



Epoxy Fill Primer

CM0482300

ADVANTAGES

- Designed to be used as a surfacer/filler for composite materials and fiberglass parts or as an intermediate primer where high fill properties are needed.
- When properly applied and sanded, a smooth, flexible film is achieved for added gloss to the topcoat.
- An excellent coating for radome fixture parts.
- Designed to work with Sherwin-Williams sanding surfacers and topcoat systems.

DESCRIPTION

CM0482300 is a specialty, epoxy polyamide sanding surfacer designed specifically as an intermediate primer to be used on composite materials and fiberglass under Sherwin-Williams topcoat systems.

COATING PROPERTIES

Solids:	Base Component
By weight	62.4 ± 2.0%
By volume	42.4 ± 2.0%
Wt./Gal.	11.0 ± 0.2 lbs.
Sp. Gravity	1.32 ± 0.02
Color	Light Blue
Gloss	Matte
Viscosity—Sprayable	
Gardner Signature #2 Zahn Cup	15-19 seconds
ISO 2431 3mm Cup —Sheen	45-65 seconds
Admixed V.O.C. (Mixed 1:1)	
U.S. Exempt Solvent	5.1 lbs./gal. (617 g/L)
Non-Exempt Solvent	5.1 lbs./gal. (617 g/L)
Useable Pot Life	
at 77°F / 25°C	6 Hours
Theoretical Coverage	
Per dry mil	451 ft. ² / gal.
Per 25 microns	11.1 m ² / L
Dry Film Weight	
Per dry mil	0.0089 lbs. / ft. ²
Per 25 microns	43.7 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

CM0482300:	2 years	CM0110588	7 years
CM0120900:	2 years	CM0702901	7 years
CM0140968	2 years		

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

SURFACE PREPARATION

Composite materials and fiberglass parts should be dry and free of oil, dust, or overspray.

Sherwin-Williams primers are designed to go over various substrate treatments. Before painting, please refer to the recommendations for cleaning, application, and preparation to the manufacturer of the treatment.

Added adhesion properties may be attained by light scuff sanding the surface to be filled. Care must be taken to not breakthrough the protective substrate of the composite or fiberglass material.

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

1 Part Epoxy Primer
CM0482300

1 Part Epoxy Adduct
CM0120900

Add the Epoxy Adduct into the Primer Component. Stir in slowly and allow a 15-minute induction time

If further reduction is needed, reduce up to 25% by volume with CM0110588 Slow Reducer or CM0702901 Fast Reducer.

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, 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

Apply in two or three light coats. Allow each coat to flash off until dull before applying the next coat.

Recommended film thickness is:

Wet: 3-5 mils (75-125 microns)

Dry: 1-1.5 mils (25-38 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 1.0 – 1.5 mils (25-38 microns).

Air Dry Times (75°F / 25°C, 50% RH)

To Light Sand (220, 240 or 320 grit)

To apply topcoat

Min.

4 Hours

4 Hours

Max.

24 Hours

24 Hours

Force Dry: (140°F / 60°C, 45% RH)

To Light Sand (220, 240 or 340 grit)

Min.

30 Minutes

If topcoat or additional primer is not applied within 24 hours of primer application, light scuff sanding will be required for good adhesion.

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

GUIDECOAT COLORANT TO ASSIST IN SANDING (OPTIONAL)

To create color contrast when sanding, add up to 0.5 fl. oz. of CM0140968 Surfacer Colorant per gallon of CM0482300 Primer base. Add the colorant to the base prior to admixing. Post adding the colorant to existing mixed material is also acceptable.

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.

Epoxy Fill Primer

Light Blue

CM0482300

- 1** Shake the CM0482300 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
	CM0482300 Primer	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
	 CM0120900 Epoxy Adduct	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Allow admix to induct 15 minutes.
- 4** If further reduction is needed, reduce up to 25% by volume with CM0110588 Slow Reducer or CM0702901 Fast Reducer.
- 5** No accelerator additives are to be used in epoxy primers or surfacers.
- 6** Filter strain and apply.