



V - Ace 5000

886B100A
886B101
886R100
886W100

PRODUCT DESCRIPTION:

V Ace 5000 is an acrylic urethane system that is designed for use over various plastic substrates. Does not need a primer over most rigid plastics. Solid colors only does not require a clear coat

TECHNICAL DATA:

	886B100A	886B101	886R100	886W100
color	Black	L/G Black	Red	White
Mixing ratio by weight:	AC10813	AC10657	AC10987	AC10812
Basecoat: Hardener: Solvent Blend	100:13.6: 40	100:13.6: 50	100:13.6: 50	100:10.1:25
Viscosity applied:	16 - 18 sec # 4 Ford			
Coverage @ 1 mil Dry	455 sq ft	437 sq ft	421 sq ft	500 sq ft
Recommended dry film thickness:	1.2 - 1.6 mils			
% Volume solids sprayable	28	27	26	31
Pot Life:	4 hrs	4 hrs	4 hrs	4 hrs
VOC	5.27 lbs	5.34 lbs	5.41 lbs	5.04 lbs

Meets the following OEM specifications
Mitsubishi ES-X71222 PD3

SURFACE PREPARATION:

Suitable substrates: various rigid

ABS, PC/ABS, Acrylic, and PC/PBT

**Note: With the inconsistencies of substrates, consult your local SHERWIN-WILLIAMS Representative for system recommendations and substrate testing.*

1. Clean as required
2. Surface must be free from all foreign substances: degrease or power wash

Prepainted Substrates:

1. Recoatable with itself
2. Lightly scuff sand to slightly dull surface appearance

MIXING:

1. Stir or shake V Ace 5000 Solid Colors thoroughly before mixing.
2. Mix by weight per above recommendations using 700C811 Hardener #1 and V-Ace Thinner Blends
3. To application viscosity of 16 to 18 sec # 4 Ford Cup as determined by line trials
4. Stir thoroughly and strain.

APPLICATION:

1. For proper results use the following recommendations. Check equipment by applying V Ace Solid Color to a test panel before using.
2. Apply 2 coats of V Ace Solid Color to achieve the recommended dry film thickness of 1.2 - 1.6 mils.
3. Flash V Ace Solid Colors 10 to 15 minutes
4. Bake 30 min at 180F part temperature

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PRODUCT AT-A-GLANCE

PRODUCT **V Ace 5000**

USE

- Direct to properly cleaned plastics
- Low Bake Cure

SUITABLE SUBSTRATES

- Rigid
 - ABS, PC/ABS, Acrylic, GTX 600, PC/PBT
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SURFACE PREPARATION

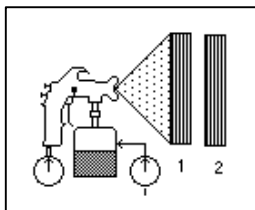
- Clean as required
- Surface must be free from all foreign substances: degrease or powder wash

MIXING

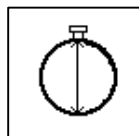
- Stir or shake V Ace 5000 Solid Color thoroughly before mixing.
- Mix by weight per above recommendations
- To application viscosity of 16 to 18 sec # 4 Ford Cup as determined by line trials
- Stir thoroughly and strain.

APPLICATION

Apply 2 coats



Time to
Cure
10 - 15 min minutes



PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.