**Polane® 8880 Acrylic Polyurethane**

**High Gloss Jet Black** ............... F63B284  
**Low Gloss Black** .................... F63B285  
**High Gloss Clear Base** .......... F63C281  
**Low Gloss Clear Base** .......... F63T283  
**High Gloss White Base** ........ F63W280  
**Low Gloss White Base** ........ F63W282  

**Catalyst** ................................ V66V280

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**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

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**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:**
- Milts Wet 1.9-5.8
- Milts Dry 1.0-3.0

**Mix Ratio**

<table>
<thead>
<tr>
<th>High Gloss</th>
<th>F63HG Series</th>
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<tbody>
<tr>
<td>8 parts</td>
<td>5 parts</td>
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<table>
<thead>
<tr>
<th>Low Gloss</th>
<th>F63VC Series</th>
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<tr>
<td>8 parts</td>
<td>6 parts</td>
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</table>

*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 ft²/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 30 mins. at 180° F
- Force Dry

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

**Package Life:** 2 years, unopened

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**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.)

**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

- 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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