

Acry Glo[®] High Solids 830 Series (A and R Colors)

DESCRIPTION

Acry Glo[®] High Solids is a high performance, acrylic urethane designed for use on aircraft. This product is normally used for smaller areas including the painting of smaller general aviation aircraft or striping.

Advantages:

- Exhibits outstanding gloss and gloss retention upon weathering.
- Excellent Distinctness of Image (DOI).
- Contains less than 3.5 lbs. of VOC per mixed gallon.
- Free of lead and chromate hazards.
- Good Buffing Characteristics.

Acry Glo[®] High Solids is an intermix system. A wide selection of custom color matching is available.

COATING PROPERTIES

	Base Component	Admixed
Solids		
By weight	58.5-72.1	55.2-65.8
By volume	54.0-55.1	50.0-50.8
Wt. /Gal	8.3-11.1 lbs.	8.3-10.2 lbs.
Sp. Gravity	0.996 – 1.332	0.996 – 1.224
VOC:	<3.5 lbs./gal. (420 g/L)	
Workable Pot Life: (at 77°F, 25°C)	1.5 hours	
Dry Time:		
Tack Time	20 minutes	
To Tape (77°F, 25°C)	12 hours	
To Tape (120°F, 49°C)	3 hours	
Gloss:		
60°	90+ units	
Theoretical Coverage:		
Per 1 dry mil	800-815 ft. ² /gal.	
Per 25 µm	19.5 – 20.0 m ² /L	
Dry Film Weight:		
Per 1 dry mil	0.0061-0.0084 lbs/ft ²	
Per 25 µm	30-41 g/m ²	

SURFACE PREPARATION

Acry Glo[®] High Solids should always be applied to a surface that has been coated with an approved, properly prepared Sherwin-Williams Aerospace primer or Jet Glo[®] / Acry Glo[®] painted and cured surface.

The key for intercoat adhesion and a smooth appearing paint surface is to properly sand the cured primers. Mechanical DA (orbital) sanding or hand sanding of epoxy primer/surfacer works well with 220, 240, and 320 grit Fre-cut type sandpaper for maximum topcoat appearance. The final sand should be with 320 grit paper. Inadvertently sanding through any of the cured primer or surfacer will require spot repair before applying the topcoat. Lightly wipe the bare area with an Alodine solution and wipe off with deionized water once the chromate has adequately colored the bare spot. "Spot-in" with an epoxy corrosion protective primer is required to cover the spot Alodine treatment. This is time consuming, but will add long-term durability to the painted aircraft.

Air-blow the entire aircraft, wiping with clean lint-free cotton cloths.

Then lightly wipe all surfaces with MPK or isopropyl alcohol. Rags should be damp, not soaking wet, to avoid "rag marks" in the coating. Follow each four square foot section being wiped with a dry lint-free cotton cloth. (Deionized water is also acceptable and is more forgiving than wiping with solvent, but must be completely dry before applying paint.)

Next air-blow all surfaces to be painted again, wiping with clean lint-free cotton cloths. This should be a thorough process to remove sanding dust that will contaminate the coating.

NOTE: The paint materials being used should be mixed at this time and application equipment ready to use.

Using a urethane-grade tack cloth, thoroughly wipe all surfaces to be painted. Do not press hard against the surface with the tack rag. Discard the tack rag when it appears loaded with dust, and continue with a new one.

If your shop procedure is to cover the wings with paper, then another light tack-wipe of the fuselage is beneficial before painting.

SURFACE PREPARATION FOR STRIPES / LOGOS

For best adhesion bonding of solid and metallic colors to the cured High Solids basecoat, a thorough scuff sanding is recommended. Scuff sanding will lessen the orange peel appearance and assure long-term durability adhesion to the applied basecoat.



830 SERIES (A AND R COLORS) PRODUCT INFORMATION SHEET

220, 240, and 320 grit Fre-cut production sandpaper works best to prepare the surface for design feature stripes, registration numbers and logos. Tape edges and rivet lines can then be Scotch bried, to assure a sufficient paint bond to the tapeline edges.

Air blow the prepared surface with clean cotton lint-free cloths, and tack wipe with a urethane grade tack cloth. Stripes, registration numbers and logos do not need wiped with a solvent wash unless the surface has somehow been contaminated! Solvents will loosen the tape edge adhesion resulting in a rough edge appearance which is not desirable. Solvent wiping will also leave rag mark imprints in the applied color coat, creating costly rework repair.

MIXING INSTRUCTIONS

Pre-shake base component for 5-10 minutes.

Admix by volume:

3 parts Color
1 part Hardener (CM0830081)
* part Activator (see chart below)

* Available Activators

For Striping	½ part	Activator CM0830U18
For Large Areas	½ part	Activator CM0830C87
For Striping and Large Areas	3/8 part	Activator CM0830H18

Thin to approximately 16-18 seconds on a Zahn #2 cup (45-65 seconds on ISO 2431 3 mm Cup - Sheen) with approximately 10% CM0110944 Thinner.

It is recommended to strain admixed paint before placing material in containers for spraying.

Tape time can be accelerated using CM08181HR.

APPLICATION

This product can be applied using conventional air spray equipment, HVLP, Graco Pro 4500 air electrostatic, or Graco Pro 4500 air assisted airless electrostatic. Please consult your Sherwin-Williams representative for proper equipment settings.

Spray atomizing pressure: 50-60 psi

Pot pressure: 10-12 psi using a 60' fluid hose (3/8" diameter)

Delivery Rate: 8-10 fluid oz per minute

Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.

Best application results are obtained by applying two medium wet coats, allowing a 30-45 minute "tack-off" period between coats. If the dry time between coats exceeds 24 hours, the surface should be thoroughly abraded.

Recommended dry film thickness is 2-3 mils (51-76 µm). Some colors may require thicker films to achieve complete hiding.

NOTE: For projects requiring more than a one-hour application timeframe, it is recommended that the fluid lines be purged, the pressure pot cleaned, and a fresh mix of Acry Glo® High Solids used to finish the painting. (See pot life time.)

EQUIPMENT CLEANUP

Use clean Ketone-type solvents. Do not allow material to cure inside equipment.

SHELF LIFE

Shelf Life is applicable only for material stored in unopened and undamaged original factory filled containers.

Minimum Storage Temp. 40°F / 4°C
Maximum Storage Temp. 90°F / 32°C

CM0830XXX (A and R-colors) Base Component: 3 years
CM0830081: 2 years
CM0830U18: 2 years
CM0830C87: 2 years
CM0830H18: 2 years

Aerosol Touch-up Kits: 1 year
Cool, Dry Storage Required.

USE OF SYSTEMS STATEMENT

Sherwin-Williams Aerospace coatings have been developed and evaluated for use as complete systems. The Aerospace primers have been developed to be compatible with the Jet Glo®, Acry Glo® and Accent™ polyurethane coatings. Use of products not manufactured by Sherwin-Williams Aerospace as primer replacements is not recommended and could negatively affect coating appearance, inter-coat adhesion, chemical resistance, and durability of the finish. Use a complete Sherwin-Williams Aerospace system to ensure the long-term integrity of the coating.

HEALTH AND SAFETY INFORMATION

Consult the Material Safety Data Sheets for product information regarding health, physical and environmental hazards, handling precautions and "First Responder" first-aid recommendations.

PRODUCT INFORMATION

Please contact your Sherwin-Williams Aerospace Distributor or Representative for more information.

NOTE: Product Information Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Information 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.