

**ADVANTAGES**

- Excellent flexibility.
- Non-Shrink
- Fast sanding times
- Designed to work with Sherwin-Williams topcoats.
- Excellent topcoat gloss hold out
- High coverage per gallon

Chrome Hazard Free Urethane Surfacer CM0486707

DESCRIPTION

This product is a high performance, urethane surfacer, which contains no hexavalent chromium. It is intended for all aircraft types and has excellent recoat/inter-coat adhesion with Sherwin-Williams topcoat systems.

COATING PROPERTIES

Solids:	Sprayable
By weight	50.3% ± 1.0%
By volume	32.7% ± 1.0%
Wt./Gal.	9.7 ± 0.5 lbs. / gal.
Sp. Gravity	1.16 ± 0.06
Color	Beige
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	14 – 18 seconds
ISO 2431 3mm Cup –Sheen	40 – 60 seconds
Admixed V.O.C.	
Non-Exempt Solvents	<4.8 lbs. / gal. (577 g/L)
Exempt Solvents	<3.5 lbs. / gal (420 g/L)
Pot Life	
At 77°F / 25°C	4 hours
Theoretical Coverage (Admixed)	
Per dry mil	524 ft ² /gal.
Per 25 microns	13.0 g/m ²
Dry Film Weight	
Per dry mil	0.01 lb./ft ²
Per 25 microns	45.0 m ² /L

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

CM0486707 Base:	3 years
CM0120677 Hardener:	2 years
CM0110667 Reducer:	7 years
CM0110677 Reducer:	7 years
CM0110707 Reducer:	7 years

SURFACE PREPARATION

Depending on the type of substrate to be prepared, different methods should be used. Various processes prepare for surfacing and top coating.

Sherwin-Williams CM0486707 Urethane Surfacers may be applied over prepared composite, fiberglass, epoxy primers, and sanded topcoats.

Note: Do not apply directly onto aluminum, Alodine, or any chrome-free pre-treatment.

MIXING INSTRUCTIONS

Shake the primer component for 15 min. before admixing.

Admix by Volume:

4 Parts	Chrome Hazard Free Urethane Primer CM0486707
1 Part	Urethane Primer Hardener CM0120677
3 Parts	Urethane Primer Reducer CM0110707 – SLOW Compliant OR CM0110667 – SLOW OR CM0110677 – FAST

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

Filter strain before placing material in containers for spraying.

EQUIPMENT

This product can be applied using conventional air spray HVLP, electrostatic air spray, or air-assisted airless electrostatic.

Please consult your Sherwin-Williams representative for specific equipment settings.

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

APPLICATION

Apply up to 3 wet single-pass coats, allowing ½ hour to one hour between coats. The recommended dry film thickness is up to 5.0 mils dry (125 microns). Allow overnight curing at 77°F/25°C. Constant airflow is recommended.

DRYING SCHEDULE

Dry times are based on the dry film thickness up to 5 mils (125 microns)

Air Dry Times (75°F / 25°C and 50% RH)

To Sand (thickness dependent) 8Hrs +

Force Dry: (140°F (60°C), 45% RH)

To lightly sand 2 Hrs. +

When applying to a production piece, apply it to a test panel; once dry, use a D/A on the panel to establish suitable hardness and standability before sanding the AC or production workpiece.

NOTE: Once the surfacer is sanded, the topcoat must be applied within seven days at air drying conditions. After seven days, the primer must be lightly re-activated with P320 or Red Scotchbrite. Clean any dust or debris using CM0110158 employing the wipe on, wipe off method.

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.

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. The customer must obtain the most recent Product Data Sheet for the used product. The information, ratings, 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 application methods that are unknown or under our control, the Sherwin-Williams Company cannot make any warranties as to the result.