



SKYscapes® Shimmer Basecoat

850 Series (SH Colors)

ADVANTAGES

- Uses translucent pearl / mica pigments to achieve special effect colors for aircraft
- Converts solid colors into an effect coating using one application process
- Provides a simple process to add effect colors to a multi-color design
- Quick drying
- Two double track coat application
- No baking required
- Dries quickly at ambient temperatures
- No need to sand between coats
- Easy to mix
- Excellent leveling
- Long pot life
- Repairable
- Designed to work with Sherwin Williams SKYscapes® Basecoat clear coat system.

DESCRIPTION

SKYscapes® Shimmer coats have been developed to enhance color space and offers a new dimension to effect coatings. This material is coat effective, and will convert any solid color basecoat into an esthetically pleasing effect finish, without losing the clean vibrancy of the color itself. This material is fully repairable and is designed for all commercial and general aviation aircraft. SKYscapes® Shimmer coat technology delivers a consistent, durable finish. This coating is used as part of a SAE AMS 3095 qualified system.

COATING PROPERTIES

Solids:	<u>Spray able</u>
By weight	33.6%
By volume	26.6%
Density:	0.91
Viscosity–Spray able	
Gardner Signature #2 Zahn Cup	15-17 seconds
Mixed V.O.C.	
U.S. Exempt Solvent	4.22 lbs./gal (506 g/L)
Non-Exempt Solvent	5.05 lbs./gal (606 g/L)
Useable Pot Life	
At 77°F / 25°C	3 Hours
Theoretical Coverage	
Per dry mil	427 ft. ² / gal.
Per 25 microns	10.5 m ² / L
Dry Film Weight	
Per dry mil	0.006 lbs. / ft. ²
Per 25 microns	29.3 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

SH-series Shimmer Coats: 3 years
CM0850081: 2 years
CM0850BR0: 7 years
CM0850BR1: 7 years



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MIXING INSTRUCTIONS

Thoroughly agitate the base component for 5-10 minutes before admixing. After agitation, please check for settling.

Mix by Volume:

- 5 Parts** SKYscapes® Shimmer coat
SH200401 – Silver
SH200415 – Multi-Color (Prismatic)
- 1 Part** SKYscapes® Basecoat Hardener
CM0850081
OR
SKYscapes® Next Gen Basecoat Hardener
CM0850BH2
- 3 Parts** SKYscapes® Basecoat Activated Reducers
(Select from options below. Both can be used
For ground and mica coats.)
CM0850BR0 – Extra Slow.
CM0850BR1 – Slow. (Suitable for most
applications)

Reducer Selection options:

- **CM0850BR0:** Use in hot, humid conditions for full repaint for wide bodied commercial aircraft or application process times that are slow per coat.
- **CM0850BR1:** Use in ambient conditions for full repaint for narrow and wide bodied commercial aircraft or application process times that are fast per coat, requiring a minimal wet edge.

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

IMPORTANT: Shimmer basecoat requires constant stirring or agitation.

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
E/S AAA	Fluid Tips 6.11 or 6.13

Note: SKYscapes® Shimmer coat can be applied with all types of professional spray equipment, including conventional air spray, HVLP Gravity, siphon or pressure; Electrostatic air spray or air assisted airless (AAA).

Before application commences, ensure that the spray equipment is clean, and is performing properly. Always ensure that the fan pattern is even by conducting a static horizontally and vertically test on paper adjacent to the AC or component. Poor gun performance and an uneven fan pattern/distribution could effect mica orientation.

THREE-STAGE APPLICATION INSTRUCTIONS

1- SOLID COLOR APPLICATION

The solid coat's main function in a basecoat system is to establish an opaque color foundation. Refer to the 850 Series SKYscapes® Basecoat Product Data Sheet for full details on mixing and application.

During application, be sure to apply light wet closed film coats and minimize any post flow. One cross coat is typically required, although certain solid vibrant colors may require additional coats to achieve full opacity. Avoid heavy film applications, flooding and saturating the substrate. This may produce picture framing, pigment flooding and flotation, which could influence the final color and shade of the full scheme once complete.

Full opacity and an even color of this layer is very important for the mid coat layers orientation and final effect.

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

Tip: It is advisable to closely inspect and spot repair the solid color at this time

2- SHIMMER COAT APPLICATION

The shimmer coat material is **TRANSPARENT** and its function is to establish an even mica effect.

Apply two wet, closed film, double track coats allowing a minimum of 15 minutes apart per application to minimize any post flow. Be conscious of consistent gun distance and pass overlaps. Take the appropriate time to apply this material.

Recommended dry film thickness is 1.5 – 2.0 mils (37 -50 microns).

Avoid heavy film applications, flooding and saturating the substrate. This approach may produce picture framing particularly around rivets and lap seams.

Tip: It is advisable to closely inspect and spot repair the Shimmer coat at this time

3- CLEAR COAT APPLICATION

SKYscapes® Shimmer coat **must be** clear coated.

SKYscapes® Clearcoat (CM0850180), SKYscapes® General Aviation Clearcoats (CM0850CC1 or 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.



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DRYING SCHEDULE

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

Air Dry Times (75°F / 25°C and 50% RH)	<u>Min</u>	<u>Max</u>
850BR1 Dry to tape	2 Hrs. +	24 Hrs.
To lightly sand	4+ Hrs.	
To apply Clear coat*	2+ Hrs.	

Air Dry Times (> 95°F / 35°C and 80% RH+)	<u>Min</u>	<u>Max</u>
850BR0 Dry to tape	4 Hrs. +	24 Hrs.
To lightly sand	5+ Hrs.	
To apply Clear coat*	2+ Hrs.	

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

SHIMMER REWORK - NO BASE COLOR REQUIRED

1. Use 320-grit D/A papers or higher. Fine grade Wet/dry sandpaper (600+) Red or Gray scotchbrite (abrade uniformly)
2. Clean using CM0110158 Basecoat Surface Cleaner (preferred) or CM0110120 Pre-paint Wipe Cleaning Solvent
3. Use a low pressure gravity or siphon gun, employ an arching technique across the sanded area this ensures that the film is feathered into the non sanded Shimmer coat. Ensure that the film is closed and wet.
4. Inspection using a sun gun ensures that the repair density matches the original surrounding area.

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3. Use a low pressure gravity or siphon gun, use an arching technique across the sanded area into the
4. Non sanded area, ensure that the solid color film is opaque.
5. Allow a 15 min flash off
6. Use a low pressure gravity or siphon gun, employ an arching technique across the sanded area this ensures that the film is feathered into the non sanded Shimmer coat. Ensure that the film is closed and wet.
7. Inspection using a sun gun ensures that the repair density matches the original surrounding area.

SHIMMER COAT PREPARATION PRIOR TO CLEAR COATING

Prep 1. For paint schemes where the area has not been touched and is perfectly clean (no tape gum or fingermarks), and **is under the 24 hours non-scuff dry time**, tack thoroughly and apply clear coat directly. No pre-paint wiping is necessary.

Prep 2: When multiple colors or an elaborate scheme has been applied (requiring multiple handling and/or back masking), remove any light contamination (such as tape gum and fingermarks) with CM0110158 Basecoat Surface Cleaner (preferred) or CM0110120 Pre-paint Wipe Cleaning Solvent. Use the wipe on, wipe off technique changing cloths regularly. Allow these materials to flash off for a minimum of 15 minutes before applying clear coat.

Note: For a Shimmer coat less than 12 hours old, **test** the pre-paint wipe cleaning solvents for sensitivity on a low light area before general cleaning of all areas.

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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