

Acry Glo[®] High Solids Basecoat Metallic Colors 830 Series (M Colors)

DESCRIPTION

The Acry Glo[®] High Solids basecoat system is a high performance, acrylic urethane designed for use as feature stripes over Jet Glo[®] and/or Acry Glo[®] products. As part of two stage system, this product requires the Acry Glo[®] High Solids clearcoat to achieve a high gloss finish.

Advantages:

- Fast dry times allowing for application of multiple stripes per shift.
- Good solvent resistance.
- Contains less than 3.5 lbs. of VOC per mixed gallon.
- Free of lead and chromate hazards.

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

COATING PROPERTIES

	Base Component	Admixed
Solids		
By weight	54.6-72.1%	42.3-54.3%
By volume	43.7-55.1%	34.3-40.0%
Wt. /Gal	8.3-11.1 lbs.	8.1-9.6 lbs.
Sp. Gr.	0.996-1.332	0.972-1.152
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	
Recoat Time		
Minimum	2-3 hours	
Maximum	24 hours	
Theoretical Coverage:		
Per 1 dry mil	550-640 ft. ² /gal.	
Per 25 μm	13.5-16 m ² /L	
Dry Film Weight:		
Per 1 dry mil	0.0063-0.0081 lbs./ft. ²	
Per 25 μm	31-40 g/m ²	

SURFACE PREPARATION

The Acry Glo[®] High Solids basecoat system 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 corrosion primer 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 of solid and metallic colors to the cured High Solids basecoat, a thorough scuff sanding is recommended. Scuff sanding will assure long-term adhesion to the applied basecoat.

830 SERIES (M COLORS) PRODUCT INFORMATION SHEET

220, 240, and 320 grit Fre-cut production sandpaper works best to prepare the surface for 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, wiping with clean, lint-free, cotton cloths, and tack wipe with a urethane grade tack cloth. Stripes, registration numbers and logos do not need solvent wiped unless the surface has somehow been contaminated. Solvents can lift the tape, allowing paint to flow beneath the tape and resulting in an uneven edge to the stripe or logo. Solvent wiping can also leave "rag marks" in the applied color coat, creating costly repair.

MIXING INSTRUCTIONS

Pre-shake base component for 5-10 minutes.

Admix by volume:

4 parts Color Component
1 part Hardener (CM0830081)
2 parts Activator/Stabilizer (CM0830991)
1 part Compliant Reducer (CM0110944)

Note: The CM0830991 Activator / Stabilizer is an integral component of the metallic system, and should not be disregarded.

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

It is recommended to filter strain the admixed metallic paint before placing in containers for spray application.

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 specific 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.

Acry Glo[®] High Solids Clear CM0830080 should be applied 2-3 hours, but within 24 hours, after applying the metallic or solid color basecoat. If applying the clearcoat to a solid color basecoat that has been allowed to dry longer than 24 hours then the basecoat should be abraded for maximum adhesion of the clearcoat. Abrading metallic basecoats is not recommended, therefore it is imperative that clearcoating occurs within the 2-24 hour window.

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 (M and A-colors) Base Component: 3 years
CM0830081: 2 years
CM0830991: 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 that are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.