



SHERWIN-WILLIAMS.

AEROSPACE COATINGS

PRODUCT DATA

Chrome Hazard Free Quick Dry Epoxy Primer

CM0483712

ADVANTAGES

- Provides corrosion protection without the use of chromate, which makes it safer for the environment and applicator
- Excellent corrosion resistance
- Short dry time with a long potlife
- Flows out to a nice, smooth surface
- Meets the performance requirements of MIL-PRF-23377J, Class N
- Qualified to SAE AMS 3095 as part of a complete chrome free system with 3M's AC-131 Surface Pretreatment and SKYscapes®
- Ideal for commercial aircraft, military aircraft, business jet and general aviation applications.
- Provides excellent substrate opacity
- Designed to work with all Sherwin-Williams topcoat systems
- High square coverage per gallon.
- Contains less than 2.9 lbs. of VOC per mixed gallon or 350 grams per liter
- Excellent topcoat gloss hold out

DESCRIPTION

CM0483712 is an high performance, two-component, corrosion inhibitive Epoxy Primer which contains no chromate. This special epoxy primer utilize unique chemistry that yields a shortened dry time with an extended pot life as well as excellent corrosion resistance. It provides excellent adhesion to treated substrates and meets U.S. VOC regulations that require a 2.9 lb/gal (348 g/L).

COATING PROPERTIES

Solids:	Base Component
By weight	66.5% +/- 1.0%
By volume	48.98% +/- 1.0%
Density:	1.421 g/ml
Wt./Gal.	11.00 +/- 0.5 lbs./gallon
Specific Gravity	1.32 +/- 0.06
Color	Light Tan
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	14-18 seconds
Admixed V.O.C. (Mixed 3:1:3)	
Mixed with CM0110944 or CM0110787 Reducer	<2.9 lbs./gal (348 g/L)
Pot Life	4 Hours
at 77°F / 25°C	
Theoretical Coverage	
Per dry mil	561 ft. ² / gal.
Per 25 microns	13.77 m ² / L
Dry Film Weight	
Per dry mil	0.01lb/ft ²
Per 25 microns	45.3 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

CM0483712:	2 years	CM0110787:	7 years
CM0120712:	2 years	CM0110944:	7 years
CM0110099	7 years		

SURFACE PREPARATION

To insure proper primer adhesion to the substrate, all contaminants must be removed using the appropriate solvent degreaser. i.e. CM0120540.

Sherwin-Williams primers are designed to go over various pre-treatments (i.e., alclad or anodized aluminum, magnesium, and stainless steel) as well as properly prepared and sanded composite substrates.

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

3 Parts	Chrome Hazard Free Epoxy Primer CM0483712
1 Part	Chrome Hazard Free Epoxy Primer Adduct CM0120712
3 Parts	Reducers. (Rated by wet edge time) CM0110787 (Fast) CM0110944 (Medium) CM0110099* (Slow)

*If CM0110099 Reducer is used, the VOC could exceed the 2.9 lbs/gallon (350 grams per liter) level.

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

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

APPLICATION

Best spray application results are obtained by applying one singular continuous closed film or one cross coat.

Recommend dry film thickness 0.6 to 1.2 mils.

This product can be applied using conventional air spray, HVLP, ~~Graco~~ compliant, electrostatic airspray or air assisted airless (AAA)

DRYING SCHEDULE

Dry times are based on the dry film thickness of 0.6-1.2mils (15-30 microns).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To light sand or apply topcoat	2 Hours	72 Hours*

<u>Force Dry:</u> (140°F (60°C), 45% RH)	<u>Min.</u>
To light sand or apply topcoat	30 Minutes

* 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 pads 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.