



Epoxy Sanding Primer

CM0560563

ADVANTAGES

- A popular, proven product that has been applied extensively at OEMs and maintenance facilities for decades.
- Easily sandable.
- Excellent sanding process characteristics.
- Covers and seals polyester filler sanding scratches.
- Designed as a flexible surfacer primer.
- Improves applied topcoat visual appearance.

DESCRIPTION

CM0560563 is an intermediate, two-component epoxy surfacer intended for use on aircraft and other aerospace applications over Sherwin-Williams corrosion protective primers. It is designed to insure maximum corrosion and aviation fluid resistance while providing a sandable surface that enhances topcoat appearance.

COATING PROPERTIES

Solids:	Base Component
By weight	62.7 ± 2.0%
By volume	42.8 ± 2.0%
Wt./Gal.	10.6 ± 0.3 lbs.
Sp. Gravity	1.27 ± 0.03
Color	Gray
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	16-18 seconds
ISO 2431 3mm Cup –Sheen	45-65 seconds
Admixed V.O.C. (Mixed 4:1:¼)	
U.S. Exempt Solvent	<4.85 lbs./gal. (581 g/L)
Non-Exempt Solvent	<4.85 lbs./gal. (581 g/L)
Useable Pot Life	
at 77°F / 25°C	4 Hours
Theoretical Coverage	
Per dry mil	484 ft.2 / gal.
Per 25 microns	11.9 m ² / L
Dry Film Weight	
Per dry mil	0.0084 lbs. / ft. ²
Per 25 microns	41.0 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

CM0560563: 2 years	CM0110588 7 years
CM0120888: 2 years	CM0702901 7 years

SURFACE PREPARATION

Surface should be dry and free of oil, dust, or overspray. For maximum adhesion and corrosion resistance, apply over a corrosion resistant primer such as CM0483928, CM0483505 or CM0483660, which has previously been properly treated or wash primed with CM0484684.

The CM0560563 should be applied over the selected corrosion preventative primer within 4 hours at 77°F (25°C). If overnight cured, a light scuff sanding (320 grit sandpaper or Scotchbrite 7447) and cleaning is recommended.

NOTE: Do not use this product as a filler Surfacer to cover marginally prepared composite/fiberglass or polyester filler bondtite area. Address these appearance items by reviewing the cured corrosion protective primer and assuring satisfactory smoothness before applying CM0560563.

MIXING INSTRUCTIONS

Shake primer component for 15 minutes before admixing.

Admix by Volume:

1 Part	Epoxy Primer Component CM0560563
1 Part	Epoxy Adduct CM0120888

Add the Adduct into the Primer Component.

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

If a lower viscosity is needed, use up to 1 - 1½ quart per 2-gallon kit of 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: 40-50 psi (2.75-3.45 bar)
- Pot pressure: 8-12 psi (0.55 – 0.83 bar) using a 60' fluid hose (3/8" diameter)
- Delivery Rate: 8-10 fluid oz (236-295 mL) per minute

Apply CM0560563 using a wet medium cross coat method. Apply in two coats with a 45 minute solvent flash-off time between coats.

Recommended final dry film thickness is 1.0 – 1.5 mils (25-38 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 1.0 – 1.5 mils (25-38 microns).

Air Dry Times (75°F / 25°C and 50% RH)	<u>Minimum</u>
To Sand (220, 240 or 320 grit)	8 Hours
To Topcoat (after sanding)	8 Hours

NOTE: Lower temperatures, heavy film thickness, improper activator range selection and poor air movement will extend the dry time.

SANDING RECOMMENDATIONS

CM0560563 must be sanded to a smooth surface prior to topcoating. Mechanical DA (orbital) sanding or hand sanding of this product works well with 220, 240 or 320 grit sandpaper. Proper sanding is the key to good intercoat adhesion and a smooth appearing surface.

If the cured epoxy primer is inadvertently sanded through, a spot repair will be required prior to spraying topcoat.

EQUIPMENT CLEANUP

Flush and clean fluid material hose and paint guns as soon as possible after spraying is complete. 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.

Epoxy Sanding Primer CM0560563

- 1** Shake the CM0560563 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
 CM0560563 Primer	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0120888 Epoxy Adduct	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Allow admix to induct 15 minutes.
- 4** If a lower viscosity is needed, use up to 1 - 1-1/2 quart per 2-gallon kit of CM0110588 Slow Reducer, CM0702901 Fast Reducer, or a blend of both products depending on your shop conditions.

 CM0110588 or CM0702901 Reducer	1/4 - 3/8 Part 	1 - 1 1/2 Qt.	1/2 - 3/4 Pt. (8-12 oz)	.95 - 1.45 L	235 - 355 mL
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- 5** No accelerator additives are to be used in epoxy primers or surfacers.
- 6** Filter strain and apply.