



Acry Glo[®] Conventional Basecoat Metallic 571 Series (H Colors)

ADVANTAGES

- Cool Metallic Finish.
- A proven performance coating in the aviation industry for over 20 years.
- Quick Drying.
- High Resistance to Chipping.
- Free of lead and chromate hazards.
- Corrosion and chemical resistance.
- Unlimited metallic colors available.

DESCRIPTION

The **Acry Glo[®] Basecoat / Clearcoat** system is a high performance, multi-component, acrylic urethane designed for use as feature stripes over cured Jet Glo[®] and/or Acry Glo[®] Basecoats. This product requires the CM0571080 Acry Glo[®] Clearcoat.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	43.0 - 50.0%	40.0 - 46.5%
By volume	33.0 - 40.0%	31.0 - 31.9%
Wt./Gal.	8.7 - 9.7 lbs.	8.4 - 8.7 lbs.
Sp. Gravity	1.044 - 1.164	1.008 - 1.044
Viscosity—Sprayable		
Gardner #2 Zahn Cup	16-18 seconds	
ISO 2431 3mm Cup—Sheen	70-100 seconds	
Admixed V.O.C. (3:1/2:1/2)		
U.S. Exempt Solvent	<5.3 lbs./gal (634 g/L)	
Non-Exempt Solvent	<5.3 lbs./gal (634 g/L)	
Useable Pot Life		
at 77°F / 25°C	2 Hours	
Gloss:		
60 degree	90+ units	
20 degree	80+ units	
Theoretical Coverage		
Per dry mil	650-765 ft. ² /gal	
Per 25 microns	16.0 - 18.8 m ² /L	
Dry Film Weight		
Per dry mil	0.0063-0.0081 lbs./ft. ²	
Per 25 microns	31-40 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

CM0571XXX (H-colors) Base Component: 3 years
CM0571081: 2 years CM0571082: 2 years CM0571085: 3 years

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

SURFACE PREPARATION

Primed Surface

Acry Glo® should be applied to a surface that has been coated with an approved, properly prepared and applied Sherwin-Williams Aerospace primer system.

Refer to Sherwin-Williams Primer Product Data Sheets (Corrosion Primers CM0483660 and CM0724400 and Sanding Surfacers CM0482300, CM0560563 and CM0560566); training guides; and your Sherwin-Williams Representative for complete details.

Topcoat Surface

For best adhesion of trim colors to the cured urethane base coat, a thorough scuff sanding is recommended. Scuff sanding and cleaning will assure long-term durability and adhesion of the applied coating. Refer to Sherwin-Williams Topcoat Product Data Sheets, training guides, and your Sherwin-Williams Representative for complete details.

MIXING INSTRUCTIONS

Shake color component for 10-15 minutes before admixing.

Admix by Volume:

3 Parts Acry Glo® Metallic Color
(H- Color Numbers)

1/2 Part Acry Glo® Hardener
CM0571081

1/2 Part Acry Glo® Stabilizer
CM0571085

* *The stabilizer additive reduces mottling effect by setting the aluminum particle in the coating as it is applied.*

To speed up tape time, use up to 4 ounces per admixed gallon (120 mL per admixed 3.8 Liter) of CM0571082 Accelerator.

If clearcoating is expected to occur after 12 hours, do not accelerate. Extended times before clearcoat may create intercoat adhesion problems.

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 Reducers:

<u>Temperature</u>	<u>Reducer</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 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 Reducer blend with urethane grade MEK (CM0110308).

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 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
4. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
5. Best application results are obtained by applying two medium wet coats, allowing a 30-45 minute "tack-off" period between coats.
6. Recommended dry film thickness is 2-3 mils (50-75 microns). Some colors may require thicker films to achieve complete hiding.
7. **Acry Glo Basecoat Metallics must be recoated with Acry Glo Clearcoat CM0571080.** Refer to the Acry Glo® Clearcoat Product Information Sheet for mixing and application procedures.

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).

	Without Accelerator	4 oz./gal (120 mL /3.8 Liter) CM0571082 Accelerator
Clearcoat Time		
Minimum:	4-6 Hours	1-2 Hours
Maximum:	24 Hours	24 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.

NOTE: Abrading metallic basecoats is not recommended, therefore it is imperative that clearcoating occurs within the 1-24 hour window.

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 Basecoat Metallic 571 Series (H Colors)

- 1** Shake the color component CM0571XXX or HXXXXX for 10 - 15 minutes before admixing.
- 2** Add in order shown below. The Hardener and Stabilizer should be mixed into the color component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0571XXX HXXXXX Color	3 Parts	3/4 Gal.	3/4 Qt. (24 oz.)	2.85 L	710 mL
 CM0571081 Hardener	1/2 Part	1 Pt.	4 Oz.	.48 L	120 mL
 CM0571085 Stabilizer	1/2 Part	1 Pt.	4 Oz.	.48 L	120 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).

- 4** Tape time can be accelerated by using up to 4 oz. per admixed gallon (120 mL per admixed 3.8 liter) of CM0571082 Accelerator if clearcoating within 12 hours. Do not accelerate if clearcoating after 12 hours.
- 6** Apply.