

B. Paints, Sealants, Adhesives

Technical Bulletin B-1

VERSATEX Paint Specification – PPG

VERSATEX is a free-foam cellular PVC that can be painted to achieve the desired look or accent color to your home. To ensure good adhesion, the surface of the product should be clean, dry and free of dirt, mildew, chalk, grease and any other surface contaminants before paint application. Prior to cleaning it is a good practice to fill all nail holes and remove any marks or blemishes that appear during the installation process. Sanding the surface is an acceptable method of removing blemishes. However, sanding removes the original exterior surface, exposing the micro cell structure. A 100% acrylic latex or 100% acrylic latex with a urethane additive should be used to achieve superior coating durability and flexibility. Only **light to medium colored PPG paints with a light reflective value of 55 units or greater** should be applied to VERSATEX. **Using a paint with a LRV below 55 units will void our product warranty.**

PPG Industries have made product recommendations based upon our guidelines and their own investigative testing for adhesion and visual appearance. Simply using a product from this list does not ensure a perfect finish. Finished results and the paints longevity depends on the amount of paint applied, proper application and the weather climatic conditions during application. Always follow PPG or the paint manufacturer's application instructions. Also, be sure to read and follow the instructions and warnings on the label.

The PPG acrylic paints listed below were tested and are approved for application over VERSATEX products:

- **Sun-Proof Exterior Semi-Gloss Latex Paint (785 Series)**
- **Sun-Proof Exterior House and Trim Flat Latex Primer (72-1 Series)**
- **Manor Hall Exterior Premium Eggshell Acrylic Latex/Urethane Modified (79-45 Series)**
- **Manor Hall Exterior Premium Flat Acrylic Latex (74-45 Series)**
- **Manor Hall Exterior Semi-Gloss (75 Series)**
- **Manor Hall Exterior Gloss (52 Series)**
- **Olympic (Machine Coat) 54670 Flat Pastel Base**

Apply when air and surface temperatures are 50°F or above, and when the air and surface temperatures will remain above 50°F for the next 24 hours. Avoid painting early in the morning or late in the day when dew and condensation are likely to form, or when rain or snow is threatening. To prolong the shelf life of the paint, always protect it from freezing.

Cleaning can be accomplished using a cloth and a mixture of a mild detergent and water. Other cleaning agents include a mild household spray cleaner, a degreaser, or denatured alcohol.

Drying Times

- 1) To the touch: 30 minutes
- 2) To handle: 1 hour
- 3) To recoat: 4 hours
- 4) To full cure: 30 days

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Features and Benefits

- Superior Hiding
- Superior Adhesion
- Fade & Chalk Resistance
- Low Temperature application to 35°F
- Soap & Water Clean-up

Dry Time at 77°F (25C); 50% relative humidity.

Flash Point: Over 200°F (93C)

Please contact VERSATEX at (724) 857-1111 or sales@versatex.com for a technical data or MSDS sheets on the above listed PPG paints.

VERSATEX Coating Adhesion Test

Sample Description	Olympic 54670		Sun-Proof 72-110		Manor Hall 74-110		Manor Hall 79-110	
	dry x-cut	wet x-cut	dry x-cut	wet x-cut	dry x-cut	wet x-cut	dry x-cut	wet x-cut
Smooth Sample #1	0	0	<5	<5	0	0	0	0
Smooth Sample #2	0	<1	<5	<5	0	<5	<1	0
Smooth Sample #3	0	<1	<5	<5	0	0	0	0
Smooth Sample #4	0	0	<5	5	<1	<5	<1	0
Embossed Sample #1	0	0	<1	<5	0	0	0	0
Embossed Sample #2	0	0	<5	<5	0	0	0	0
Embossed Sample #3	0	<1	<5	<5	<1	0	0	0
Embossed Sample #4	0	0	<1	<5	0	0	0	0

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ASTM D 3359: Cross-Cut Tape Test Adhesion Strength Test

Sample Description	Olympic	54670	Sun-Proof	72-110	Manor Hall	74-110	Manor Hall	79-110
	dry x-cut	wet x-cut	dry x-cut	wet x-cut	dry x-cut	wet x-cut	dry x-cut	wet x-cut
Smooth Sample #1	5A	5A	4A	4A	5A	5A	5A	5A
Smooth Sample #2	5A	4A	4A	4A	5A	4A	4A	5A
Smooth Sample #3	5A	4A	4A	4A	5A	5A	5A	5A
Smooth Sample #4	5A	5A	4A	3A	4A	4A	4A	5A
Embossed Sample #1	5A	5A	4A	4A	5A	5A	5A	5A
Embossed Sample #2	5A	5A	4A	4A	5A	5A	5A	5A
Embossed Sample #3	5A	4A	4A	4A	4A	5A	5A	5A
Embossed Sample #4	5A	5A	4A	4A	5A	5A	5A	5A

ASTM D 3359 Rating System

- 5A – No peeling or removal.
- 4A – Trace peeling or removal along incisions or at their intersections.
- 3A – Jagged removal along incisions up to 1/16" on either side.
- 2A – Jagged removal along most incisions up to 1/8" on either side.
- 1A – Removal from most of the area of the X under the tape.
- 0A – Removal beyond the area of the X.

Considerations

- Higher quality paints typically outperform lower quality paints.
- Temperature humidity, wind and the amount of direct sunlight at time of application will affect paint drying times.
- Since VERSATEX is impervious to moisture it may take as much as 30 days for paint application to fully cure.
- Paint failures on wood are due primarily to moisture cycling. Since VERSATEX cannot absorb moisture, paints will adhere better and for a much longer time versus wood.

Disclaimer

Wolfpac Technologies, Inc. is not liable for paint used on VERSATEX Trimboards and/or the results of its use.



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Benjamin Moore makes the following recommendations based on adhesion testing of representative premium exterior paint testing.

Surface Preparation

Surfaces must be clean and free of grease, wax, and mildew. Remove any chalk and loose or scaling paint. Roughen the surface with a 220 grit sandpaper or equivalent for optimum adhesion. Wash dirty surfaces with a detergent solution and/or rinse with a strong stream of water from a garden hose to remove contaminants.

Exterior Paint Selection

Apply one or two coats of the following Benjamin Moore[®] premium exterior paints:

- Aura[®] Waterborne exterior paints, Flat 629, Low Lustre 634, Satin 631, or semi-gloss 632.
- Regal[®] Select high build Exterior Finish, Flat N400, Low lustre N401, Soft Gloss 403, and Soft Gloss N402 (regular build).
- Moorlife[®] 100% Acrylic Flat House Paint N105, Moorgard[®] 100% Acrylic low lustre House Paint N103, Moorglo[®] 100% Acrylic Fortified Soft Gloss House Paint N096.
- ben[®] 100% Acrylic Exterior Finish, Flat 541, Low Lustre 542, Soft Gloss 543.
- Premium Commercial Ultra Spec[®] Exterior Finish, flat N447, Satin N448, Gloss N449.
- Premium Commercial Super Spec[®] 100% Acrylic Exterior, Flat 183, Low Lustre N185, Satin 184, Semi Gloss 170.

Dark colors recommendation

Dark colors from the Benjamin Moore Vinyl Select palette can be used to supersede the general recommendation of never painting vinyl siding or trim darker than the original color.

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- Temperature humidity, wind and the amount of direct sunlight at time of application will affect paint drying times.
- Since VERSATEX is impervious to moisture it may take as much as 30 days for paint application to fully cure.
- Paint failures on wood are due primarily to moisture cycling. Since VERSATEX cannot absorb moisture, paints will adhere for a much longer time when applied to VERSATEX versus wood.

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VERSATEX Paint Specification

The Sherwin-Williams Company has completed adhesion testing and accelerated weather testing on VERSATEX Trimboard and makes the following coating recommendations;

Surface Preparation

VERSATEX Trimboards must be Clean, Dry and in Sound Condition prior to coating. If substrate is dirty it should be cleaned with ProClean Professional™ Prep Wash Concentrated Cleaner to remove all surface contamination.

Coating Specifications

Field Application - Sherwin-Williams recommends priming VERSATEX Trimboard with A-100 Exterior Latex Primer followed by Two Coats of SuperPaint™ Exterior Latex, A-100 Exterior Latex, or Duration Exterior Coating. Sherwin-Williams also offers a field applied coating under their "GreenSure®" product designation. Kem Aqua® BP Enamel is a water reducible polyurethane - acrylic top coat that offers fast dry times and no critical; recoat times. Due to its excellent adhesion properties it is an ideal coating for cellular PVC. A primer is not recommended but if you prefer to prime the trim use Aqua Kem® bonding primer E61W525.

Factory Application - Sherwin-Williams recommends factory priming with SuperPaint™ Machine Finish Latex Primer. Product should be allowed to dry for a minimum of 2 hours and then top coated with SuperPaint™ Machine Finish Satin Topcoat. For the longest lasting performance, a second Factory coat of SuperPaint™ Machine Finish Satin Topcoat or a second field applied coat of SuperPaint™ Exterior Latex, A-100 Exterior Latex or Duration Exterior Coating should be applied.

Applications

Field Application - When the air temperature is at 50°F, substrates may be colder; prior to painting, check to be sure the air, surface, and material temperature are above 50°F and at least 5° above the dew point. Avoid using if rain or snow is expected within 2-3 hours. Apply primer and topcoats using the following methods;

Brush - Use a nylon/polyester brush.

Roller - Use a 3/8" - 3/4" nap synthetic cover.

Spray - Airless Pressure...2000 psi Tip...015"-019"



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VERSATEX Paint Specification

Pre-Finishing

Pre-finishing of VERSATEX Trimboard by a Sherwin-Williams Authorized Factory Finisher is a superior way of finishing this substrate. Factory Pre-Finishing allows the substrate to be coated under environmentally and quality controlled conditions to provide exceptional adhesion and long lasting protection. Following the surface preparation procedure above, it is important to apply a light rinse and allow to dry prior to painting.

Apply SuperPaint™ Machine Finish Latex Primer at a minimum of 4 mils WFT. Allow minimum of 2 hours to dry. For best results, factory finish with 1 or 2 coats of SuperPaint™ Machine Finish Satin Topcoat at 4.0 to 6.0 mils WFT. Allow each coat to dry for 2 hours at 77° F, 50% RH. Force Dry with high intensity hot air or infrared head to a board surface temperature of 120°F for immediate recoat and packaging after board has cooled to ambient temperature. Use an IR gun to check the temperature of the trimboard. Oven dwell time will vary depending upon the curing method being used. Typical dwell times will be three (3) to five (5) minutes.

Product may be shipped with only a primer coat, but must be top coated within 180 days after installation. Follow above instructions for Field Applied Topcoats.

All exposed surfaces must be coated. All field cut edges must be primed with one of the above primers and finished with the recommended topcoats.

Packaging

Interleaving is preferred as this will create a barrier to prevent edge blocking or what we refer to as paint pick off. Blocking is common with an acrylic latex coating if trimboards are stacked together. If product is being forced dried in an oven the product must be allowed to cool to a temperature less than 100°F prior to packaging. If the product is being air dried it may take 10 to 20 days to achieve adequate cure before the product can be packaged. Factors such as humidity, temperature, air movement and the amount of tint in the paint will all affect the length of cure.

For questions regarding the above specification you may call (800) 4-Sherwin. You can also contact your local Sherwin-Williams Representative at (800) 524-5979 for Technical Data Sheets, MSDS or EDS sheets on any of the above listed products.

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KEM AQUA® 600 Smooth/ Water Reducible Enamel

Black F73B530
Clear F73V531
White F73W532

DESCRIPTION

KEM AQUA® 600 Smooth Water

Reducible Enamel is a one component, low gloss, 2.3 lb/gal VOC complying, acrylic latex, water reducible coating developed for the electronic business machine market. This product can be used as a smooth coating on treated metal, structural foam plastic, and wood substrates to obtain very smooth, non-orange peel surfaces.

Advantages:

- VOC of less than 2.3 lb/gal
- Meets the performance requirements of the electronic cabinetry industry
- Air dry or force dry – low energy cure
- Excellent solvent resistance
- Excellent smoothness - no orange peel
- One package – no catalyst
- Reduce and clean up with water - means cost savings for solvent and insurance, reduced fire hazards, lower odors and improved working conditions
- Apply with conventional, airless, air assisted airless, or HVLP spray methods
- Available in a broad range of colors
- Ideal for a wide range of product finishing
- No flash point
- Low HAPS content
- Free of lead hazards as packaged in compliance with Consumer Product Safety Commission's (CPSC) 16CFR Chapter II: Subchapter B, part 1303

CHARACTERISTICS

Gloss: 25-35 units
Volume Solids: 36-40 ± 1%
varies by color

Viscosity:
61-67 Krebs Units

Recommended film thickness:
Mils Wet 4.0 - 5.5
Mils Dry 1.5 - 2.0

Spreading Rate (no application loss)
297-439 sq ft/gal @ 1.5-2.0 mil DFT

Drying (1.0 mils dft, 77°F, 50% RH):
To Touch: 5-15 minutes
Tack Free: 15-20 minutes
To Handle: 30-45 minutes
To Pack: overnight
Force Dry: 30 minutes at 140°F

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

Flash Point: None, Seta Flash
Closed Cup

Package Life: 1 year unopened,
inside storage

pH: 8.0 - 8.5

Air Quality Data: (Theoretical)
Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum, less exempt solvents 1.89 lb/gal, 226 g/L

Volatile Organic Emissions as packaged, maximum
.99 lb/gal, 118 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility.

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: Prime with Kem Aqua Wash Primer E61G520.

Galvanized Steel: Prime with Kem Aqua Wash Primer E61G520.

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. If needed, prime with Kem Aqua Bonding Primer E61W525 or Polane W2 Primer E61AC514. If filling is required use Kem Aqua 65P SprayFil. Please consult your Sherwin-Williams Chemical Coatings Sales Representative for system recommendations.

Steel: 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. If needed, prime with Polane W2 Primer E61AC514. If filling is required use Kem Aqua 65P SprayFil.



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KEM AQUA® 600 Smooth/ Water Reducible Enamel

Wood (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties. Prime with Kem Aqua 65P SprayFil, Sher-Wood 2400 Millwork Primer E60W501, or Polane W2 Primer E61AC514.

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.

APPLICATION

Typical Setups

May require two coats. Spray a full wet coat and allow to flash off 10 minutes before applying the second coat

Reduction: Reduce with water as needed up to 10%.

Conventional Spray

Air Pressure45-60 psi
Fluid Pressure15-20 psi
Tip Size040 - .070"

HVLP

Air Pressure 8-10 psi
Fluid Pressure 10-15 psi
Tip Size040 - .070"

Air Assisted Airless

Fluid Pressure 600-800 psi
Air Assist Pressure 5-15 psi
Tip009 - .013"

Airless

Fluid Pressure 1600-2300 psi
Tip011 - .013"

Cleanup:

This product dries hard and adheres tightly to tanks and equipment. Cleanup may be very difficult once material is fully dry. For best results, wash with water while coating is still wet. If the product has begun to dry, use a blend of 4 partswater, 1 part Butyl Cellosolve, and 1-2% household ammonia to clean up equipment and tanks. Use protective safety apparel (rubber gloves, chemical mask, and safety glasses) when handling this solution. Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Avoid freezing. Store at temperatures of 50°F to 100°F.
- Keep container closed to prevent skinning of this fast dry coating. Filtering may be required.
- Product is thixotropic. Do not use viscosity cup to measure viscosity. Do not reduce over 10%.
- A minimum of 1.1 mils dry film per coat is required for good adhesion and film integrity.
- Do not apply with electrostatic bell or turbodisk.
- Not intended for long term exterior applications.
- The practical upper limit for gloss is 40-45 units. This range will require up to a 1:1 addition of F73V531. Kem Aqua 600 is not a high gloss coating.
- Kem Aqua Colorants not to exceed 8 ounces per gallon.

- Gloss levels may be adjusted by using D64F505 Kem Aqua Flattening Base. Refer to data sheet CC-S13 for details.

Performance Tests

24 gaugeBonderite 1000 steel panels and 1.5 mils dft, 14 days air drying
Salt Spray Test
ASTM B11748-72 hours
Humidity
ASTM D2247, 100°F, 100% RH ...
100 hours
Pencil Hardness HB
Taber Abrasion
CS 17 wheel, 1000 g, 1000 cycles ...
<100 mg
Freeze Thaw Stability2 cycles

Chemical Resistance

After ½ hour spot test and 1 hour recovery
IsopropanolExcellent
10% NaOHExcellent
Ethyl AcetateGood
AmmoniaExcellent
Ivory LiquidExcellent
Clorox Formula 409Excellent
MEKGood
TolueneGood
10% HClExcellent
1 normal H2SO2Excellent
5% Tide solutionExcellent
MEK Resistance 50 double rubs .Passes

Stain Resistance

After ½ hour spot test
CoffeeExcellent
VaselineExcellent
Coca ColaExcellent
CatsupExcellent
Motor OilExcellent
GasolineExcellent
LipstickExcellent



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KEM AQUA[®] 600 Smooth/ Water Reducible Enamel

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

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.



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Tip Size040 - .070"

HVLP

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100 hours
Pencil Hardness HB
Taber Abrasion
CS 17 wheel, 1000 g, 1000 cycles ...
<100 mg
Freeze Thaw Stability2 cycles

Chemical Resistance

After ½ hour spot test and 1 hour recovery
IsopropanolExcellent
10% NaOHExcellent
Ethyl AcetateGood
AmmoniaExcellent
Ivory LiquidExcellent
Clorox Formula 409Excellent
MEKGood
TolueneGood
10% HClExcellent
1 normal H2SO2Excellent
5% Tide solutionExcellent
MEK Resistance 50 double rubs .Passes

Stain Resistance

After ½ hour spot test
CoffeeExcellent
VaselineExcellent
Coca ColaExcellent
CatsupExcellent
Motor OilExcellent
GasolineExcellent
LipstickExcellent

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Bonding

When bonding VERSATEX to itself or another PVC material, most standard PVC pipe cements perform well especially those that are solvent based. Care should be taken to assure the substrates are clean and dry. Also, cements with moderate to slow setup time are preferred. When bonding VERSATEX sheets to themselves to obtain a thicker product, additional adhesive cure time will be required due to the impervious nature of VERSATEX. Extreme Adhesive PVC TrimWelder Laminating Grade is an ideal product for this application. Through independent testing VERSATEX has identified a few adhesives and sealants that provide outstanding PVC bond strength (see chart on the next (2) pages). Although most cyanoacrylates (super glues) are excellent for bonding VERSATEX to itself, they are prone to breakdown when subjected to a moist environment. Adhesive and sealant formulations vary with each manufacturer. Performance is dependent upon the application. Therefore, each adhesive and sealant should be tested in the field on a small sample of VERSATEX to determine compatibility before being placed into use.

Please consult the manufacturer for recommended products for your application.

Recommended Adhesive Tape Manufacturers:

Double sided adhesive tapes

Manufacturer Website:

3M: www.3m.com

Venture Tape: www.venturetape.com

Covalence Adhesives: www.covalenceadhesives.com

Scapa: www.scapa.com

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Bonding & Filling Applications

Adhesives

Manufacturer	Products	Application
<p>Extreme Adhesive 63 Epping Road, Raymond, NH 03077 www.extremeadhesives.com P. (800) 888-Glue (4583) P. (603) 895-4028 F. (603) 895-6236</p>	<p>Methyl methacrylates, cyanoacrylates, epoxies, anaerobics, UV curing acrylics and Hotmelts.</p>	<p>PVC TrimWelder - VERSATEX to Itself as well as most metals (galvanized and aluminum), most plastics, fiberglass, wood and wood composites. Consult the manufacturer regarding your specific application.</p>
<p>IPS Corporation 202 Industrial Park Lane Collierville, TN 38017 www.ispcorp.com P. (901) 853-5001 F. (901) 853-5008 E. info@ispcorp.com</p>	<p>Weld-On 705, 717, 719 and 4052 (slow cure & low VOC). Two part systems include 810, 811(cart.) and 815(cart.).</p>	<p>VERSATEX to itself. Use Weld-On 4052 when more working time is needed. 717 is a medium set while 719 is a slightly slower set. Both have a higher viscosity than 705.</p>
<p>Ze-VO Products Group, LLC 14 Eastern Park Road East Hartford, CT 06108 www.ze-vo.com P. (508) 879-3151</p>	<p>1-Part-Adhesive Cellular PVC Cement</p>	<p>For bonding VERSATEX to itself. Consult the manufacturer regarding your specific application.</p>
<p>Trim Glue, Inc. www.TrimTight.com P. (877) 874-6458 F. (888) 329-4583</p>	<p>TrimTight cellular PVC cement. Eco-Friendly, Low VOC, UV stable</p>	<p>VERSATEX to itself. Consult the manufacturer regarding your specific application.</p>
<p>T. Christy Enterprises, Inc. 655 East Ball Road, Anaheim, CA 92805 www.tchristy.com P. (800) 258-4583 F. (800) 468-4583</p>	<p>Red Hot White Vinyl Adhesive. 10.3 Fl. Oz tubes.</p>	<p>VERSATEX to itself. Available in a standard caulking tube making it ideal for use in the field. Consult the manufacturer regarding your specific application.</p>
<p>ICI - Macco Adhesives 15885 West Sprague Road Strongsville, OH 44136 www.liquidnails.com P. (800) 634-0015 F. (440) 297-7366</p>	<p>Liquid Nails Adhesive for Heavy Duty Construction & Remodeling (LN-901), Liquid Nails Adhesive for Sub-Floors & Decks (LN-602), Polyurethane Construction Adhesive, Contact Cement.</p>	<p>Check Technical Data Sheets for product compatibility. Consult the manufacturer regarding your specific application.</p>
<p>Henkel Consumer Adhesives Mentor, Ohio 44060 www.stickwithpl.com P. (800) 624-7767</p>	<p>PL Ultimate Hybrid Sealant & Adhesive, PL Premium Polyurethane Construction Adhesive. OSI TrimTeQ Bond PVC Miter Joint and Adhesive OSI TrimTeQ mount polyurethane based adhesive designed for PVC Trim.</p>	<p>VERSATEX to itself and other substrates. Consult the manufacturer regarding your specific application. Water in the form of a mist is required to activate a polyurethane adhesive when bonding VERSATEX to itself.</p>

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Bonding & Filling Applications

Adhesives Continued

Manufacturer	Products	Application
Ambel Corporation 12040 Murphy Highway Clinton, MI 49286 www.excelglue.com P: (800) 779-3935 F: (734) 726-5093	Excel One Liquid Polyurethane Adhesive, Excel Xpress Gel Polyurethane Adhesive and Excel Structan Polyurethane Adhesive.	VERSATEX to itself and various substrates. Consult the manufacturer regarding your specific application.
3M 3M Center Saint Paul, MN 55144 www.3m.com P: (888) 364-3577	Fastbond Scotch Weld 4475 Scotch Weld Polyurethane Adhesive	VERSATEX to various substrates including glass, plastic, wood and Formica. Consult the manufacturer regarding your specific application.

Sealing and Filling

For sealing, caulking and filling VERSATEX or just repairing a ding or a dent, there are a few options:

Manufacturer	Products	Application
NPC, Inc. 1208 South 8th Avenue Maywood, Illinois 60153 www.npcsealants.com P. (708) 681-1040 or (800) 654-1042 F. (708) 681-1424	#900 Solar Seal Terpolymer Sealant and Adhesive. #111 Trimboard White is a good color match to VERSATEX	Seals and adheres VERSATEX to itself and various substrates. Consult the manufacturer regarding your specific application. Available in over 200 standard colors & custom colors. Has a 20 yr. life expectancy. Paintable.
DAP, Inc. 2400 Boston Street Baltimore, MD 21224 www.dap.com P. (410) 675-2100 F. (410) 534-2650	Crack Shot High Performance Spackling Paste Fast N' Final Spackling	Fills nail holes and dents in VERSATEX. Painting is required. Fills nail holes and dents in VERSATEX. Painting is required.
Extreme Adhesive 63 Epping Road Raymond, NH 03077 www.extremeadhesives.com P. (800) 888-GLUE (4583) F. (603) 895-6236	PVC TrimWelder	Fills nail holes and dents in VERSATEX. Painting is required. Available in white only.

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Sealing and Filling Continued

Manufacturer	Products	Application
Henkel Corporation/OSI Professional & Consumer Sealants 7405 Production Drive Mentor, Ohio 44060 www.osipro.com P. (800) 321-3578 F. (440) 974-8358	Quad, TrimTeQ Mount, Polyurethane Based Solvent Adhesive, H2V Acrylic Urethane Sealant, PLV Himate Hybrid Sealant and Adhesives.	Seals and adheres to VERSATEX and various other substrates including wood and metal. Follow the manufacturer's application recommendations. Paintable.
Siroflex, Inc. P.O. Box 26749 Greenville, NC 29616 www.siroflexinc.com P. (800) 359-6398 or (864) 458-9094 F. (864) 458-9092	Duo-Sil Urethane Acrylic Sealant & Adhesive. Non-Hazardous, Non-Flammable, available in over 100 in stock colors.	Seals and adheres to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.
Franklin International 2020 Bruck Street Columbus, Ohio 43207 www.titebond.com P. (800) 877-4583 F. (614) 445-1813	WeatherMaster Sealant	Seals VERSATEX and various other substrates including wood metal (aluminum & brass), and fiberboard. Follow the manufacturer's application recommendations. Available in over 200 colors.
Geocel Corporation P.O. Box 398 Elkhart, IN 46515 www.Geocelusa.com P. (800) 348-7615 F. (800) 348-7009	2300 Construction Tripolymer Sealant	Seals to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.

As with any solvent based adhesive, sealant or filler, proper ventilation and a clean workspace are required to obtain adequate curing and provide a safe working environment for your employees. It is also recommended that you follow the manufacturer's storage and handling specifications. Discarding of unused adhesives or solvents may be subject to local, state or federal regulations.

B. Paints, Sealants, Adhesives

Technical Bulletin B-4

ASTM D3359 Paint Adhesion Test Method

ASTM D3359 test method assesses the adhesion of coating films to various substrates (such as metal and plastic) by applying and removing pressure-sensitive tape over “X” cuts made in the film.

Let’s focus on what X-cuts are. X-cuts are typically two 4cm long incisions intersecting each other in the middle with the smallest angle being 30° to 45°. A thin razor sharp knife is typically used to produce the “X”-Cut.

Most people make the cuts manually without the use of a template. When it comes to tape, all kinds of tape are used but typically 3M invisible tape is preferred. The tape is often smoothed with the fingernail but a rubber eraser on the end of a pencil should be used. Pulling off the tape correctly after using the prescribed period gives you the test result.

The evaluation according to the scale described in the standard is outlined below:

- 5A : no removal or peeling.
- 4A : Trace peeling or removal along incisions; leaves room for discussion, e.g.
- 3A : Jagged removal along incisions up to 1.6 mm on either side.
- 2A : Jagged removal along incisions up to 3.2 mm on either side.
- 1A : Removal from most of the area of the X under the tape.
- 0A : Removal beyond the area of the X.

There are two test methods under D 3359. Test Method A is primarily intended for use at job sites while Test Method B (PPG test method) is more suitable for use in the laboratory. Also, Test Method B is not considered suitable for films thicker than 5 mils (125µm).

These test methods are used to establish whether the adhesion of a coating to a substrate is at a generally adequate level. They do not distinguish between higher levels of adhesion for which more sophisticated methods of measurement are required.

B. Paints, Sealants, Adhesives

Technical Bulletin B-5

Heat Reflective Paint Technology

There is a limit to how dark of an acrylic latex paint you can apply to VERSATEX or any other cellular PVC trim, due to the amount of heat absorbed relative to the heat distortion temperature of the product. In the past, color has been limited to pastels with a Light Reflective Value (LRV) of 55 units or greater. Keep in mind LRV is a measure of heat gain by a paint where black = an LRV of 0 and white = an LRV of 100. Most recently, some paint companies have introduced heat reflective paint technology for vinyl based products. Aqua Sur Tech OEM has taken the lead in providing heat reflective paint. **Consult the paint representative or pre-finisher for recommended heat reflective paint colors compatible with VERSATEX.** Be sure these colors have an equivalent LRV of 55 units or greater.

VERSATEX Trimboard exhibits excellent paint adhesion when tested in accordance with ASTM D 3359 Cross-Cut Tape Test, Adhesion Strength Test. Although VERSATEX does not require paint for protection, it readily accepts 100% latex paints. Since moisture is not present in VERSATEX paint lasts longer on it than on wood.

Disclaimer

Wolfpac Technologies, Inc. is not liable for paint used on VERSATEX Trimboards and/or the results of its use.