



**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 airline, business jets, general aviation, military aircraft and aircraft ground support equipment.
- Designed to work with all polyurethane topcoat systems.
- Simple 2:1:1 mix ratio with no additional reduction required.
- High square coverage per gallon.
- Contains less than 2.8 lbs. of VOC per mixed gallon or 335 grams per liter.
- Excellent topcoat gloss hold out.

# Universal Chrome Free Epoxy Primer

## CM0483810

**DESCRIPTION**

Universal Chrome Hazard Free Epoxy Primer, CM0483810, is a high performance, two-component, corrosion inhibitive Epoxy Primer which contains no chromate. It provides exceptional corrosion protection of aluminum alloys and excellent adhesion to treated substrates. It is ideal for the application to aircraft and ground support equipment. It also meets the U.S. VOC regulations that require 2.8 lb./gal (335 g/L) and is designed to work under all polyurethane topcoat systems

**COATING PROPERTIES**

**Solids:**

By weight	63.0 ± 1.0
By volume	48.0 ± 1.0

**Wt./Gal.**

11.0 ± 1.0

**Specific Gravity**

1.32 ± 0.06

**Color**

Green

**Viscosity—Sprayable**

Gardner Signature #2 Zahn Cup	14-20 seconds
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**Admixed V.O.C. (Mixed 2:1:1)**

U.S. Exempt Solvent	<2.8 lbs./gal (335 g/L)
Non-Exempt Solvent	<4.2 lbs./gal (504 g/L)

**Useable Pot Life**

at 77°F / 25°C	3 Hours
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**Theoretical Coverage**

Per dry mil	767 ft.2 / gal.
Per 25 microns	18.84 m <sup>2</sup> / L

**Dry Film Weight**

Per dry mil	0.009 lb./ft <sup>2</sup>
Per 25 microns	45.1 gm/m <sup>2</sup>

**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

CM0483810: 1 year  
 CM0120800: 1 year  
 CM0120A03: 1 year

## SURFACE PREPARATION

To ensure 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, ferrous, 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:

<b>2 Parts</b>	Chrome Hazard Free Epoxy Primer (Base) <b>CM0483810</b>
<b>1 Part</b>	Adduct (Hardener) <b>CM0120800</b>
<b>1 Part</b>	Activator <b>CM0120A03</b>

Add the Adduct to the Base and mix thoroughly for 3-5 minutes then add Activator and mix for another 3-5 minutes. Allow for a 20-30 minute induction time before use.

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 air spray or air assisted airless.

## DRYING SCHEDULE

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

<b>Air Dry Times:</b> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To light sand or apply topcoat	2-3 Hours	48 Hours*

<b>Force Dry:</b> (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 48 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 or 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.