



Chrome Hazard Free Epoxy Primer

CM0483787

ADVANTAGES

- Provides corrosion protection without the use of chromate, which makes it safer for the environment and applicator.
- Excellent wet edge. Ideal for a large surface application area.
- Flows out to a nice, smooth surface.
- Provides excellent substrate opacity.
- Ideal for commercial aircraft, business jets, and general aviation.
- Designed to work with 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.
- Qualified to SAE AMS 3095 with both Jet Glo Express™ and SKYscapes®.

DESCRIPTION

CM0483787 is an high performance, two-component, corrosion inhibitive Epoxy Primer which contains no chromate. It provides excellent adhesion to treated substrates and meets U.S. VOC regulations that require 2.9 lb/gal (350 g/L).

COATING PROPERTIES

Solids:	Base Component
By weight	63.1 ± 1.0
By volume	43.1 ± 1.0
Wt./Gal.	11.1 ± 1.0
Specific Gravity	1.33 ± .06
Color	Light Gray
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	15-20 seconds
Admixed V.O.C. (Mixed 3:1:1)	
U.S. Exempt Solvent	<2.9 lbs./gal (350 g/L)
Non-Exempt Solvent	<4.2 lbs./gal (504 g/L)
Useable Pot Life	
at 77°F / 25°C	4 Hours
Theoretical Coverage	
Per dry mil	691 ft.2 / gal.
Per 25 microns	16.9 m ² / L
Dry Film Weight	
Per dry mil	0.01 lb/ft ²
Per 25 microns	49.5 gm/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

CM0483787: 2 years
CM0120787: 2 years
CM0110787: 7 years



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SURFACE PREPARATION

To insure proper primer adhesion to the substrate, all contaminants must be removed. Depending on the type of substrate to be prepared, different methods should be used. There are a variety of processes to prepare these substrates for primer and painting.

Sherwin-Williams primers are designed to go over various treatments (i.e., alclad or anodized aluminum, composite, fiberglass, magnesium, and stainless steel) as well as properly prepared metal and composite substrates. Please refer to recommendations for cleaning, application, and preparation before painting to the manufacturer of the treatment.

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

3 Parts	Chrome Hazard Free Epoxy Primer CM0483787
1 Part	Adduct CM0120787
1 Part	Reducer CM0110787

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 electrostatic airspray or air assisted airless.

DRYING SCHEDULE

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

Air Dry Times (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To light sand or apply topcoat	2-3 Hours	72 Hours*

Force Dry: (140°F (60°C), 45% RH)	<u>Min.</u>
To light sand or apply topcoat	20-30 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.



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