



SKYScapes® Basecoat Repair Additive CM0850RA9

ADVANTAGES

- Designed for quick repair on solid, metallic and mica SKYscapes® basecoat finishes
- Quick drying
- No baking required
- Dries quickly at ambient temperatures
- Easy to mix
- Options available to vary dry and recoat time requirements

DESCRIPTION

SKYscapes® CM0850RA9 basecoat repair additive has been developed to decrease the dry to tape times of the SKYscapes® basecoat for repair. It is designed to be used on exterior surfaces of commercial and general aviation aircraft. This additive when used in conjunction with the SKYscapes® basecoat product line meets the SAE AMS 3095 specification.

COATING PROPERTIES

Solids:	<u>Sprayable</u>
By weight	36.7% - 50.6% depends on color
By volume	28.9% - 35.3% depends on color
Density:	0.94 – 1.11 g/ml depends on color
Viscosity–Sprayable Gardner Signature #2 Zahn Cup	14-18 seconds
Mixed V.O.C.	
U.S. Exempt Solvent (4:1:3:1 to 4 parts)	<3.5 lbs./gal (420 g/L)
Non-Exempt Solvent	<4.5 lbs./gal (535 g/L)
Useable Pot Life At 77°F / 25°C	1-2 Hours depending on additive addition amount.
Theoretical Coverage	
Per dry mil	464-567 ft. ² / gal.
Per 25 microns	11.4-13.9 m ² / L
Dry Film Weight	
Per dry mil	0.0063 – 0.0082 lbs. / ft. ²
Per 25 microns	30.6 – 40.0 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

CM0850RA9: 7 Years



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SURFACE PREPARATION

SKYscapes® Basecoat should be applied to a surface that has been coated with an approved, properly prepared and applied Sherwin-Williams Aerospace Epoxy or Urethane primer systems.

Refer to Sherwin-Williams Corrosion Primer and Sanding Surfacers Product Data Sheets data sheets or contact your Sherwin-Williams Representative for complete details.

MIXING INSTRUCTIONS

Shake color component for 15 minutes before mixing.

Mix by Volume:

- 4 Parts** SKYscapes® Color **850 Series**
(S- or SP-Intermix Solid Color Numbers)
- 1 Part** SKYscapes® Basecoat Hardener **CM0850081**
- 3 Parts** SKYscapes® Basecoat Activator / Reducer **CM0850BR3**

Stir thoroughly.

Add **up to 4 parts** of **CM0850RA9** - Repair additive

Stir thoroughly.

NOTE: Use immediately:

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

EQUIPMENT

This product can be applied using conventional air spray, HVLP Gravity or siphon; Electrostatic airspray

RECOMMENDED FLUID TIP SIZES

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

APPLICATION

Apply multiple coats to full hide.

Recommended dry film thickness is 1.2 – 2.0 mils (30 -50 microns).

NOTE: Some colors may require thicker films to achieve complete hiding

The SKYscapes® Basecoat **must be** recoated with SKYscapes® Clearcoat. Refer to the **CM0850180** SKYscapes® Clearcoat Product Data Sheets for mixing and application procedures.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2.0 mils (50 microns).

Dry to Tape Times Using CM0850RA9

Addition:		Max Non-Sand
1 part Additive Addition	2 Hours	48 Hours
2 parts Additive Addition	1 Hour	24 Hours
3 parts Additive Addition	30 mins	12 Hours
4 parts Additive Addition	15 mins	6 Hours

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

BASECOAT REPAIR

Use one of the following options when it is necessary to re-apply basecoat for repairs:

- Use 320-grit D/A papers or higher.
- Fine grade Wet/dry sandpaper (600+) may also be used
- Red or Gray scotchbrite

To reactivate aged SKYscapes Basecoat without sanding before applying SKYscapes, Clearcoat, apply the SKYscapes® Adhesion Promoter (**CM0850AP8**).

Refer to the **CM0850AP8** Product Data sheet for additional information.

CLEANING PRIOR TO OVERCOATING

Use SW Aerospace **CM0110120** Pre-paint Wipe Cleaning solvent to remove dust or light contamination. Use the wipe on, wipe off technique. Change to clean cloths regularly. Allow CM0110120 to flash off for a minimum of 15 minutes before re-applying basecoat or clearcoat.

EQUIPMENT CLEANUP

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






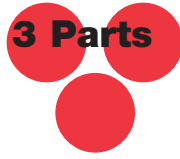


PRODUCT INFORMATION

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.



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- 1** Shake the CM0850XXX – Factory packed colors or SXXXXX Intermix colors for 15 minutes before mixing.
- 2** Add in order shown below. The Hardener and Activated Reducer should be mixed into the clear component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0850XXX or SXXXXX Color	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0850081 Basecoat Hardener	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0850BR3 Activated Reducer	 3 Parts	3 Gal.	3 Qt.	11.4 L	2.9 L
 CM0850RA9 Select amount from chart below based on dry-to-tape and recoat requirements.	 1-4 Parts	1-4 Gal.	1-4 Qt.	3.8 - 15.2 L	.95 - 3.8 L

- 3** Dry to Tape Times Using CM0850RA9

Addition Level:	<u>DTT Max</u>	<u>Non-Sand</u>
1 part Additive Addition	2 Hours	48 Hours
2 parts Additive Addition	1 Hour	24 Hours
3 parts Additive Addition	30 mins	12 Hours
4 parts Additive Addition	15 mins	6 Hours

- 4** Use mix immediately.
- 5** Filter strain and apply.

