SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Corrosion Protective Urethane Primer

CM0486606

ADVANTAGES

- Qualified to the SAE AMS 3095 system specification using CM0484646 Wash Primer and Jet Glo Express topcoat as a system.
- Designed to work with Sherwin-Williams topcoats.
- Can be topcoated without sanding between 2 and 16 hours.
- Sands easily, if required.
- Excellent topcoat gloss hold out
- High square feet coverage per gallon
- Excellent flexibility
- Lower VOC to comparable competitive products.

DESCRIPTION

CM0486606 is a high performance, corrosion inhibitive urethane primer. This primer is intended for use on all types of aircraft and has excellent recoat/intercoat adhesion with Sherwin-Williams topcoat systems.

COATING PROPERTIES

	Admixed Material
Solids:	
By weight	47.2% ± 1.0%
By volume	28.1% ± 1.0%
Wt./Gal.	9.38 ± 0.3 lbs. / gal.
Sp. Gravity	1.12 ± 0.02
Color	Yellowish Green
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	14 – 18 seconds
ISO 2431 3mm Cup –Sheen	40 – 60 seconds
Admixed V.O.C.	4.97 lbs. / gal. (595 g/L)
Useable Pot Life	
At 77°F / 25°C	2 hours
Theoretical Coverage (Admixed)	
Per dry mil	485.9 sq.ft./gal.
Per 25 microns	11.93 g/sq. m
Dry Film Weight	
Per dry mil	0.0092 lb./sq. ft.
Per 25 microns	44.75 g/sq. m

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

CM0486606 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 a Sherwin-Williams representative for recommendations on cleaning, application, and preparation before use.

Wash primer is to be used to comply with AMS 3095. Please refer to the CM0484646 Wash Primer Product Data Sheet.

MIXING INSTRUCTIONS

Shake primer component for 15 min. before admixing.

Admix by Volume:

4 Parts	Urethane Primer **CM0486606**
1 Part	Urethane Primer Hardener **CM0120677**
4 Parts	Urethane Primer Reducer **CM0110667 – SLOW** OR **CM0110677 - FAST**

CM0110667 is recommended for full or part repaints, general use, or hot conditions.

CM0110677 is recommended for smaller AC or part repaints.

Filter strain before placing material in containers for spraying. NOTE: Constant slow agitation of admixed materials is recommended through end of potlife.

EQUIPMENT

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

Please consult your Sherwin-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).

Application of these product systems requires controlled 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.

Recommended solvent wipe materials to clean the surface after sanding:

- CM0110120 Prepaint Wiping Solvent
- CM0110158 Basecoat Cleaner
- CM0110146 Waterborne Basecoat Cleaner

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.