



# Acry Glo<sup>®</sup> High Solid Clearcoat

CM0830080

## ADVANTAGES

- Basecoat/ Clearcoat system.
- 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

## DESCRIPTION

**Acry Glo<sup>®</sup> High Solids Clearcoat** is a high performance, acrylic urethane system designed for use on aircraft. This product is intended for clear coating Acry Glo<sup>®</sup> High Solids metallic and solid color base coats. Properly applied and cured CM0830080 clearcoat has anti-graffiti resistant protective and removal qualities.

## COATING PROPERTIES

<b>Solids:</b>	<b>Base Component</b>	<b>Admixed</b>
By weight	62%	52.1-54.0%
By volume	54%	46.2-48.3%
<b>Wt./Gal.</b>	8.31 lbs/gal.	8.33-8.51 lbs/gal.
<b>Sp. Gravity</b>	0.996	0.998-1.0197

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

U.S. Exempt Solvent <3.5lbs./gal (420g/L)

### Useable Pot Life

at 77°F / 25°C 1.5 Hours

### Theoretical Coverage

Per dry mil 730.0-761.0ft.<sup>2</sup> / gal.  
Per 25 microns 17.915-18.676 m<sup>2</sup> / L

### Dry Film Weight

Per dry mil 0.0059-0.0061 lbs. / ft.<sup>2</sup>  
Per 25 microns 29.0-29.5 g / m<sup>2</sup>

## 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

CM0830080: 3 years

CM0830081: 2 years

CM0830H18: 2 years

## SURFACE PREPARATION

Acry Glo® High Solids Clearcoat should be applied over an Acry Glo® High Solids metallic or High Solids color base coat. The clearcoat should be applied 2-3 hours after applying the basecoat, but within 24 hours. 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. Abrading metallic basecoats is not recommended, therefore it is imperative that clearcoating occurs within the 3-24 hour window.

## MIXING INSTRUCTIONS

**NOTE:** Acry Glo High Solids CM0830080 Clear Component should be shaker conditioned before admixing.

Pre-shake for 5-10 minutes on a mechanical paint shaker before admixing.

Admix by Volume:

<b>3 Parts</b>	Acry Glo® High Solids Clearcoat <b>CM0830080</b>
<b>1 Part</b>	Acry Glo® High Solids Hardener <b>CM0830081</b>
<b>3/8 Part</b>	Acry Glo High Solids Activator <b>CM0830H18</b>

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

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

Tape time can be accelerated by using CM08181HR. Refer to the CM08181HR Product Data Sheet for details.

## 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
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 5-10 minute "tack-off" period between coats.

6. If the dry time between coats exceeds 48 hours, the surface should be thoroughly abraded.

7. 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 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).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	Without <u>Accelerator</u>	1 oz./gal (30 mL /3.8 Liter) CM08181HR <u>Accelerator</u>
Dust Free	20 Minutes	20 Minutes
Dry to Handle	3 Hours	½ Hour
Tape Time	10 Hours	2-3 Hours
<b>Recoat Time:</b> (maximum)	48 Hours	12 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

Please contact your Sherwin-Williams Aerospace Distributor or Representative for more 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® High Solids Clear CM0830080

- 1** Shake the CM0830080 for 5-10 minutes before admixing.
- 2** Add in order shown below. The Hardener and Activator should be mixed into the color component. Stir as components are added.

Order of Addition		Volume	English		Metric	
			Large	Small	Large	Small
	<b>CM0830080</b> AXXXXX Color	<b>3 Parts</b>	3 Gal.	3 Qt.	11.4 L	2.85 L
	<b>CM0830081</b> Hardener	<b>1 Part</b>	1 Gal.	1 Qt.	3.8 L	.95 L
	<b>CM0830H18</b> Activator	<b>3/8 Part</b>	3 Pt.	12 Oz.	1.4 L	.36 L

- 3** Allow admix to induct 15 minutes.
- 4** Check viscosity to ensure 16-18 seconds on a Gardner Signature Series Zahn #2 Cup (45-65 seconds on ISO 2431 3mm Cup). Use approximately 10% by folume of **CMO110944** if additional Reducer is required.
- 5** Tape time can be accelerated by using **CM08181HR**.
- 6** Filter strain and apply.