



High Solids Corrosion Resistant Epoxy Primer

CM0483928

ADVANTAGES

- Qualified to SAE AMS3095.
- Designed to work with Sherwin-Williams sanding surfacers and topcoat systems.
- Excellent corrosion and chemical resistance.
- Designed to meet the performance criteria set forth in BMS 10-72; MIL-P-23377, Type 1, Class C; and several other commercial and OEM specifications.
- High square coverage per gallon.
- Contains less than 2.9 lbs. of VOC per mixed gallon or 350 grams per liter.
- A proven performer that has been used in the field for several years.
- Excellent topcoat gloss hold out

DESCRIPTION

CM0483928 is a high performance, high solids, low VOC, two-component, green corrosion inhibitive epoxy primer. This high performance Epoxy primer is intended for use on all types of aircraft and has excellent recoat/intercoat adhesion with Sherwin-Williams topcoat systems.

COATING PROPERTIES

Solids:	<u>Base Component</u>
By weight	73.0 ± 1.0%
By volume	48.8 ± 0.8%
Wt./Gal.	12.8 ± 0.2 lbs.
Sp. Gravity	1.53 ± 0.02
Color	Yellow / Green

Viscosity–Sprayable

Gardner Signature #2 Zahn Cup	18-22 seconds
ISO 2431 3mm Cup –Sheen	45-65 seconds

Admixed V.O.C. (Mixed 4:1:20%)

<2.9 lbs./gal. (350 g/L)*

* If CM0110944 is used, it is a US exempt solvent. If used in other countries, it may increase the VOC beyond this level.

Useable Pot Life

at 77°F / 25°C	4 Hours
at 95°F / 35°C	2 Hours

Theoretical Coverage

Per dry mil	740 ft.2 / gal.
Per 25 microns	18.1 m ² / L

Dry Film Weight

Per dry mil	0.0110 lbs. / ft. ²
Per 25 microns	54 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

CM0483928:	2 years
CM0120828:	2 years
CM0110944	7 years

Aerosol Touch –up Kits: 1 year
Cool, Dry Storage Required.

SURFACE PREPARATION

To insure proper primer adhesion to the substrate, all contaminants must be removed. Depending on the type of substrate to be prepared, different methods should be used. There are a variety of processes to prepare these substrates for primer and painting.

Sherwin-Williams primers are designed to go over various treatments (i.e., alclad or anodized aluminum, composite, fiberglass, magnesium, and stainless steel). Please refer to recommendations for cleaning, application, and preparation before painting to the manufacturer of the treatment.

If a wash primer is needed, please refer to the Product Data Sheet for CM0484684 Wash Primer.

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

- 4 Parts** Epoxy Primer
CM0483928
- 1 Part** Epoxy Adduct
CM0120828

Add the Adduct into the Primer Component.

Admixed product should be allowed a 30-minute induction time for optimum application performance.

Reduce to sprayable viscosity using up to a maximum of 20% with CM0110944 Reducer.

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

APPLICATION

This product can be applied using conventional air spray, HVLP, Graco electrostatic airspray, or air assisted airless. Please consult your Sherwin-Williams representative for specific equipment settings.

Electrostatic users: Ensure that the aircraft is properly grounded for potential static buildup.

Equipment settings:

Conventional air spray:

- Air cap 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

Best spray application results are obtained by applying one light continuous closed film cross coat

Recommended dry film thickness is 0.6 – 0.9 mils (15-23 microns).

Surfacer primer can be applied after a MINIMUM two-hour cure to allow time for solvent flash-off. Thicker mil films or cooler conditions will extend the solvent flash time. Please refer to the Product Data Sheets CM0480920 Epoxy Surfacer or CM0481810 Urethane Surfacer for more details.

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 0.6-0.9 mils (15-23 microns).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To apply topcoat	2 Hours	72 Hours*
Tack free	5 Hours	
Dry Hard	8 Hours	

<u>Force Dry:</u> (140°F (60°C), 45% RH)	<u>Min.</u>
To apply topcoat	1 Hour

* If an intermediate primer or topcoat is not applied within 72 hours of primer application, light scuff sanding using P240,P320 paper &/or red abrasive pad will be required for good intercoat adhesion.

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

EQUIPMENT CLEANUP


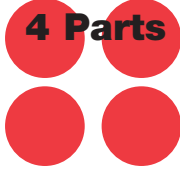


Use clean Ketone–type solvents such as CM0110308 MEK. Do not allow material to cure inside equipment.

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 Corrosion Resistant Epoxy Primer CM0483928

- 1 Shake the CM0483928 for 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
 CM0483928 Primer	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0120828 Epoxy Adduct	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3 Allow admix to induct 30 minutes.
- 4 The admixed primer can be sprayed without further reduction. The product is generally reduced by 20% with CM0110944 US Exempt Reducer.

 CM0110944 US Exempt Reducer	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
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- 5 Filter strain and apply.

CM0483928

Rolling Procedure

If the product needs to be applied in an area with a roller, please use the following process.

- 1** Shake the Base component for 10-15 minutes before admixing.
- 2** Add in order shown below. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0483928 Chromated Primer	 4 Parts	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0120828 Epoxy Adduct	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0110944 US Exempt Reducer	 1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Allow admix to induct 15 minutes. (Viscosity check not required.)
- 4** Filter strain and apply one single cross roller coat to achieve full opacity, flow and finish.

Note: CM0483928 must be applied over suitably prepared surfaces i.e., sanded Urethane, pretreated Aluminum, sanded composites / plastics.
- 5** 0.6 to 1.2 mils DFT required.
- 6** Recommended roller type: 4-inch high-density disposable foam roller.