



SKYscapes® General Aviation Basecoat Colors

855 Series – SG, SGE, SGM and SGP Colors

ADVANTAGES

- Quick drying. Allows for multiple color livery applications per day
- Perfect for small general aviation aircraft and helicopters where expedited production times are required
- Available in a solid, mica or metallic finish.
- One double track coat application for most colors
- No baking required
- Dries quickly at ambient temperatures
- Apply additional colors without mechanically sanding
- Excellent opacity at low film thickness
- Excellent flow and leveling
- Long pot life
- Easy to keep clean and maintain

DESCRIPTION

SKYscapes® General Aviation (GA) Basecoat polyester urethane is a Sherwin-Williams topcoat that is applied using a basecoat-clearcoat process. It is designed to be used on exterior surfaces of general aviation aircraft and helicopters. SKYscapes® GA basecoat delivers a consistent, durable and colorful solid, mica or metallic finish.

COATING PROPERTIES

Solids:	Sprayable
By weight	22.3% - 25.5% depends on color
By volume	22.5% - 24.5% depends on color
Density:	1.15 – 1.35 g/ml depends on color
Viscosity–Sprayable	16-20 seconds
Gardner Signature #2 Zahn Cup	
Mixed V.O.C.	
U.S. Exempt Solvent	<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	6 Hours
Theoretical Coverage	
Per dry mil	350-375 ft. ² / gal.
Per 25 microns	8.59-9.20 m ² / L
Dry Film Weight	
Per dry mil	0.0060 – 0.0083 lbs. / ft. ²
Per 25 microns	29.5 - 41 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

855 Series – SG, SGE, SGM and SGP Colors:	2 years
CM0855GH3 Hardener:	2 years
CM0855GR1 Slow Reducer	7 years
CM0850GR5 Standard Reducer:	7 years
CM0855GR9 Repair Reducer	2 years

SURFACE PREPARATION

SKYscapes® General Aviation Basecoats 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 Surfacer 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:

- 6 Parts** SKYscapes® General Aviation Color
SG, SGE, SGM and SGP Colors
- 1 Part** SKYscapes® General Aviation Hardener
CM0855GH3
- 2 Parts** SKYscapes® General Aviation Reducer
CM0855GR1 – Slow Reducer*
CM0850GR5 – Standard Reducer
CM0855GR9 – Repair Reducer

* The CM0855GR1 Reducer can be used in high temperatures (90°F/32°C and up) or for larger area application. Use of the CM0855GR1 Slow Reducer may cause the mixed VOC to exceed 3.5 lb/gal (420 g/L).

Add the Hardener and Reducer into the color component. Stir in slowly.

If CM0855GR9 Reducer is unavailable, add up to add up to 3 oz CM0818A97 Standard Accelerator per sprayable gallon for repairs.

CM0110512 Blending Solvent can be used in a 2-gun method or to over reduce the basecoat to feather a blended edge.

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

APPLICATION

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 1.3-1.6 mm
Conventional Pressure Feed	Fluid Tips 1.0-1.2mm @ 8-10 oz/min
E/S airspray with pressure pot	Fluid Tips 1.0 to 1.4 mm
E/S AAA	Fluid Tips 6.11 or 6.13

1. Adjust air pressure at the gun to 55 psi for siphon, gravity or pressure feed (adjust pot pressure to 5-10 psi for 10-14 fluid ounces per minute delivery).
2. Apply basecoat in medium coats at a gun distance of 8-10 inches. Allow each coat to become hand slick before applying the next coat. Spray to hiding only. (For Metallic Colors: low pressure finesse coat.)

3. Clean spray gun immediately after use with a quality lacquer thinner.
4. Allow at least 30 minutes flash before clearcoating; cooler temperatures will extend the clearcoat recoat time.

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

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

All SKYscapes® General Aviation Basecoat colors **must be** recoated with SKYscapes® Clearcoat. Refer to the CM0850CC1 or 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).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min</u>	<u>Max</u>
Tack Free	10-20 Minutes	
Dry to tape	60-90 Minutes	
To apply Clearcoat	30-60 Minutes	96 Hrs

Force Dry Times

Dry to Tape (120 F)	30 Minutes
Dry to Tape (140 F)	20 Minutes

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

PREPARING BASECOAT FOR REAPPLICATION

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

BASECOAT PREPARATION PRIOR TO OVERCOATING

Use CM0110158 Basecoat Surface Cleaner or 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 Reducer. 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.