SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Aerospace Wash Primer

CM0484646

ADVANTAGES

- Qualified to SAE AMS 3095 system specification.
- Designed to work with CM0486606 Urethane Corrosion Primer and CM0486707 Chrome Hazard Free Urethane Primer.
- The mixed primer provides a corrosion resistant film for aluminum.
- Simple, two-component mixing.

DESCRIPTION

This product is a two-component chromated Wash Primer that is designed for pretreatment of aluminum. Wash Primer can be used as an alternative to Alodine, Anodize or non-chrome pre-treatments.

COATING PROPERTIES

	Base Component
Solids:	
By weight	28.1% ± 1.0%
By volume	15.6% ± 1.0%
Wt./Gal.	7.8 lbs./gal. ± 0.3 lbs.
Sp. Gravity	0.93 ± 0.02
Color	Yellow
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	14-16 seconds
ISO 2431 3mm Cup –Sheen	40-60 seconds
Admixed VOC	6.1 – 6.4 lbs./gal.
Useable Pot Life	
at 77°F / 25°C	8 hours
Theoretical Coverage (Admixed)	
Per dry 0.5 mil	224 sq. ft. / gal.
Per 12.5 microns	5.6 sq. m^2 /L
Dry Film Weight	
Per dry 0.5 mil	0.00445 lb./sq. ft.
Per 12.5 microns	21.7 g/sq. m

SHELF LIFE

Shelf Life is applicable only for materials stored in unopened and undamaged original factory filled containers.

Minimum Storage Temp: 40ºF / 4ºC
Maximum Storage Temp: 100ºF / 37ºC

CM0484646 Base:	3 years
CM0110546 Reducer:	3 years
CM0110646 Reducer:	3 years

SURFACE PREPARATION

The surface to be coated should be a properly cleaned and prepared aluminum substrate before applying Wash Primer.

There are a variety of processes and products to prepare the substrate for priming and painting. Please refer to the recommendations for cleaning, application, and preparation before painting to the manufacturer of the treatment.

Note: Do not use wash primer over any conversion coating such as Alodine.

MIXING INSTRUCTIONS

Shake primer component for 10-15 minutes before admixing. Mix components in plastic containers only.

Admix by Volume:

2 Parts Wash Primer
CM0484646

3 Parts Wash Primer Reducer
CM0110546 – Slow
OR
CM0110646 - Fast

Select the Reducer based on the following criteria:

Select CM0110**546** for:

- Use for large surfaces at any temperature above 59ºF/ 15ºC.
- Any hot conditions up to100ºF/ 38ºC
- When conventional equipment is used. (Due to high air velocity)

Select CM0110**646** for:

- Small Aircraft (Temperatures between 59ºF/ 15ºC to 77ºF/ 25ºC .)
- Parts or components

Stir the admixed material slowly. Filter strain before use.

APPLICATION

This product can be applied using Conventional air spray, HVLP, Graco electrostatic airspray, or air assisted airless.

Note: Always turn the Electrostatic function **OFF.**

Best spray application results are obtained by applying one wet continuous closed film coat or one wet cross coat to achieve a dry film thickness of between 0.25-0.5 mils (6.25-12.5 microns).

NOTE: Sherwin-Williams Urethane Primers CM0486606 or CM0486707 **must** be used over the CM0484646 wash primer.

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 59ºF/ 15ºC before, during, and after application.

DRYING /OVERCOATING SCHEDULE

Dry times are based on the dry film thickness of 0.25 - 0.5 mils (6.25-12.5 microns).

Air Dry Times (77°F / 25°C and 50%)	Min.	Max.
To apply primer	½ Hour	8 Hours

It is not recommended to apply at ambient temperatures below 59ºF/ 15ºC or at a relative humidity level below 33% or above 85%.

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 that are not known or under our control, The Sherwin–Williams Company cannot make any warranties as to the end result.

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PRODUCT MIXING GUIDE

Aerospace Wash Primer CM0484646

1. Shake **CM0484646** Primer for 10-15 minutes before admixing.
2. Mix components in plastic containers only.
3. Addmix by volume

Order of Addition	Volume	U.S. Large	U.S. Small	Metric Large	Metric Small
CM0484646 Adduct	2 Parts	2/3 Gal.	1 Qt. (32 Oz.)	5 L	1 L (1000 mL)
CM0110546 Slow or CM0110646 Fast Reducer	3 Parts Part	1 Gal.	3 Pt. (48 Oz.)	7.5 L	1.5 L (1500 mL)

4. Stir the admixed material slowly.
5. Apply one wet closed film coat to Bare substrate only.
6. Allow 2 hours to air dry before priming.
7. DO NOT use Wash Primer with the Electrostatic function turned on.

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Revision 1.0, 09/24/2012