SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Chrome Hazard Free Urethane Primer

CM0486707

ADVANTAGES

- Qualified to the SAE AMS 3095 system specification using CM0484646 Wash Primer with Jet Glo Express™ and SKYscapes® topcoat as systems.
- Provides corrosion protection without the use of hazardous chromates.
- Convenience – This product can be used as both a Primer and Surfacer. One product for both types of application
- Excellent flexibility.
- Designed to work with Sherwin-Williams topcoats.
- Excellent topcoat gloss hold out
- High square feet coverage per gallon
- Excellent flexibility
- Lower VOC to comparable

DESCRIPTION

This product is a high performance, corrosion inhibitive urethane primer, which contains no hexavalent chromium. This primer can also be used as as a high-build sanding surfacer. It is intended for use on all types of aircraft and has excellent recoat/intercoat adhesion with Sherwin-Williams topcoat systems.

COATING PROPERTIES

	Sprayable
Solids:	
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)
Pot Life	
At 77°F / 25°C	4 hours
Theoretical Coverage (Admixed)	
Per dry mil	524 ft^2./gal.
Per 25 microns	12.9 g/m^2
Dry Film Weight	
Per dry mil	0.01 $lb./ft^2$
Per 25 microns	45.4 gm/m^2

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

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

SURFACE PREPARATION

Depending on the type of substrate to be prepared, different methods should be used. There are a variety of processes to prepare surface for the primer and topcoating.

Sherwin-Williams Urethane primers are designed to go over various treatments (i.e., wash primed, Alodine or Anodized aluminum, composite, fiberglass, sanded primer or topcoats. Please refer to recommendations for cleaning, application, and preparation before use.

If wash primer is needed, please refer to the CM0484684 Wash Primer Product Data Sheet.

MIXING INSTRUCTIONS

Shake primer component for 15 min. before admixing.

Admix by Volume:

4 Parts Chrome Hazard Free Urethane Primer
CM0486707

1 Part (1/4 part of Base Volume)
Urethane Primer Hardener
CM0120677

3 Parts (3/4 parts of Base Volume)
Urethane Primer Reducer
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, Graco electrostatic air spray or air assisted airless.

Please consult yourSherwin-Williams representative for specific equipment settings.

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

APPLICATION

Best results are obtained by applying one light continuous closed film cross coat. The recommended dry film thickness is 0.6 – 1.2 mils (15-30 microns).

This primer can also be applied as a high-build sanding surfacer. Apply up to 3 wet single pass coats allowing one hour between coats. Total recommended dry film thickness is up to 5.0 mils dry (125 microns). It is preferred to allow overnight cure at 77°F/25°C for maximum cure properties. Constant airflow is recommended.

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 55ºF / 13ºC before, during, and after application.

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)	Min.	Max.
To apply topcoat (thickness dependent)	2 to 4 Hrs	16 Hrs
To Lightly Sand (thickness dependent)	6 Hours	
Dry Hard	8 Hours	

Force Dry: (140ºF (60ºC), 45% RH	Min.
To light sand or apply topcoat	1 Hour

* If an intermediate primer or topcoat is not applied within 16 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, 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

Chrome Hazard Free Urethane Primer CM0486707

1. Shake **CM0486707** Primer for 15 minutes before admixing.
2. Add in order shown below. The Adduct and Reducer should be slowly mixed into the primer component. Stir as components are added.

Order of Addition	Volume	U.S. Large	U.S. Small	Metric Large	Metric Small
CM0486707 Primer	4 Parts	1 Gal.	1 Qt.	3.78 L	946 mL
CM0120677 Adduct	1 Part	1 Qt.	1/2 Pt.	.95 L	235 mL
CM0110677 Fast or **CM0110667 Slow** Reducer	3 Parts	3 Qt.	1 1/2 Pt.	2.85L	705 mL

3. Allow admix to induct 30 minutes.
4. Filter strain and apply.

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