



## V - Ace 5000 HS

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### PRODUCT DESCRIPTION:

V Ace 5000 HS 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:

	886 B 150
color	Black
Mixing ratio by weight:	AC 10813
Basecoat: Hardener: Solvent Blend	100:18:10
Viscosity applied:	16 - 18 sec # 4 Ford
Coverage @ 1 mil Dry	631 sq ft
Recommended dry film thickness:	1.2 - 1.6 mils
% Volume solids sprayable	39
Pot Life:	4 hrs
VOC	4.46 lbs

Meets the following OEM specifications  
Mitsubishi ES-X71222 PD3

### SURFACE PREPARATION:

*Suitable substrates: various rigid*

*ABS, PC/ABS, PMMA, 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 the surface

### MIXING:

1. Stir or shake V Ace 5000 HS Solid Colors thoroughly before mixing.
2. Mix by weight 100 pts B150: 18 pts 700C811: 10 pts V-Ace Thinner Blend
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

## PRODUCT AT-A-GLANCE

**PRODUCT**      **V Ace 5000 HS**

### USE

- Direct to properly cleaned plastics
- Low Bake Cure

### SUITABLE SUBSTRATES

- Rigid
  - ABS, PC/ABS, Acrylic, PC/PBT
- 

### SURFACE PREPARATION

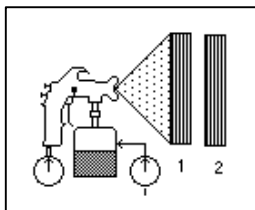
- Clean as required
- Surface must be free from all foreign substances: degrease or powder wash

### MIXING

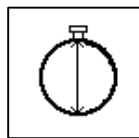
- Stir or shake V Ace 5000 HS Solid Color thoroughly before mixing.
- Mix by weight per above recommendations
- To application viscosity of 16 to 18 sec # 4 Ford Cup as determined by line trials
- Stir thoroughly and strain.

### 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.