



Acry Glo[®] High Solids

830 Series (M- Colors) Basecoat Metallic Colors

ADVANTAGES

- Contains less than 3.5 lbs/gal (420 g/L) of VOC.
- Cool Metallic Finish
- Quick Drying which allows for the application of multiple stripes per shift.
- High Resistance to Chipping.
- Free of lead and chromate hazards.
- Corrosion and chemical resistance.
- Unlimited metallic colors available.

DESCRIPTION

The **Acry Glo[®]** High Solids basecoat metallic system is a high performance, acrylic urethane designed for use as feature stripes on aircraft. It can be applied over Jet Glo and Acry Glo topcoat systems. As part of a two-stage system, this product requires an Acry Glo Clearcoat to be applied over the metallic to achieve a high gloss appearance.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	55.5 – 72.1%	40.2 - 55.0%
By volume	44.4 - 55.1%	31.3 - 40.0%
Wt./Gal.	8.3 - 11.1 lbs.	8.0 - 9.3 lbs.
Sp. Gravity	0.996 - 1.332	0.960 - 1.116

Viscosity–Sprayable

Gardner #2 Signature Zahn Cup	16-18 seconds
ISO 2431 3mm Cup –Sheen	45-75 seconds

Admixed V.O.C. (4:1:2)

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

at 77°F / 25°C	1.5 Hours
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Gloss:

60 degree	90+ units
20 degree	80+ units

Theoretical Coverage

Per dry mil	500-640 ft. ² / gal.
Per 25 microns	12.3 - 15.8 m ² / L

Dry Film Weight

Per dry mil	0.0061-0.0081 lbs. / ft. ²
Per 25 microns	30-40 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

CM0830XXX (M-colors) Base Component: 5 years

CM0830081: 2 years

CM0830991: 2 years

CM0110944: 7 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 Primer Product Data Sheets (Corrosion Primers CM0483928 and CM0483505 and Sanding Surfacing CM0480920 and CM0481810); 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. 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:

4 Parts	Acry Glo® HS Metallic Color (M- Color Numbers)
1 Part	Acry Glo® HS Hardener CM0830081
2 Parts	Acry Glo® HS Activator / Stabilizer CM0830991
1 Part	US Exempt Reducer CM0110944

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

If additional reducer is required, Use up to 10% by volume of CM0110944 Reducer.

Must be clearcoated with CM0830080 Acry Glo HS Clearcoat.

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 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.** Refer to the Acry Glo® Clearcoat Product Information Sheets 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).

Clearcoat Times

Minimum	2-3 Hours
Maximum	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 2-24 hour window.

EQUIPMENT CLEANUP


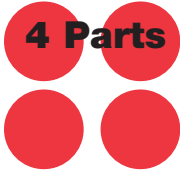






Use clean Ketone-type solvents such as CM0110308 MEK. Do not allow material to cure inside equipment.

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® High Solids Basecoat Metallic 830 Series (M Colors)

- 1** Shake the CM0830XXX or MXXXXX 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	English		Metric	
		Large	Small	Large	Small
 CM0830XXX MXXXXX Color	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0830081 Hardener	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0830991 Stabilizer/Activator	 2 Parts	2 Gal.	2 Qt.	7.6 L	1.9 L
 CM0110944 Reducer	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Check viscosity to ensure 16-18 seconds on a Gardner Signature Series Zahn #2 Cup (45-65 seconds on ISO 2431 3mm Cup). If additional Reducer is required, use up to 10% by volume of **CM0110944 Reducer**.
- 4** Tape time can be accelerated by using **CM08181HR Touch Up Accelerator**.
- 5** Filter strain and apply.
- 6** Must be clearcoated with a **Sherwin-Williams Aerospace Clearcoat**.