



SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

ADVANTAGES

- High gloss, extremely durable product
- Designed to work over Sherwin-Williams SKYscapes® or SKYscapes® General Aviation Clearcoat basecoat systems
- Can also be used over Acry Glo® Conventional and Acry Glo® High Solids metallic colors.
- Excellent buffability
- Fast dry times that lead to improved productivity
- Easy to mix
- Excellent flow and leveling
- When used over SkyScapes® General Aviation basecoat, system has good chemical resistance to Royco 756 and is suitable for use on aircraft utilizing MIL-PRF-5606 hydraulic fluid.

SKYscapes®

General Aviation Clearcoat

CM0850CC1

DESCRIPTION

SKYscapes® General Aviation Clearcoat is an aircraft grade, polyester urethane designed to be used over SKYscapes® basecoat on exterior surfaces of general aviation aircraft (i.e. Non-Skydrol aircraft). This high performance product is designed to deliver the maximum in appearance and productivity in a high-gloss, durable finish that can be easily cleaned, buffed and repaired.

COATING PROPERTIES

Solids:

By weight	(3:1:10%)
	(3:1:1)
By volume	(3:1:10%)
	(3:1:1)

Sprayable

52.9%
47.4%
46.7%
41.1%

Density:

8.29 lb/gal
993 g/l

Viscosity-Sprayable

Mixed 3:1:10%	
With CM0110106 Reducer	17-21 seconds
Mixed 3:1:1	
With CM0110106 Reducer	14-19 seconds

V.O.C. (Mixed 3:1:10%)

U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)
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V.O.C. (Mixed 3:1:1)

U.S. Exempt Solvent	<4.0 lbs/gal (475 g/L)
Non-Exempt Solvent	<4.4 lbs/gal (519 g/L)

Useable Pot Life

at 77°F / 25°C	1.5 Hours
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Theoretical Coverage

Per dry mil	668 ft. ² / gal.
Per 25 microns	16.4 m ² / L

Dry Film Weight

Per dry mil	0.006 lbs. / ft. ²
Per 25 microns	28.95 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

CM0850CC1: 7 years

CM0850CH1: 7 years

CM0110106: 7 years

CM0110104: 7 years

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SURFACE PREPARATION

CM0850CC1 SKYscapes® General Aviation Clearcoat is designed to be applied over Sherwin Williams 850 series SKYscapes® Basecoat colors. It can also be used over over Acry Glo® Conventional and Acry Glo® High Solids metallic colors.

MIXING INSTRUCTIONS

Mix by Volume:

3 Part	SKYscapes® General Aviation Clearcoat CM0850CC1
1 Part	SKYscapes® Clearcoat Hardener CM0850CH1
1 Part*	SKYscapes® Clearcoat Activated Reducer CM0110106 or Universal Reducer- Medium CM0110104 – use for cold temperatures

*For U.S. VOC compliance, only use up to 10% reducer with mix.

Add the Hardener and Reducer into the Clearcoat.

It is recommended to filter strain mixed Clearcoat before placing material in containers for spraying.

APPLICATION

Apply one heavy cross coat or two coats with a 5-7 minute flash time. Apply the second coat of clear after the first coat has become hand slick but before 45 minutes to prevent a possible recoat lift. Use a gun distance of 5 – 7 inches.

Desired film build is 2.0 – 2.5 mils (dry).

RECOMMENDED FLUID TIP SIZES

HVLP / compliant guns.

Air Cap Pressure 9 psi – 10 psi

Conventional Gun

Air Cap Pressure 35 psi – 45 psi

DRYING SCHEDULE

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

Air Dry:

Tack Free 45 minutes

Force Dry Time:

Minimum 30 minutes @ 140°F (60°C)

Before applying heat, allow the Clearcoat to flash off at room temp for 15-30 minutes.

Buffing Time:

4-6 Hours

If force dried, wait 30 minutes after cool down.

NOTE: Lower temperatures, heavy film thickness, improper and poor Air movement will extend the dry time.

REPAIR PROCEDURE




- Prep surface with 320 grit sandpaper.
- Wipe surface free of any dust.
- Mix and apply as directed.
- After cure, buff as needed.

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.

SKYscapes® General Aviation Clearcoat CM0850CC1

- 1** Mix components by volume.
- 2** Add in order shown below. The Hardener and Reducer should be mixed into the clearcoat component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0850CC1 Clearcoat	3 Parts	3 Gal.	3 Qt.	11.4 L	2.85 L
 CM0850CH1 Hardener	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0110106 US Exempt Reducer OR CM0110104 Reducer	1 Part*	1 Gal.	1 Qt.	3.8 L	.95 L

*For U.S. VOC compliance, only use up to 10% reducer with mix.

- 3** The **CM0110104** Reducer should be used for cold temperatures.
- 4** Filter strain and apply.