



VERSATEX
T R I M B O A R D

TRIM SMARTER.

B. Paints, Sealants, Adhesives

Technical Bulletin B-2

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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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.

Disclaimer

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



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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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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 gauge Bonderite 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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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.