SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Acry Glo® High Solids

830 Series (A and R- Colors)

Solid Colors

ADVANTAGES

- Exhibits outstanding gloss and gloss retention upon weathering.
- Contains less than 3.5 lbs/gal (420 g/L) of VOC.
- Quick Drying.
- Excellent Distinctness of Image (DOI).
- Single coat – no clear coat required.
- High Resistance to Chipping.
- Free of lead and chromate hazards.
- Good Buffing Characteristics.
- Corrosion and chemical resistance.
- Unlimited colors available.

DESCRIPTION

Acry Glo® High Solids is a high performance, acrylic urethane designed for use on aircraft. This product is designed to have the flexibility to use for striping as well as for overall painting of helicopters and small general aviation aircraft. . It can be applied over Jet Glo®, Jet Glo Express™, Acry Glo® or SKYscapes® topcoat systems

COATING PROPERTIES

Solids:	**Base Component**	**Admixed**
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

Viscosity–Sprayable	
Gardner #2 Signature Zahn Cup	16-18 seconds
ISO 2431 3mm Cup –Sheen	45-75 seconds
Admixed V.O.C. (3:1:3/8)	
U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)
Useable Pot Life	
at 77°F / 25°C	1.5 Hours
Gloss:	
60 degree	90+ units
20 degree	80+ units
Theoretical Coverage	
Per dry mil	800-815 $ft.^2$ / gal.
Per 25 microns	19.5-20.0 m^2 / L
Dry Film Weight	
Per dry mil	0.0061-0.0084 lbs. / $ft.^2$
Per 25 microns	30-41 g / m^2

SHELF LIFE

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

Minimum Storage Temp: 40ºF / 4ºC
Maximum Storage Temp: 100ºF / 37ºC

CM0830XXX (A or R-colors) Base Component: 5 years
CM0830081: 2 years
CM0830H18: 2 years

Aerosol Touch –up Kits: 1 year

SURFACE PREPARATION

Primed Surface
Acry Glo® High Solids 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 Corrosion Preventative Primer Product Data Sheets:
* Chromated Primers such as CM0483928, CM0483505, CM0483987 and CM0486606
* Chrome Hazard Free Primers such as CM0481968, CM0483712, CM0483787, CM0483790, and CM0486707
* Sanding Surfacers such as CM0480920
Consult 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. Tape edges and rivet lines should be scrubbed with an abrasive pad to assure a sufficient paint bond to the tapeline edge. 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® HS Color **(A- and R- Color Numbers)**
1 Part	Acry Glo® HS Hardener **CM0830081**
1/4-1/2 Part*	Acry Glo® HS Activator **CM0830H18**

*By using ½ part, the individual mix may exceed 3.5 ibs/gal (420 g/l) voc.

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

Reduce to desired application viscosity with approximately 10% by volume of CM0110944 Reducer.

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

Tape time can be accelerated by using CM08181HR Accelerator.

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 two medium wet coats, allowing a 30-45 minute "tack-off" period between coats.
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). Some colors may require thicker films to achieve complete hiding.

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 55ºF / 13ºC 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	
Tack Time	20 Minutes
Tape Time (75°F / 25°C)	12 Hours
Force Dry Times	
(120°F/49°C)	3 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.