



High Solids Epoxy Sanding Surfacer

CM0480920

ADVANTAGES

- Product forms tough films with excellent recoat / intercoat adhesion properties.
- Excellent sanding process characteristics.
- Designed for light sanding on the same day or heavier sanding overnight.
- Less than 2.9 lbs./gallon (350 g/L) of VOC without use of exempt solvents.
- Reduces process time for basecoat preparation.

DESCRIPTION

CM0480920 is a high solids epoxy surfacer intended for use on aircraft and other aerospace applications over Sherwin-Williams corrosion protective primers. It is used to fill and cover surface imperfections to create a smooth surface for topcoat application.

COATING PROPERTIES

Solids:	Base Component
By weight	71.6 ± 1.0%
By volume	49.5 ± 1.3%
Wt./Gal.	11.9 ± 0.2 lbs.
Sp. Gravity	1.43 ± 0.02
Color	White
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	19-24 seconds
ISO 2431 3mm Cup –Sheen	
Admixed V.O.C.	
(Mixed 4:1: to viscosity)	
U.S. Exempt Solvent 110944	<2.9 lbs./gal. (350 g/L)
Non-Exempt Solvent 110093	<3.8 lbs./gal. (455 g/L)
Useable Pot Life	
at 77°F / 25°C	2 Hours
Theoretical Coverage	
Per dry mil	610 to 735 ft.2 / gal.
Per 25 microns	15 to 18 m ² / L
Dry Film Weight	
Per dry mil	0.0100 lbs. / ft. ²
Per 25 microns	48.9 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

CM0480920: 2 years
 CM0120911: 2 years
 CM0110093 7 years
 CM0110944 7 years

SURFACE PREPARATION

Surface should be dry and free of oil, dust, or overspray. For maximum adhesion and corrosion resistance, apply over a chromate or chrome free corrosion resistant primer such as CM0483928, CM0483505 or CM0481968

The CM0480920 should be applied over the selected corrosion preventative primer within 12 hours of the primer application at 77°F (25°C). If overnight cured (>16 hours), a light scuff sanding or Scotchbriting is recommended.

NOTE: Do not use this product as a filler Surfacer to cover marginally prepared composite/fiberglass or polyester filler bondtite area. Address these appearance items by reviewing the cured corrosion protective primer and assuring satisfactory smoothness before applying CM0480920.

MIXING INSTRUCTIONS

Shake primer component for 10-15 minutes before admixing.

Admix by Volume:

4 Parts	Epoxy Primer Component CM0480920
1 Part	Epoxy Surfacer Adduct CM0120911

Add the Adduct into the Primer Component.

Admixed product should be allowed a 15-minute induction time for optimum application performance.

Add the required volume (up to a maximum of 1 part) of CM0110093 or CM0110944 Reducer to reach desired viscosity. For best results on large surfaces, hot conditions >80°F/27°C, or thicker films, the CM0110093 is recommended. This additional reduction may change the application VOC to greater than 2.9 lbs./gal. (350 g/L) depending on the legislation in your area.

It is recommended to filter strain admixed and reduced primer 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. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
2. Make sure pots, guns, and lines are purged and cleaned.
3. This product has a short pot life. Mix material for the second coat during the solvent flash time if surfacing a large aircraft.
4. Mix thoroughly and filter strain before spray applying.
5. Spray atomizing pressure: 40-50 psi (2.75 -3.45 bar)
Pot pressure: 8-12 psi (0.55 – 0.83 bar) using a 60' fluid hose (3/8" diameter)

Delivery Rate: 8-10 fluid oz (236-295 mL) per minute

6. Best spray application results are obtained by applying two or three smooth medium-wet coats. There should be a 30-45 minute flash off time between coats.
7. Recommended film thickness is:
Wet: 4–6 mils (15-23 microns)
Dry: 2-3 mils (50-75 microns)

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.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2-3 mils (50-75 microns).

Air Dry Times (75°F / 25°C and 50% RH)	<u>Min.</u>
To Lightly Sand (thickness dependant)	4 to 6 Hours
To DA (orbital) Sand	Overnight

Force Dry: (120°F (49°C), 50% RH)	<u>Min.</u>
To DA (orbital) Sand	4 Hours

NOTE: Lower temperatures, heavy film thickness, improper activator range selection and poor air movement will extend the dry time.

SANDING RECOMMENDATIONS

Mechanical DA (orbital) sanding or hand sanding of this product works well with 220, 240 or 340 grit sandpaper. Proper sanding is the key to good intercoat adhesion and a smooth appearing surface.

If the cured epoxy primer is inadvertently sanded through, a corrosion primer spot repair will be required prior to spraying topcoat.

EQUIPMENT CLEANUP


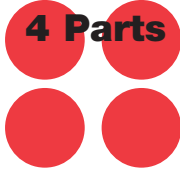


Flush and clean fluid material hose and paint guns as soon as possible after spraying is complete. Use clean Ketone-type solvents such as CM0110308 MEK. Do not allow material to cure inside equipment.

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.

High Solids Epoxy Sanding Surfacers CM0480920

- 1** Shake the CM0480920 for 10-15 minutes before admixing.
- 2** Add in order shown below. The Adduct should be mixed into the primer component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0480920 Primer	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0120911 Epoxy Adduct	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Allow admix to induct 15 minutes.

- 4** Add the required volume (up to a maximum of 1 part) of **CM0110093** or **CM0110944 Reducer** to reach desired viscosity. For best results on large surfaces, hot conditions 80°F/27°C, or thicker films, the **CM0110093** is recommended. This additional reduction may change the application VOC to greater than 2.9 lbs./gal. (350 g/L) depending on the legislation in your area.

 CM0110944 US Exempt Reducer	 1 Part	1/2 - 1 Gal.	1/2 - 1 Qt.	1.9 - 3.8 L	.48 - .95 L
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- 5** Filter strain and apply.