



Acry Glo[®] Conventional Clear

CM0571080

ADVANTAGES

- Exhibits outstanding gloss and gloss retention upon weathering.
- Excellent Distinctness of Image (DOI).
- Provides durability and a smooth finish to Acry Glo Metallic finishes.
- Quick Drying.
- High Resistance to Chipping.
- Free of lead and chromate hazards.
- Good Buffing Characteristics.
- Corrosion and chemical resistance.

DESCRIPTION

Acry Glo[®] Clear is a high performance, multi-component acrylic urethane designed for use on aircraft. This product is intended to clear coat Acry Glo Metallic and solid color base coats.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	43.5 – 47.5%	45.2 – 48.2%
By volume	37.5 – 41.5%	38.9 - 41.9%
Wt./Gal.	8.0 – 8.6 lbs.	8.1 – 8.5 lbs.
Sp. Gravity	0.958 – 1.03	0.971 – 1.02

Viscosity–Sprayable

Gardner #2 Zahn Cup	16-18 seconds
ISO 2431 3mm Cup–Sheen	45-80 seconds

Admixed V.O.C. (3:1)

U.S. Exempt Solvent	<4.4 lbs./gal (526 g/L)
Non-Exempt Solvent	<4.4 lbs./gal (526 g/L)

Useable Pot Life

at 77°F / 25°C	2 Hours
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Gloss:

60 degree	90+ units
20 degree	80+ units

Theoretical Coverage

Per dry mil	650 ft. ² / gal.
Per 25 microns	16.0 m ² / L

Dry Film Weight

Per dry mil	0.0060 lbs. / ft. ²
Per 25 microns	29 g / m ²

SHELF LIFE

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

Minimum Storage Temp: 40°F / 4°C

Maximum Storage Temp: 100°F / 37°C

CM0571080: 3 years

CM0571081: 2 years

Aerosol Touch–up Kits: 1 year

Cool, Dry Storage Required.

SURFACE PREPARATION

CM0571080 Acry Glo Clear should be applied over an Acry Glo metallic or solid color base coat. The clear coat can be applied in as soon as one hour, but no later than 24 hours after application of the color. If applying the Clearcoat to a solid color basecoat after 24 hours, the surface should be abraded. Abrading a metallic basecoat is not recommended, so therefore clear coating must be completed within 24 hours.

MIXING INSTRUCTIONS

Stir the CM0571080 for 5 minutes before admixing.

Admix by Volume:

3 Parts	Acry Glo® Clear CM0571080
1 Part	Acry Glo® Hardener CM0571081

Admixed product should be allowed a 15-minute induction time for optimum application performance.

Reduce to desired application viscosity with approximately 10-25% thinner.

Available Thinners:

<u>Temperature</u>	<u>Thinner</u>	<u>Blend</u>
60-70°F (16-21°C)	CM0110755	100%
70-80°F (21-27°C)	CM0110701	100%
80-90°F (27-32°C)	CM0110701	90-95%
	CM0110821	5-10%
90°F+ (32°C+)	CM0110701	75-90%
	CM0110821	10-25%

When the relative humidity exceeds 65%, it is recommended to replace 25% of the thinner blend with urethane grade MEK (CM0110308).

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

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 specific equipment settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix thoroughly and filter strain before spray applying.
3. Spray atomizing pressure: 50-60 psi (3.45-4.15 bar)
Pot pressure: 10-12 psi (0.69 – 0.83 bar) using a 60' fluid hose (3/8" diameter)
Delivery Rate: 8-10 fluid oz (236-295 mL) per minute
3. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
4. Best application results are obtained by applying as a two-coat procedure. First apply a medium wet coat, allow a 30-45 minute "tack-off" period, followed by a second full wet coat. A third coat may be necessary on larger areas or if buffing the clear is included in the detail process.
5. If the dry time between coats exceeds 24 hours, the surface should be thoroughly abraded.
6. Recommended dry film thickness is 2-3 mils (50-75 microns).

NOTE: Application of these product systems requires recommended temperature / humidity conditions and film thickness ranges. The material, hangar, and aircraft skin temperature should be no lower than 55°F / 13°C before, during, and after application.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2-3 mils (50-75 microns).

Air Dry Times (75°F / 25°C and 50% RH)

Tack Free	3-4 Hours
To Tape	8-10 Hours

Recoat Time: (maximum) 24 Hours

NOTE: Lower temperatures, heavy film thickness, improper activator range selection and poor air movement will extend the dry time.

EQUIPMENT CLEANUP





Use clean Ketone-type solvents such as CM0110308 MEK. Do not allow material to cure inside equipment.

PRODUCT INFORMATION


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.

ACRY GLO® Conventional Clear CM0571080

- 1** Stir the CM0571080 for five minutes.
- 2** Add in order shown below. The Hardener should be mixed into the clear. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0571080 Clear	 3 Parts	3/4 Gal.	3/4 Qt. (24 oz.)	2.85 L	710 mL
 CM0571081 Hardener	 1 Part	1 Qt.	1/2 Pt. (8 oz.)	.95 L	235 mL

- 3** Allow admix to induct 15 minutes.
- 4** Reduce to desired viscosity with approximately 10-25% thinner using the following chart:

	Temperature	Reducer	Blend
	60-70°F (16-21°C)	CM0110755	100%
70-80°F (21-27°C)	CM0110701	100%	
80-90°F (27-32°C)	CM0110701 CM0110821	90-95% 5-10%	
90°F+ (32°C+)	CM0110701 CM0110821	75-90% 10-25%	

When the relative humidity exceeds 65%, it is recommended to replace 25% of the thinner blend with urethane grade MEK (CM0110308).

- 5** CM0571082 Accelerator is not recommended for use with the Clearcoat.
- 6** Filter strain and apply.