

JetFlex[®] Water Reducible SprayFil CM0481505

DESCRIPTION

JetFlex[®] Water Reducible Spray Fil is a one-component, VOC complying acrylic latex filler developed to fill and hide profile and surface imperfections on foam plastics, metal and wood for aircraft interior application.

Advantages:

- Water reducible latex quality.
- Low VOC, less than 1.2 lbs./gal.
- Volatile organic emissions under 0.7 lb./gal.
- Excellent adhesion to a wide range of structural foam and injection molded plastics.
- Easy filling and sanding.
- Eliminates wicking of plastics.
- Fast air dry.
- Low odor.
- Reduced fire hazards, possible lower insurance rates.
- Single component, no catalyzation.
- No critical recoat time.
- Free of lead and chromate hazards.
- Reduce and clean up with water.
- Non-photochemically reactive.

COATING PROPERTIES

| | |
|------------------------------------|--|
| Color: | Off White |
| Volume Solids: | 50.1 ± 2% |
| Weight per Gallon: | 12.6 |
| Specific Gravity: | 1.52 |
| Viscosity: | 65-85 KU |
| Recommended Film Thickness: | |
| Mils Wet: | 5.0-6.0 (127-152 μm) |
| Mils Dry: | 2.0-2.5 (51-63.5 μm) |
| Theoretical Coverage: | |
| 1 mil DFT | 804 sq. ft./gal. |
| Per 25 μm | 19.8 m ² /L |
| Gloss: | Flat |
| VOC: | As packaged, maximum 1.2 lbs./gal. (144 g/L) |
| Volatile Organic Emissions: | As packaged, maximum 0.7 lbs./gal. (84 g/L) |
| Flash Point: | None, Pensky-Martens Closed Cup |
| pH: | 7.7-8.3 |

Cure Data:

| | |
|-----------------------------------|----------------------------|
| 2.0 mils DFT, 77°F (25°C), 50% RH | |
| To Touch | 10-15 minutes |
| To Handle | 20-25 minutes |
| To Sand | 30-40 minutes |
| To Recoat | 30-40 minutes |
| Force Dry | 30 minutes at 140°F (60°C) |

SURFACE PREPARATION

General: Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties.

Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc for iron phosphate to improve corrosion protection.

Aluminum: prime with Wash Primer CM0484684.

Plastic: Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. Please consult your Sherwin-Williams aerospace representative for system recommendations.

Wood (interior only): Must be clean, dry, and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination to ensure optimum adhesion and coating performance properties.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full-scale application.

MIXING AND APPLICATION

Conventional Spray:

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|-----------------|--------------------|
| Reducer: | water |
| Reduction Rate: | as needed up to 5% |

Airless Spray:

| | |
|-----------------|---------------------|
| Pressure | 2000-2400 psi |
| Tip | 011-.013" |
| Reducer | water |
| Reduction Rate: | as needed up to 10% |

Air Assisted Airless:

| | |
|----------------|---------------------|
| Air Pressure | 15-30 psi |
| Fluid Pressure | 850-950 psi |
| Cap/Tip | 011-.013" |
| Reducer | water |
| Reduction Rate | as needed up to 10% |

HVLP

| | |
|----------------|---------------------|
| Air Pressure | 8-9 psi |
| Fluid Pressure | 6-9 psi |
| Reducer | water |
| Reduction Rate | as needed up to 10% |

Note: Do not over reduce. Water reducible enamels must be applied at a higher viscosity than solvent-based enamels. They apply and atomize easier at higher viscosity level.

EQUIPMENT CLEANUP

Clean equipment and lines immediately with water. If dried, clean with a blend of water and ammonia as soon as possible. Clean spray gun cap with MEK. Flush equipment with solvent to prevent rusting.

Follow manufacturer's safety recommendations when using any solvent.

SHELF LIFE

Shelf Life is applicable only for material stored in unopened and undamaged original factory filled containers.

Protect from freezing. Freezing will cause a dramatic increase in viscosity.

Minimum Storage Temp. 40°F / 4°C
Maximum Storage Temp. 95°F / 35°C

CM0481505: 1 year

PRODUCT LIMITATIONS

- High humidity will slow drying.
- Spray wet film for good film integrity.
- Customer must test on specific surface for performance because a wide variety of plastic and wood compositions exist in the marketplace.
- Do not exceed 4.0 mils total dry film to avoid mudcracking and improper drying.
- Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
- Do not shake or agitate violently because of tendencies to foaming and air entrapment.
- Keep container closed to prevent skinning of this fast drying coating.

- Do not use viscosity cups to measure viscosity, product should be applied at as heavy a viscosity as practical.
- Not intended for use on machine tool castings.
- Gloss topcoats will show decreased gloss when applied over this product, sand for best gloss holdout.
- Does not provide significant corrosion resistance to systems, not recommended where salt spray resistance is needed.
- On MDF, the surface profile of the substrate may telegraph through this product to the topcoat.

USE OF SYSTEMS STATEMENT

Sherwin-Williams Aerospace coatings have been developed and evaluated for use as complete systems. The Aerospace interior primers have been developed to be compatible with the JetFlex® coatings. Use of products not manufactured by Sherwin-Williams Aerospace as primer replacements is not recommended and could negatively affect coating appearance, inter-coat adhesion, chemical resistance, and durability of the finish. Use a complete Sherwin-Williams Aerospace system to ensure the long-term integrity of the coating.

HEALTH AND SAFETY INFORMATION

Consult the Material Safety Data Sheets for product information regarding health, physical and environmental hazards, handling precautions and "First Responder" first-aid recommendations.

PRODUCT INFORMATION

Please contact your Sherwin-Williams Aerospace Distributor or Representative for more information.

NOTE: Product Information Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Information 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.