



ADVANTAGES

- Simple mixing ratio
- Eliminates the need for sanding between aged basecoat and clearcoat
- Promotes adhesion between aged SKYscapes® basecoat and freshly sprayed SKYscapes® clearcoat
- Quick overcoat time with Skyscapes Clearcoat
- Improves overall appearance of the basecoat-clearcoat system by:
 - ❖ Enhances clearcoat low film wetting
 - ❖ Improves the clearcoat dry profile
 - ❖ Wets finger marks and tape gum
 - ❖ Assists clearcoat hold up on livery line edges, and picture framing
 - ❖ Wets general surface contamination
- Ideal for small or large aircraft.
- Can be overcoated with itself at any time
- Ideal for use with mica and metallic finish repairs

SKYscapes® Basecoat 2K Adhesion Promoter CM0850AP8

DESCRIPTION

SKYscapes® Basecoat 2K Adhesion Promoter CM0850AP8 is a high performance product designed to be used over dry or aged basecoat over 72 hours old at room temperature, It is used on exterior surfaces of aircraft to extend the basecoat non-sand overcoating window and offers many application advantages to reduce rework.

COATING PROPERTIES

Solids	Sprayable
By weight	30.91%
By volume	25.09%
Density	0.9434 g/ml
V.O.C.	5.43 lbs./gal (652 g/L)
Useable Pot Life at 77°F / 25°C	4 hours
Theoretical Coverage	
4 microns (0.16 mils)	2512 ft. ² / gal
8 microns (0.32 mils)	1256 m ² / L

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

CM0850AP8	3 years
CM0850PH1	2 years
CM0850PR4	7 years
CM0110944:	7 years



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SURFACE PREPARATION

SKYscapes® 2K Adhesion Promoter is designed to be applied over dry or aged basecoat colors that were applied over properly prepared metal and composite substrates.

MIXING INSTRUCTIONS

Mix by Volume:

- 4 Parts** SKYscapes® 2K Adhesion Promoter
CM0850AP8
- 1 Part** SKYscapes® Ad Pro Hardener
CM0850PH1
- 3 Parts** SKYscapes® Ad Pro Reducer
CM0850PR4 – **Medium Temperature**
CM0110944 – **Fast Temperature**

Add the Hardener and Reducer into the Adhesion Promoter Component. Stir in slowly and allow a 15-minute induction time

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

APPLICATION EQUIPMENT

This product can be applied using conventional air spray, HVLP Gravity or siphon; Electrostatic airspray or air assisted airless (AAA)

Typical Fluid Tip Sizes:

- HVLP / compliant guns. Fluid Tips 1.2 to 1.4 mm
- E/S airspray with pressure pot Fluid Tips 1.0 to 1.5 mm
- E/S AAA Fluid Tips 6.11 or 6.13

Apply 1 singular or double track closed film coat .

APPLICATION

Apply one light closed film coat to ensure good flow and leveling

Recommended dry film thickness: 12-25 microns (0.5- 1.0 mils).

DRYING SCHEDULE

Dry times are based on the dry film thickness of **12-25 microns (0.5- 1.0 mils).**

Air Dry Times

	<u>Min.</u>	<u>Max</u>
Dry to clearcoat @ (75°F / 25°C and 50% RH)	1/2 Hour	5 Hours
To lightly sand @ (75°F / 25°C and 50% RH)	4 Hours	

- Fine grade 600+ Wet/dry sandpaper used wet
- Use 600-grit D/A papers.
- Red or Gray scotchbrite

Note: Care should be taken not to sand through the thin adhesion promoter film. Re Apply the adhesion promoter before clearcoat

Force Dry:

Not applicable.

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

EQUIPMENT CLEANUP

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



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

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0850AP8 2K Adhesion Promoter	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0850PH1 Ad Pro Hardener	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
Reducer  CM0850PR4 Medium Temperature OR CM0110944 Fast Temperature	 3 Parts	3 Gal.	3 Qt.	11.4 L	2.9 L

- 3** Allow mix to induct 15 minutes.
- 4** Filter strain and apply.



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