



# MIL-PRF-23377K, Type 1 Class C2 2.8 VOC Chromated Epoxy Polyamide Primer

CM0724933

## ADVANTAGES

- This product has been qualified by the U.S. Naval Air Warfare Center (NAWC) Patuxent River, MD to MIL-PRF-23377K, Type I, Class C2.
- 2.8 lb/gal VOC.
- Excellent chemical, solvent and corrosion resistance.
- For aluminum with chromate Conversion coating or anodized aluminum, it offers excellent filiform resistance.

## DESCRIPTION

**CM0724933** is a 2.8 lb/gal VOC compliant, epoxy polyamide primer. It meets MIL-PRF-23377K, Class C2 composition and performance specification. It is used as a primer under MIL-PRF-85285 polyurethane topcoats.

## COATING PROPERTIES

<b>Solids:</b>	<u>Base Component</u>
By weight	71.04± 1.0%
By volume	41.96 ± 0.8%
<b>Wt./Gal.</b>	13.39± 0.2 lbs.
<b>Sp. Gravity</b>	1.53 ± 0.02
<b>Color</b>	Green
<b>Gloss</b>	20-45
<b>Viscosity–Sprayable</b>	
Gardner Signature #2 Zahn Cup	18-25 seconds
<b>Admixed V.O.C. (Mixed 3:1)</b>	<2.8 lbs./gal. (350 g/L)
<b>Useable Pot Life</b>	
at 77°F / 25°C	4 Hours
<b>Theoretical Coverage</b>	
Per dry mil	742 sq ft/gal
<b>Dry Film Weight</b>	
Per dry mil	0.0115 lbs. / ft. <sup>2</sup>
Per 25 microns	56 g/ 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

CM0724933: 18 months

CM0120933: 12 months

Touch –up Kits: 6 months

## 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 treatments (i.e., alclad or anodized aluminum, composite, fiberglass, magnesium, and stainless steel). 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>3 Parts</b>	Epoxy Primer Component <b>CM0724933</b>
<b>1 Part</b>	Epoxy Adduct <b>CM0120933</b>

Add the required volume (up to a maximum of 1½ part) of CM0110933. This additional reduction may change the application VOC to greater than 2.9 lbs./gal. (350 g/L) depending on the legislation in your area.

Admixed product should be allowed a 15-minute induction time for optimum application performance.

It is recommended to filter strain admixed 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.

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).

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).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
To apply topcoat	2 Hours	72 Hours*
Tack free	5 Hours	
Dry Hard	8 Hours	

<u>Force Dry:</u> (140°F (60°C), 45% RH)	<u>Min.</u>
Dry Hard	45-60 minutes

\* If an intermediate primer or topcoat is not applied within 72 hours of primer application, light scuff sanding using P240,P320 paper &/or red abrasive pad 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.