



Aerospace Clearcoat

CM0ACC201

ADVANTAGES

- High gloss and extremely durable product
- Designed to work over all Sherwin-Williams aerospace basecoats such as SKYscapes® basecoats (850 and 855 Series) and SKYscapes Single Stage (858 series), JetGlo Express, and AcryGlo.
- Can be used over properly prepared dry topcoat systems such as Acry Glo® Conventional and Acry Glo® High Solids
- Excellent buffability
- A customizable and flexible wet edge and dry time system for improved productivity
- Easy to mix
- Excellent flow and leveling

DESCRIPTION

The CM0ACC201 Aerospace Clearcoat is designed to be used over all topcoat systems on exterior surfaces of general aviation aircrafts (i.e., non-Skydrol areas on aircraft). This high-performance product is designed to deliver maximum appearance and productivity by offering a high-gloss, durable finish that can be easily cleaned, buffed, and repaired. The product mix allows the painter to modify the wet edge times by blending activators.

COATING PROPERTIES

Solids:	<u>Sprayable</u>
By weight	45.3%
By volume	41.1%
Density:	8.64 lb./gal 1036 g/l
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	14-17 seconds
V.O.C. (Mixed 3:1:1)	
U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)
Non-Exempt Solvent	<4.8 lbs./gal (576 g/L)
Useable Pot Life	
at 77°F / 25°C	4 Hours
Theoretical Coverage	
Per dry mil	659 ft. ² / gal.
Per 25 microns	16.2 m ² / L
Dry Film Weight	
Per dry mil	0.006 lbs. / ft. ²
Per 25 microns	29.0 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

CM0ACC201		3 years
CM0ACH201		7 years
CM0ACA203	Slow	7 years
CM0ACA205	Medium	7 years
CM0ACA207	Fast	7 years

SURFACE PREPARATION

The CM0ACC201 Aviation Clearcoat should be applied to a surface that has been coated with an approved and properly prepared Sherwin-Williams Aerospace topcoat.

Refer to Sherwin-Williams topcoat Product Data Sheets or contact your Sherwin-Williams Representative for complete details.

MIXING INSTRUCTIONS

Mix by Volume:

- 3 Part** Aviation Clearcoat
CM0ACC201
- 1 Part** Clearcoat Hardener
CM0ACH201
- 1 Part** Clearcoat Activated Reducer

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

No induction time is required.

Available Activated Reducers (77°F (25°C) 50%RH):

Activator	Sprayable Potlife	Wet Edge	Dry to Tape
Fast Activator CM0ACA207	1.5 Hrs.	20 Mins	3-4 Hrs.
Medium Activator CM0ACA205	4 Hrs.	30 Mins	6-8 Hrs.
Slow Activator CM0ACA203	4 Hrs.	45 Mins	10-12 Hrs.

Fast Repair Options (77°F (25°C) 50%RH)

Accelerator	Activator Combination	Sprayable Potlife	Dry to Tape
CM08181HR	---	10 Mins	20 Mins
CM08181HR 50%	CM0ACA207 50%	20 Mins	40 Mins
CM08181HR 25%	CM0ACA207 75%	25 Mins	1 Hr.
CM08181HR 10%	CM0ACA207 90%	35 Mins	2 Hrs.

APPLICATION

This product can be applied using conventional air spray, HVLP gravity or siphon, electrostatic airspray or air assisted airless (AAA) equipment.

Recommended Fluid Tip Sizes

- Conventional gun Fluid Tips 1.2 to 1.4mm
- HVLP / compliant guns Fluid Tips 1.2 to 1.4mm
- Low Pressure / E-stat guns Fluid Tips 1.0 to 1.2mm
- High pressure AAA / E-stat guns Fluid Tips 60° 11thou

Note: Refer to your specific equipment for optimal air cap pressure.

Accelerator / Repair Application

Quickly apply two or three wet singular or cross coats to full hide allowing a short flash off between coats

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

Body Coat Application (203, 205 & 207):

Apply two or three wet singular or cross coats allowing each coat to flash off.

Desired film build is 2.0 – 2.5 mils (dry)

Note: If a 3rd coat is required mix fresh material for the final coat.

Adjustable Wet Edge Times:

The CM0ACC201 product allows the painter to adjust wet edge times by mixing different reducers. This product can be easily altered to accommodate individual environmental conditions or required dry times.

Factors affecting wet edge include air flow, temperature, humidity, spray equipment, and aircraft size.

Note: Activated reducers should be mixed in 25% increments to achieve desired results.

Example:

Activator Combination	Sprayable Potlife	Wet Edge	Dry to Tape
CM0ACA207 50% + CM0ACA205 50%	2.75 Hours	25 Mins	4.5-6 Hours

DRYING SCHEDULE

All dry times are based on a dry film thickness of 2.0 – 2.5 mils (50 – 64 microns).

Air Drying Schedule:

Once the application is complete, maintain airflow and application conditions for at least 1/3 of the dry to tape time. Ideally, maintain airflow until dry to tape time has been achieved.

Force Drying Schedule:

Before applying heat, maintain the airflow and application condition for at least 1/3 of the products dry to tape time. Force dry the product up to 140°F (60°C) for 30 to 60 minutes once at target temperature.

Dry to tape times will vary due to the activator used and the density of the aircraft components.

Note: One force dry cycle equates to 24hr air dry. Full cure will be achieved at 7 days at 77°F and 50% RH

RE-APPLICATION

Once airdry recoat application time has elapsed, deglaze the gloss thoroughly using one of the following sanding options:

- P320/P600- grit D/A papers.
- Fine grade Wet/dry sandpaper (P400/P600) Wet
- Red Scotchbrite

Cleaning the Sanded Film:

Clean using CM0110158 pre-paint wipe. Cleaner should be wiped off using clean lint free cloths. Replace cloths regularly.

SANDING AND POLISHING

The ACC201 clearcoat will sand and polish throughout its service life.

A typical sanding process:

1. P1500 (wet or dry)
2. P3000 (wet or dry)
3. P5000 or P8000 (wet or dry)
4. Use the abrasive polish selection per shop preferences

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 result.