



Corrosion Resistant Epoxy Primer, MIL-PRF-23377F CM0724400

ADVANTAGES

- Meets the performance properties of MIL-P-23377F, Type I, Class I.
- A popular, proven product that has been applied extensively at OEMs and maintenance facilities for decades.
- Excellent corrosion, water and chemical resistance.
- Designed to work with Sherwin-Williams sanding surfacers and topcoat systems.

DESCRIPTION

CM0724400 is a high performance, two-component, yellow Epoxy Primer possessing both outstanding flexibility and corrosion resistance. This high performance epoxy primer is intended for use on all types of aircraft and meets MIL-P-23377F, Type I, Class I. It yields films that are very corrosion, chemical, and impact resistant.

COATING PROPERTIES

Solids:	<u>Base Component</u>
By weight	62.6 ± 2.0%
By volume	40.2 ± 2.1%
Wt./Gal.	11.2 ± 0.2 lbs.
Sp. Gravity	1.4 ± 0.02
Color	Yellow
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	16-20 seconds
ISO 2431 3mm Cup –Sheen	45-65 seconds
Admixed V.O.C. (Mixed 1:1)	5.04 lbs./gal. (605 g/L)
Useable Pot Life	
at 77°F / 25°C	4 Hours
at 95°F / 35°C	2 Hours
Theoretical Coverage	
Per dry mil	460 ft.2 / gal.
Per 25 microns	11.3 m ² / L
Dry Film Weight	
Per dry mil	0.0092 lbs. / ft. ²
Per 25 microns	44.9 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

CM0724400:	1 years	CM0110588	7 years
CM0724114:	1 years	CM0702901	7 years

Cool, Dry Storage Required.



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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 substrate treatments. Before painting, please refer to the recommendations for cleaning, application, and preparation to the manufacturer of the treatment.

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

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

1 Part Epoxy Primer
CM0724400

1 Part Epoxy Adduct
CM0724114

Add the Epoxy Adduct into the Primer Component.

For optimum application performance, stir well during a 15-minute induction time

Reduce to spraying viscosity using CM0110588 Slow Reducer, CM0702901 Fast Reducer or a blend of both products depending on your shop conditions.

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

APPLICATION

This product can be applied using conventional air spray, HVLP, Graco electrostatic airspray, or air assisted airless. Please consult your Sherwin-Williams representative for specific equipment settings.

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

Equipment settings:

Conventional air spray:

Air cap atomizing pressure: 50-60 psi (3.45-4.15 bar)

Pot pressure: 10-12 psi (0.69 – 0.83 bar) using a 60' fluid hose (3/8" diameter)

Delivery Rate: 8-10 fluid oz (236-295 mL) per minute

Best spray application results are obtained by applying one light continuous closed film cross coat

Recommended dry film thickness is 0.6 – 0.9 mils (15-23 microns).

Surfacer primer can be applied after a two-hour cure to allow time for solvent flash-off. Please refer to the Product Data Sheets for Epoxy Surfacer (CM0560563, CM0480920, CM0482300, CM0487600) or CM0481810 Urethane Surfacer for more details.

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 0.6-0.9 mils (15-23 microns).

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

Force Dry: (140°F /60°C, 45% RH)	<u>Min.</u>
To apply topcoat	1 Hour

*** For maximum performance of a urethane topcoat appearance, allow primer to cure for a minimum of 12 hours before topcoating.**

If an intermediate primer or topcoat is not applied within 72 hours of primer application, light scuff sanding 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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MIL-PRF-23377F

Corrosion Resistant Epoxy Polyamide Primer CM0724400

- 1** Shake the CM0724400 for 15 minutes before admixing.
- 2** Add in order shown below. The Adduct should be mixed into the primer component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0724400 Primer	1 Part	1 Gal.	1 Qt.	3.78 L	946 mL
  CM0724114 Adduct	1 Part	1 Gal.	1 Qt.	3.78 L	946 mL

- 3** Allow admix to induct 15 minures..
- 4** Reduce to spraying viscosity using CM0110588 Slow Reducer, CM0702901 Fast Reducer or a blend of both products depending on shop conditions.
- 5** Filter strain and apply.



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