



Exterior Composite Surfacer

CM0481030 – Gray CM0481035 – White

ADVANTAGES

- Quick cure- increasing shop productivity
- Resistance to film shrinkage
- Forms a tough film with excellent recoat / intercoat adhesion properties
- Excellent sanding characteristics
- No priming necessary
- Reduces process time for topcoat preparation
- Compatible with Sherwin-Williams topcoats including SKYscapes —a rain erosion resistant coating
- Available in white and gray

DESCRIPTION

CM0481030 and CM0481035 are high quality two-component urethane surfacers that provide performance, versatility and productivity. These Sherwin-Williams' products provide excellent gloss holdout, resist film shrinkage, easy to sand, and retain flexibility. This product is intended for use on exterior composites or pre-primed aluminum surfaces for aircraft and parts. CM0481030 (Gray) and CM0481035 (White) are ideal to fill and permanently conceal surface imperfections. to create a smooth surface for topcoat applications.

COATING PROPERTIES

Solids:	As applied
By weight	66.8% ± 1.0%
By volume	46.0% ± 1.0%
Wt./Gal.	11.70 ± 0.2 lbs.
Sp. Gravity	1.413 ± 0.02
Color	Gray and White
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	18-20 seconds
ISO 2431 3mm	70-75 seconds
Admixed V.O.C. (Mixed 4:1: 1 with CM0110944)	
U.S. Exempt Solvent	3.25 lbs./gal. (389 g/L)
Non-Exempt Solvent	3.89 lbs./gal. (467 g/L)
Useable Pot Life	
at 77°F / 25°C (CM0110102)	1 Hours
at 77°F / 25°C (CM0110030)	30 Minutes
Theoretical Coverage	
Per dry mil	738 ft.2 / gal.
Per 25 microns	18.11 m ² / L
Dry Film Weight	
Per dry mil	0.01 lbs. / ft. ²
Per 25 microns	54.76 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

CM0481030: 7 years	CM0110102: 7 years
CM0481035: 7 years	CM0110030 7 years
CM0120677: 2 years	CM0110944 7 years

SURFACE PREPARATION

This product is intended for use on exterior aircraft and parts for the following substrates:

- composites
- pre-primed or sanded paint schemes over aluminum surfaces

Abrade the composite surface or filler with a 240 or 320 grit sandpaper or other comparable procedure.

Surface should be dry and free of oil, dust, or overspray.

MIXING INSTRUCTIONS

Shake primer component for 10-15 minutes before admixing.

Admix by Volume:

4 Parts	Exterior Composite Surfer CM0481030 or CM0481035
1 Part	Urethane Primer Hardener CM0120677
1 Part	Reducer (Select from below) CM0110102 - Standard Reducer (Recommended use)
	or
	CM0110944 – US Exempt Reducer (For low VOC use)
	or
	CM0110030 - Accelerated Reducer (For Touch-Up Use)

Add the Hardener into the Primer Component. Add the Reducer immediately.

An additional ½ part of **CM0110944** US Exempt Reducer can be added to enhance smoothness and extend the pot life by as much as thirty minutes.

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

NOTE: No induction required, use immediately

APPLICATION

This product can be applied using conventional air spray equipment and HVLP. Please consult your Sherwin-Williams representative for specific equipment settings

1. Make sure guns are purged and cleaned.
2. Mix thoroughly and filter strain before spray applying.
3. Apply 2 or 3 medium/wet coats 5 to 10 mins apart at a gun distance of 5" to 7".
4. Gun settings: 6-9 psi HVLP / 25-45 psi Conventional. (Refer to your specific spray gun manufacturers technical data sheet)

Always air-blow and tack-wipe the surfaces to be painted.

Best spray application results are obtained by applying two or more smooth medium-wet coats with 5-15 minutes between coats.

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 up to **5 mils (125 microns)**.

Air Dry Times (75°F / 25°C and 50% RH)	<u>Min</u>
To DA (orbital) Sand (using CM0110102)	1-2 Hours
To DA (orbital) Sand (using CM0110030)	45 Minutes

Force Dry (140°F / 60°C)	
To DA (Orbital) Sand (using CM0110102)	30 Minutes
To DA (Orbital) Sand (using CM0110030)	20 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 240 or 320 grit sandpaper. Proper sanding is the key to good intercoat adhesion and a smooth appearing surface.

Note: Once sanded, topcoat within 7 days. After 7 days, solvent clean and scuff.

If the cured primer is inadvertently sanded through, a light coat of corrosion primer as a spot repair 0.5 mil (12 microns) will be required prior to spraying topcoat. Allow primer to dry a minimum of 30 minutes before overcoating.

EQUIPMENT CLEANUP

Flush and clean spray equipment immediately. Use clean Ketone-type solvents such as CM0110308 MEK. Do not allow material to cure inside equipment.

PRODUCT INFORMATION


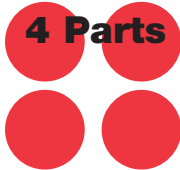




Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent 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.

Exterior Composite Surfacer

CM0481030 - Gray

CM0481035 - White

- 1 Shake the CM0481030 or CM0481035 for 10-15 minutes before admixing.
- 2 Add in order shown below. The Adduct and reducer should be mixed into the primer component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 <p>CM0481030 Composite Surfacer - Gray</p> <p>CM0481035 Composite Surfacer - White</p>	<p>4 Parts</p> 	4 Gal.	1 Gal.	15.2 L	3.8 L
 <p>CM0120677 Urethane Primer Hardener</p>	<p>1 Part</p> 	1 Gal.	1 Qt.	3.8 L	.95 L
 <p>CM0110102 Reducer or</p> <p>CM0110944 US Exempt Reducer</p>	<p>1 Part</p> 	1 Gal.	1 Qt.	3.8 L	.95 L

- 3 An additional ½ part of CM0110944 US Exempt Reducer can be added to extend the pot life and enhance smoothness.
- 4 For repairs or touch-up areas, use CM0110030 Accelerated Reducer in place of the CM0110102 Reducer.
- 5 Filter strain and apply. No induction required.