



**PRODUCT DATA SHEET**

V-ACE™ 5000 886 Series Coating is a HAPs compliant 2K solvent monocoat system providing direct adhesion to multiple substrates used for interior rigid trim. This monocoat system is designed for application to interior parts such as radios, bezels and dashboards and is available in solid and metallic colors. The V-ACE™ 5000 886 Series Coating also offers a full range of gloss levels.



**SURFACE PREPARATION**

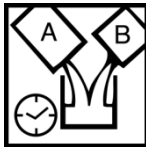
- To achieve the best physical properties the substrate should be free of mold release agents, dirt, or any other contamination.
- Clean the substrate with alcohol wipe or power wash substrate prior to application.



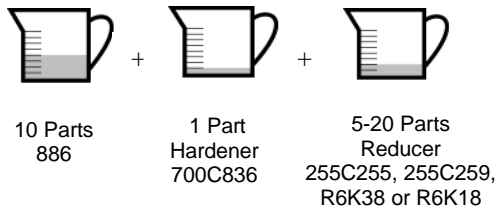
**SUITABLE SUBSTRATES**

- Adheres directly to PC (Polycarbonate), PC/ABS (Polycarbonate / Acrylonitrile Butadiene Styrene), ABS (Acrylonitrile Butadiene).

**Note:** Validation of application process is needed to determine whether primer should be used to prevent solvent soak in over specific substrates. Contact your Sherwin Williams Representative for details.

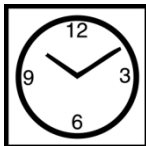


**MIXING**  
**By Volume**



**APPLICATION**

- Conventional spray equipment and/or HVLP.
  - Equipment set up recommendations are specific to customer application. Contact your Sherwin-Williams Representative for proper recommendations.
- Thoroughly mix contents with a mechanical agitator before using.
- Spray to recommended film thickness (0.8 – 1.2 mils).



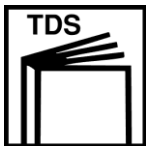
**DRYING SCHEDULE**

- 10 minute flash prior to bake.
- 30 minutes bake at 180°F.

**STORAGE**

- Store material indoors away from heat and sunlight.
- Recommended storage temperature between 40°F and 90°F.
- Shelf Life (unopened) – 24 months.

**TECHNICAL DATA**



	As Packaged		As Applied**		Viscosity, Zahn #4 @ 77° F	60-70KU
<b>WPG</b>	8.00-9.00		7.50-8.50		<b>Dry Film Thickness</b>	0.8-1.2 mils
<b>% Volume Solids</b>	20-35		10-25		<b>Pot Life @ 77° F</b>	30 minutes
	Lbs/Gal	G/L	Lbs/Gal	G/L	<b>Theoretical Coverage (sq ft/gal/mil)</b>	200-400
<b>VOC Total</b>	4.50-5.75	540-630	5.00-6.60	575-795	<b>Gloss Level (60°)</b>	5-90
<b>VOC Less Exempt</b>	5.00-6.00	600-700	5.50-6.50	650-750		

\*\*As applied based on 10 parts reduction with 255C259

**NOTE:** See COA for specific color information

To learn more about Sherwin-Williams® Products, please visit our web site at [www.sherwin-automotive.com](http://www.sherwin-automotive.com)