



SKYscapes[®] General Aviation Clearcoat CM0855CC3

ADVANTAGES

- High gloss, extremely durable product
- Exhibits outstanding gloss and gloss retention upon weathering.
- Good extended buffing characteristics
- Ability to extend wet edge for a controlled application in hot environment or large areas
- Designed to work over Sherwin-Williams 850 SKYscapes[®] or SKYscapes 855 series General Aviation Clearcoat basecoat systems
- Can also be used over Acry Glo[®] Conventional and Acry Glo[®] High Solids metallic colors.
- Excellent Distinctness of Image (DOI).
- Contains less than 3.5 lbs. of VOC per mixed gallon.
- Free of lead and chromate hazards.

DESCRIPTION

SKYscapes[®] General Aviation Clearcoat is a high performance, acrylic urethane system designed for use on aircraft. This product is intended for clear coating **SKYscapes[®]** (850 Series) and **SKYscapes[®] General Aviation** (855 Series) base coat colors. Three activators are available to accommodate variable environmental conditions and aircraft type/size.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	62%	42.0%
By volume	54%	37.2%
Wt./Gal.	8.31 lbs/gal.	8.7 lb./gal.
Sp. Gravity	0.996	1.04

Viscosity–Sprayable

Mixed 3:1:2 16-18 seconds (Zahn #2)

Admixed V.O.C. (3:1:2)

U.S. Exempt Solvent <3.5lbs./gal (420g/L)

Useable Pot Life

at 77°F / 25°C 3 hours

Theoretical Coverage

Per dry mil 596.2 ft.² / gal.
Per 25 microns 14.63 m² / L

Dry Film Weight

Per dry mil 0.0061 lbs. / ft.²
Per 25 microns 29.6 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

CM0855CC3:	3 years
CM0855CH3	2 years
CM0855CR4:	2 years
CM0855CR6:	2 years
CM0855CR8:	2 years



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SUITABLE BASECOAT FINISHES

SKYscapes® CM0855CC3 **General Aviation** Clearcoat can be applied over Sherwin-Williams Aerospace **SKYscapes®** 850 or 855 series finishes or **Acry Glo®** or **Acry Glo®** metallic finishes.

Refer to the appropriate PDS sheet for recommended basecoat overcoating times.

MIXING INSTRUCTIONS

NOTE: ° **CM0855CC3 Clear Component should be thoroughly mechanically shaken to condition the base before admixing.**

Pre-shake for 5-10 minutes on a mechanical paint shaker before admixing.

Admix by Volume:

- | | |
|----------------|--|
| 3 Parts | SKYscapes® General Aviation Clearcoat
CM0855CC3 |
| 1 Part | SKYscapes® General Aviation Clearcoat Hardener
CM0855CH3 |
| 2 Parts | SKYscapes® General Aviation Clearcoat Activated Reducer
CM0855CR4 - Slow
CM0855CR6 - Standard
CM0855CR8 - Fast |

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

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
4. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
5. Best application results are obtained by applying two medium wet coats, allowing a 5-10 minute "tack-off" period between coats.
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.

NOTE: Once the CM0855CC3 Clearcoat is dry to tape, it must be suitably sanded to deglaze the surface before re-application to ensure a suitable mechanical key.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2-3 mils (50-75 microns).@ (75°F / 25°C and 50% RH)

Typical Air Dry Times:

- CM0855CR4 - 15 hours
- CM0855CR6 - 7.5 hours
- CM0855CR8 - 3.5 hours

NOTE: Lower temperatures, heavy film thickness, improper activator range selection, poor air movement, equipment type and settings could affect wet edge & dry times.

ACTIVATOR SELECTOR:

(75°F / 25°C and 50% RH)

- CM0855CR4 - Overall repaints. Offers a 40-45 min wet edge.
- CM0855CR6 - Overall repaints. Offers a 20/30 min wet edge.
- CM0855CR8 – Repairs and small areas. Offers a 10-15 min wet edge.

EQUIPMENT CLEANUP

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

PRODUCT INFORMATION

Please contact your Sherwin-Williams Aerospace Distributor or Representative for more 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.

