



SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Spread n' Spray Spot Primer CM0480922

ADVANTAGES

- One product can be spread for fill in areas or sprayed for larger areas.
- Free of lead, chromate, and isocyanates.
- Spreadable mix minimizes prep work and is ideal for filling rivets and seams.
- Versatility for spray application as well for larger areas or spot repairs.
- Excellent adhesion properties to many substrates and treatments.
- Excellent gloss holdout and sanding characteristics.

DESCRIPTION

Spread n' Spray Spot Primer is a high build Filler that can be applied by spraying or spreading. This primer provides excellent adhesion and is chrome, lead, and isocyanate free. With the ability to apply as a Primer that can be spread, it eliminates the need to mask, tape and spray. This capability will greatly decrease prep time and cleanup on smaller repair areas. For larger areas, CM0480922 can also be spray applied.

COATING PROPERTIES

Admixed V.O.C.	Spread	Spray
U.S. Exempt Solvent	<2.3 lbs./gal.(274 g/L)	<2.3 lbs./gal.(274 g/L)
Non-Exempt Solvent	<2.5 lbs./gal.(300 g/L)	<3.6 lbs./gal.(430 g/L)
Color:	Light Gray	
Workable Pot Life	1 hour	
At <90°F / 32°C, ≤ 50% R.H.		
Recommended min. dry film thickness	Film Builds After Sanding 2.0 – 6.0 mils (50 to 150 microns)	
Theoretical Coverage	Spread	Spray
Per dry mil	1000-1040 ft. ² /gal./mil.	780-800ft. ² /gal./mil.
Per 25 microns	24.5-25.5m ² /L	19.1-19.6 m ² /L
Dry Film Weight		
Per dry mil	0.010 lbs. / ft. ²	
Per 25 microns	48.1 grams / 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

CM0480922	3 years
CM0120722	7 years
CM0110722	7 years

MIXING INSTRUCTIONS

Shake base 15 minutes and then stir by hand before admixing.

Spread Application

Admix by Volume:

4 Parts	Spread n' Spray Spot Primer Base CM0480922
1 Part	Primer Adduct CM0120722

Spray Application

Admix by Volume:

4 Parts	Spread n' Spray Spot Primer Base CM0480922
1-2 Parts	Sprayable Primer Reducer CM0110722
1 Part	Primer Adduct CM0120722

Admixed product should be allowed a 10-minute induction time for optimum application performance.

SURFACE PREPARATION

Bare Metal

Thoroughly clean with alkaline soap solution and rinse with deionized water. Solvent-wipe and wipe dry with a clean, dry, lint-free cloth.

Prepainted Surface

1. Wash surface with alkaline soap solution. Rinse well with deionized water and wipe dry with a clean, dry, lint-free cloth.
2. Solvent-wipe and wipe dry with a clean, dry, lint-free cloth.
3. Sand repair area and featheredge using 80, 180, 280, 310 and finish with 400 grit sandpaper.
4. Air blow with clean cotton lint-free cloths and tack cloth wipe with a urethane grade tack cloth. Area does not need to be wiped with a damp solvent rag unless the sanded surface has been contaminated.

APPLICATION

Spread Application

1. Spread n' Spray Primer is applied using a plastic body filler/putty spreader or squeegee applicator.
2. Apply first coat by spreading the primer over the repair area in one direction. Apply in a thin uniform coat, tapering the material past the repair area into the properly sanded and featheredged panel.
3. Allow a 5-minute flash time after the first pass. Apply second coat in a cross coat direction from the first coat. Taper the material beyond the repair area into the properly sanded and featheredged panel.

Spray Application

This product can be applied using conventional air spray equipment or HVLP.

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: 35-45 psi (2.4 -3.1 bar); 6-9 psi air cap pressure for HVLP.
6. Best spray application results are obtained by applying two or three smooth full wet coats at a gun distance of 5" to 7". Allow each coat to flash dull between coats.
7. Do not back spray over an area if a spot is missed. Cover the area with the second coat after proper flash time.

DRYING SCHEDULE

Air Dry Times

(70°F / 21°C and 50% Relative Humidity)
Unaccelerated 2-3 hours

Force Dry Times

(140°F / 60°C)
Unaccelerated 20-30 minutes

NOTE: Lower temperatures, heavy film thickness, 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 primer is inadvertently sanded through, a spot repair will be required prior to spraying topcoat.

Maximum recoat time after sanding: Up to 7 days. After 7 days, solvent clean the area and re-scuff sand.

EQUIPMENT CLEANUP

Use clean Ketone-type solvents such as CM0110308 MEK.