



Acry Glo® Conventional Basecoat Metallic - Large Area 571 Series (HLG - Colors)

ADVANTAGES

- Cool metallic finish.
- A proven performance coating throughout in the aviation industry.
- Extended wet edge formula
- 2 or 3 singular coat application depending on color.
- Quick drying.
- High resistance to chipping.
- Unlimited metallic colors available.
- May be overcoated with any Sherwin Williams Aerospace Clear coat.

DESCRIPTION

This specially formulated Acry Glo® Metallic has been developed for the large application area where an extended wet edge is required. As with all metallic finishes, correct spray technique, properly adjusted spray equipment, good unimpeded lighting and viewing access is essential to attain even orientation.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	43.0 - 50.0%	40.0 - 46.5%
By volume	33.0 - 40.0%	31.0 - 31.9%
Wt. /Gal.	8.7 - 9.7 lbs.	8.4 - 8.7 lbs.
Sp. Gravity	1.044 - 1.164	1.008 - 1.044

Viscosity-Sprayable

Gardner signature #2 Zahn Cup 14-18 seconds

Admixed V.O.C. (3:½:½)

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 3 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 m²/L

Dry Film Weight

Per dry mil 0.0063-0.0081 lbs./ft.²
Per 25 microns 31-40 g/m²

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 (HLG- colors) Base Component: 3 years
CM0571081: 2 years
CM0110944: 7 years
CM0110099: 7 years
CM0110093: 7 years



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SURFACE PREPARATION

Primed Surface

Acry Glo Metallic™ 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 Corrosion Primer and Sanding Surfacers Product Data Sheets data sheets or contact your Sherwin-Williams Representative for complete details.

Dry Topcoat Surface

For best adhesion onto dry trim colors or repairs, the dry surface should be thoroughly abraded (no gloss) with 240 or 320 grit sandpaper and/or red abrasive pads.

MIXING INSTRUCTIONS

Shake color component for 10-15 minutes before admixing.

Admix by Volume:

3 Parts Acry Glo® Metallic Color
(HLG- Color Numbers)

½ Part Acry Glo® Hardener
CM0571081

Reduce to viscosity

½ part up to 1 Part
CM0110093 Slow Reducer (longest wet edge)
CM0110099 Medium Reducer
CM0110944 Fast Reducer

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

Note: Certain metallic colors may require a ground coat to achieve the final color and effect. This ground coat will be identified on the formula in the Sky Match® color retrieval system and on the label. Contact your Sherwin Williams representative for information and advice when ordering the metallic.

RECOMMENDED EQUIPMENT INFORMATION

This product can be applied using **Typical Fluid Tip Sizes:**

HVLP / compliant guns. Fluid Tips 1.3 or 1.4 mm
E/S air spray with pressure pot Fluid Tips 1.0 to 1.4 mm

Note: AG metallic can be applied with all types of professional spray equipment, including conventional air spray, HVLP Gravity, siphon or pressure; Electrostatic air spray (**turned off**)

Note: Before application commences, ensure that the spray equipment is clean, and is performing properly. Conduct a static horizontally and vertically test on paper adjacent to the AC or component. Poor gun performance and an uneven fan pattern/distribution could affect the metallic orientation.

ACRY GLO BASECOAT APPLICATION

NOTE: This system is designed for application temperatures below 90°F (32°C).

Apply 2 or 3 wet closed film coats allowing a minimum of 30 minutes apart per application to minimize excessive post flow. Be conscious of consistent gun distance and pass overlaps. Take time to apply this material.

For orientation correction, apply a final 45° cross hatch coat increasing the substrate to gun distance.

To ensure that Metallic finish applies evenly without orientation concerns, the refinisher must employ best practice application techniques to include:

- Use spray equipment that is suitable for this type of material finish and is in good working condition, including even fan and pigment distribution.
- Ensure that when multiple painters are applying these materials to large areas they work as a team to ensure that the wet edge is contained and controlled.
- Ensure that the metallic finish has the required number of coats or recommended dry film thickness applied.
- Ensure full opacity has been attained.
- Avoid heavy film applications, flooding and saturating the substrate. This approach may produce picture framing particularly around rivets and lap seams.
- Use well lighted areas that offer an unimpeded visual vantage point for orientation correction at the time of application.

Note: When using e-stat equipment the e-stat function should be switched off.

Sherwin William's cannot accept responsibility for poor metallic orientation, lack of hiding, dryness of film and color repair consistency.

Tip: It is advisable to closely inspect and repair the Metallic at this time.

RECOMMENDED DRY FILM THICKNESS

Apply between 2-3 dry mils (50-75 microns)

Certain colors may require thicker film thickness to achieve full hiding.



METALLIC REPAIR TIPS BEFORE CLEAR COAT

Abrade uniformly using 320-grit D/A papers or higher. Fine grade Wet/dry sandpaper (600+) Red or Gray Scotch brite.

Clean using CM0110158 Basecoat Surface Cleaner (preferred) or CM0110120 Pre-paint Wipe Cleaning Solvent.

Method 1. Dry repair

- Use a small low pressure spray gun
- Apply the metallic color employing an arching technique across the sanded area, feathering the color.
- Ensure that the metallic film is closed and wet
- Ensure full opacity is achieved
- Stand back from the repair and view at all angles, repeat if necessary

Note: Certain colors are best repaired using method 2.

Method 2. Wet bed repair

- Use a small low pressure spray gun
- Apply the metallic color employing an arching technique across the sanded area, feathering the color.
- Ensure that the film is closed and wet.
- Ensure full opacity is achieved
- Allow to flash off for 10 mins
- Mix a small amount of Ready to Spray (RTS) Clear coat, further reduce up to 50% using 110944 solvent.
- Apply a light wet coat of diluted low solids clear coat over and around the color repair
- Allow to flash off several mins
- Apply the final metallic color coat into the wet clear coat to diffuse the repair edge.
- Stand back from the repair and view at all angles.
- Repeat all steps if necessary

A final inspection using a sun gun ensures that the repair color & density matches the original surrounding area.

CLEAR COAT APPLICATION

Acry Glo® Metallic colors **must be** clear coated.

SKYscapes® Clearcoat (CM0850180), SKYscapes® General Aviation Clearcoats (CM0850CC1 and CM0855CC3), Acry Glo Clear (CM0571080), and Acry Glo HS Clear (CM0830080) are all acceptable options depending upon the performance properties needed.

Refer to the applicable Clearcoat Product Data Sheet for mixing and application procedures.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2-4 mils (50-100 microns). @ 77F. 50% RH

Clearcoat Times

Minimum:	4 Hours
Maximum:	24 Hours

Note: Lower temperatures, heavy film thickness, and poor air movement will extend the dry/overcoating time. Abrading metallic basecoats is not recommended; therefore it is imperative that clear coating occurs within the 24hr 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.

