



# General Industrial Coatings

CC-D36

## POLANE® 2K Acrylic Waterborne Enamel Monochromatics & Clears

Black ..... F63BL504 Red Oxide ..... F63RL500 Catalyst ..... V66VL6  
30-40 Gloss Clear ..... F63TL500 White ..... F63WL504 \*Custom Blend Series (KA Colorants)..... F63KK  
Full Gloss Clear..... F63CL500 Yellow Oxide ..... F63YL500 \*Custom Blend Series (KA SR Colorants). F63KR

### DESCRIPTION

**Polane® 2K Acrylic Waterborne Enamel** is a Non-HAP, <1.1 VOC, two-component, high performance polyurethane coating.

#### Advantages:

- Good gloss and color retention
- Product is designed for interior use
- Good performance for exterior use
- Clear and Blend monochromatics are provided
- Can be used on metal, plastic, or wood with the appropriate pretreatment, primer or basecoat.
- Designed to meet AAMA 623 and 613
- Can be blended with up to 8 oz/gal Kem Aqua colorants or Kem Aqua Solar Reflective colorants.
- \*Formulated to meet < 1.1 lbs./gal. VOC, less exemptions.
- Formulated to be non-HAP.

### CHARACTERISTICS

#### 60° Gloss:

|                             |       |
|-----------------------------|-------|
| Monochromatics              | 30-40 |
| 30-40 Gloss Clear, F63TL500 | 30-40 |
| Full Gloss Clear, F63CL500  | 85+   |

#### Volume Solids (varies by color):

|                     |          |
|---------------------|----------|
| As Packaged         | 36 ± 2 % |
| Catalyzed & Reduced | 36 ± 2 % |

#### Weight Solids (varies by color):

|                     |          |
|---------------------|----------|
| As Packaged         | 40 ± 2 % |
| Catalyzed & Reduced | 36 ± 2 % |

**Viscosity** (at 77° F): 20-30 secs., #2 Zahn

#### Recommended Film Thickness:

|          |         |
|----------|---------|
| Mils Wet | 3.0-5.0 |
| Mils Dry | 1.1-1.8 |

**Spreading Rate** (no application loss):  
591 ft.<sup>2</sup>/gal. at 1.0 mil DFT

\*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](http://www.PaintDocs.Com).

#### Cure:

Air Dry or  
Force Dry Flash 10 mins., 15 mins. at 140° F

| Fiberglass Cure Schedule |           |           |
|--------------------------|-----------|-----------|
| Pencil Hardness          |           |           |
| Cure @ 130° F            | Post Cure | Overnight |
| 15 mins.                 | 6B        | B         |
| 60 mins.                 | 3B        | HB        |

| PVC Cure Schedule |           |           |
|-------------------|-----------|-----------|
| Pencil Hardness   |           |           |
| Cure @ 130° F     | Post Cure | Overnight |
| 15 mins.          | 2B        | 2H        |
| 60 mins.          | HB        | 3H        |

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

**Substrate Disclaimer:** Curing of coating at temperatures higher than the heat distortion parameters of the substrate may cause substrate issues.

#### Drying (77° F, 50% RH):

|           |   |
|-----------|---|
| To Touch  | 20-30 minutes                                 |
| Tack Free | 30-40 minutes                                 |
| To Handle | 40-50 minutes                                 |
| To Sand   | 50-60 minutes                                 |
| To Recoat | Sand between coats<br>No critical recoat time |
| To Pack   | Overnight                                     |

#### Mixing Ratio (by volume):

|                  |          |
|------------------|----------|
| Part A           | 10 Parts |
| Catalyst, V66VL6 | 1 Part   |

#### Mixing Ratio With Plural Component:

|                  |          |
|------------------|----------|
| Part A           | 12 Parts |
| Catalyst, V66VL6 | 1 Part   |

If you do not use plural component equipment, you must mix at least five minutes with good agitation before spraying.

#### Working Potlife Is Product Dependent

|                |           |
|----------------|-----------|
| Monochromatics | 4-5 hours |
| Clears         | 7-8 hours |

#### Flash Point (Pensky Martens Closed Cup):

|        |         |
|--------|---------|
| Bases  | N/A ° F |
| V66VL6 | 104 ° F |

#### Air Quality Data (as packaged, may vary by color):

Non-photochemically Reactive  
Volatile Organic Compounds (VOC), Less  
Exempts: ≤ 1.1 lb/gal, 125 g/L  
Hazardous Air Pollutants (HAPS): Non-HAP

**Recommended Storage:** Inside, sealed container, 45-95° F, freeze hazard.

#### Package Life:

|                  |                    |
|------------------|--------------------|
| Part A           | 1 year, unopened   |
| Catalyst, V66VL6 | 9 months, unopened |

### SPECIFICATIONS

**General:** All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details. Any use over metal must be primed and/or a basecoat applied. Product does not contain flash rust inhibitors so use over any metal must be tested thoroughly.

**Plastics & Composites:** Due to the diverse nature of plastic/composite 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.

**Wood (Interior):** Must be clean, dry, and finish sanded. Use of Sherwood® Interior Millwork Primer is suggested for priming. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties. Moisture content of wood should be 6-8%.

**Wood (Exterior):** Must be clean, dry, and finish sanded. Use of exterior alkyd primer or Sherwood 90 Day Exterior Primer is recommended for priming. Due to the nature of wood and use of various primers, these products should be thoroughly tested for exterior performance.

**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

**Plural component equipment for mixing is preferred**

#### Mixing Ratio With Plural Component:

|                  |          |
|------------------|----------|
| Part A           | 12 Parts |
| Catalyst, V66VL6 | 1 Part   |

**May be applied by:** Conventional Spray  
Airless Spray  
Air Assisted Airless Spray  
HVLP Spray

#### Conventional Spray:

|                |           |
|----------------|-----------|
| Air Pressure   | 40-60 psi |
| Fluid Pressure | 10-15 psi |
| Cap/Tip        | 797/FF    |

#### Airless Spray:

|          |                         |
|----------|-------------------------|
| Pressure | > 1,500 psi             |
| Tip      | Dependent on line speed |

#### Air Assisted Airless Spray:

|                     |                         |
|---------------------|-------------------------|
| Air Assist Pressure | 20 psi                  |
| Fluid Pressure      | 150-250 psi             |
| Tip                 | Dependent on line speed |

#### HVLP Spray:

|                         |              |
|-------------------------|--------------|
| Gun                     | Binks Mach 1 |
| Air Pressure at the ca[ | 40-65 psi    |
| Fluid Pressure          | 6-10 psi     |
| Cap/Tip                 | 95P/97       |

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

**Cleanup:** Clean tools and equipment immediately after use with a mixture of 25% Butyl Cellosolve/75% water. Clean V66VL6 with Butyl Acetate. **Do not use solvents such as MEK or acetone to clean up V66VL6, as they may contain water and may cause plug up of lines or equipment.** Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

1. 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.
2. Do not store material that has been catalyzed. Pressure can build in closed containers. Use all catalyzed material.
3. Potlife maybe different for each color or clear.
4. Do not freeze. Store between 45 – 90 °F.
5. 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.
6. Product is designed for interior use. Product has good performance when used exterior. Please consult your S-W Representative to discuss use for exterior applications.
7. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.
8. **If Solar Reflective colors are used for a heat sensitive substrate, then only the Clear and Monochromatic White can be used in the formula.**
9. Compatible with Kem Aqua Colorants. Do not add more than 8 ounces of Kem Aqua or Kem Aqua Solar Reflective Colorants per gallon of base.

|                       | * Colorant Selection |                                     |
|-----------------------|----------------------|-------------------------------------|
|                       | Kem Aqua Colorants   | Kem Aqua Solar Reflective Colorants |
| * Blend Prefix To Use | F63KK                | F63KR                               |

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## 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](http://www.PaintDocs.Com).

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

#### Note:

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