



Acry Glo[®] Conventional

571 Series (W and T Colors)

ADVANTAGES

- A proven performance coating in the aviation industry for over 20 years.
- Quick Drying.
- Exhibits outstanding gloss and gloss retention upon weathering.
- Excellent Distinctness of Image (DOI).
- High Resistance to Chipping.
- Free of lead and chromate hazards.
- Good Buffing Characteristics.
- Corrosion and chemical resistance.
- Unlimited colors available.

DESCRIPTION

Acry Glo[®] is a high performance, multi-component acrylic urethane designed for use on aircraft. This product is designed to have the flexibility to use for striping as well as for painting helicopters and smaller aircraft.

COATING PROPERTIES

| Solids: | Base Component | Admixed |
|-------------|----------------|---------------|
| By weight | 45.9-65.0% | 46.8-62.1% |
| By volume | 39.8-49.3% | 40.5-47.7% |
| Wt./Gal. | 8.5-11.3 lbs. | 8.4-10.6 lbs. |
| Sp. Gravity | 1.02-1.356 | 1.008-1.272 |

Viscosity—Sprayable

| | |
|------------------------|----------------|
| Gardner #2 Zahn Cup | 16-18 seconds |
| ISO 2431 3mm Cup—Sheen | 70-100 seconds |

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

| | |
|---------------------|-------------------------|
| 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 | 0.0061-0.0084 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: 40°F / 4°C

Maximum Storage Temp: 100°F / 37°C

CM0571XXX (W or T-colors) Base Component: 3 years

CM0571081: 2 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 Surfacer 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® Color
(W- and T- Color Numbers)

1 Part Acry Glo® Hardener
CM0571081

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 Thinners:

| Temperature | Thinner | 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).

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

Tape time can be accelerated by using up to four ounces per admixed gallon (120 mL per admixed 3.8 Liter) of CM0571082 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 5-10 minute "tack-off" period between coats.
5. If the dry time between coats exceeds 48 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 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).

| Air Dry Times (75°F / 25°C and 50% RH) | Without Accelerator | 4 oz./gal (120 mL /3.8 Liter) CM0571082 Accelerator |
|---|---------------------|--|
| Dust Free | 20 Minutes | 20 Minutes |
| Dry to Handle | 3 Hours | ½ Hour |
| Tape Time | 10 Hours | 2 Hours |

Recoat Time: (maximum) 48 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.

ACRY GLO® Conventional 571 Series (W and T Colors)

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

| Order of Addition | Volume | U.S. | | Metric | |
|---|--|----------|---------------------|--------|--------|
| | | Large | Small | Large | Small |
|  CM0571XXX or WXXXXX or TXXXXX Color |  3 Parts | 3/4 Gal. | 3/4 Qt. (24 oz.) | 2.85 L | 710 mL |
|  CM0571081 Hardener |  1 Part | 1 Qt. | 1/2 Pt. (8 oz.) | .95 L | 235 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 | 90-95% |
| | CM0110821 | 5-10% |
| 90°F+ (32°C+) | CM0110701 | 75-90% |
| | CM0110821 | 10-25% |

When the relative humidity exceeds 65%, it is recommended to replace 25% of the thinner blend with urethane grade MEK (CM0110308).

- 5** Tape time can be accelerated by using up to 4 oz. per admixed gallon (120 mL per admixed 3.8 liter) of CM0571082 Accelerator.
- 6** Filter strain and apply.