martens
Closed Cup

Package Life: 2 years, unopened,
Inside storage

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: A minimum of a 5 stage chrome phosphate metal treatment, or type or approved non-chrome type pretreatment (See AAMA 2604-13 spec) is required for good adhesion and optimum coating performance properties.

Testing: 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.

APPLICATION

Typical Setups

May be applied by:

Conventional Spray
Electrostatic Spray
HVLP
Electrostatic Bells
Electrostatic Disc
Electrostatic Handgun

APPLICATION (cont.)

Viscosity:

Air Spray: 20-25 seconds Zahn #2
11-15 seconds Zahn #3

Bells & Discs: 20-25 seconds Zahn #2
11-15 seconds Zahn #3

Note : To maintain VOC at 3.0, use either Oxsol 100, Acetone or a combination of these exempt solvents if adjustment of viscosity is needed.

Cleanup:

Clean tools/equipment immediately after use with Ketone or aromatic solvents. Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

Baking Schedule:

- 20 minutes at 400°F with at least 8 minutes at a peak metal temperature (PMT) above 395°F.
- 8 minutes at 450°F with a PMT of at least 5 minutes above 400°F.
- 25 minutes above 375°F with a PMT of at least 15 minutes above 375°F.
- Line speed and oven temperatures must be established to attain required PMT on substrate mass being coated. For cure, run 50 MEK double rubs with slight burnish.

SPECIFICATIONS

Product Limitations:

1. Substrate cleaning and pretreatment is critical to obtaining expected performance.
2. Proper cure - reaching required peak metal temperature (PMT) - is critical to proper cure. Use temperature tapes or pyrometer and check cure

(Continued on Back)

3. Do not add any other materials to VITRASIL products because they may affect performance properties.
4. Do not apply to anodized or "hard coat" aluminum because of adhesion concerns.
5. Applicators must be pre-qualified by a Sherwin-Williams Technical Service Rep, Engineer or Technical person to confirm proper metal treatment, application and cure to assume the long-term performance of VITRASIL® 4000 Silicone Polyester Enamels.

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.

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.

Building Products/Columbus
M King
9/27/13

DISCONTINUED