



Wash Primer

CM0484684

ADVANTAGES

- Designed to work with Sherwin-Williams corrosion preventative primers.
- The mixed primer provides a corrosion resistant film for aluminum.
- Can be applied as a specialty coating.
- Product was designed to meet the military specification DOD-P-15328.

DESCRIPTION

CM0484684 is a two-component, Vinyl Wash Primer. It is used for aluminum pretreatment where Alodine or Anodized treatment is not required.

COATING PROPERTIES

Solids:	Base Component
By weight	22.7 ± 1.0%
By volume	11.9 ± 0.8%
Wt./Gal.	7.8 ± 0.3 lbs.
Sp. Gravity	0.94 ± 0.02
Color	Green
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	15-19 seconds
ISO 2431 3mm Cup –Sheen	45-65 seconds
Admixed VOC (Mixed 1:1:25%)	7.4 lbs./gal. (889 g/L)
Useable Pot Life at 77°F / 25°C	4 hours
Theoretical Coverage	
Per dry mil	107 ft.2 / gal.
Per 25 microns	2.62 m ² / L
Dry Film Weight	
Per dry mil	0.0094 lbs. / ft. ²
Per 25 microns	46.2 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

CM0484684: 1 year
CM0120789: 1 year
CM0110701: 7 years

SURFACE PREPARATION

The surface to be coated should be a properly cleaned and prepared aluminum substrate before applying CM0484684 Wash Primer.

There are a variety of processes and products to prepare the substrate for priming and painting. Please refer to the recommendations for cleaning, application, and preparation before painting to the manufacturer of the treatment.

Do not use wash primer over a conversion coating such as Alodine.

MIXING INSTRUCTIONS

Shake primer component for 10-15 minutes before admixing.

The Wash Primer Reducer should be slowly added into the Wash Primer Component. Failure to do this could be hazardous causing and exothermic reaction.

Admix by Volume:

1 Part	Wash Primer CM0484684
1 Part	Wash Primer Reducer CM0120789
½ Part	Reducer – Medium Temperature CM0110701

Stir the admixed material slowly.

APPLICATION

Important note: **ALWAYS** turn the Electrostatic function **OFF**

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.

Mix thoroughly and filter strain before spray applying.

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

Equipment settings:

Conventional air spray:

- Air cap atomizing pressure: 40-50 psi (2.75-3.45 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

Wash primer should be applied using low atomizing air pressure (about 40 psi or 2.75 bar) to minimize overspray. (This is the opposite of the settings normally required for good spray atomization.)

Recommended dry film thickness is 0.5 – 0.7 mils (13-18 microns).

NOTE: A Sherwin-Williams corrosion preventative primer **must** be used over the CM0484684 wash primer, such as CM0483505, CM0483660, CM0483928 or CM0484900.

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 /OVERCOATING SCHEDULE

Dry times are based on the dry film thickness of 0.5-0.7 mils (13-18 microns).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To apply primer	60 Min.	8 Hours

It is not recommended to apply at ambient temperatures below 55°F (10°C) or at a relative humidity level below 33% or above 85%.

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.

Wash Primer CM0484684

- 1** Shake the CM0484684 for 10-15 minutes before admixing.
- 2** Add in order shown below. **The Wash Primer Reducer must be added into the Wash Primer Component. Failure to do this could be hazardous causing an exothermic reaction.**

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0484684 Wash Primer	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0120789 Wash Primer Reducer	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0110701 Reducer	1/2 Part 	2 Qt.	1 Pt.	1.9 L	.48 L

- 3** Stir the admixed material slowly.
- 4** Filter strain and apply.