



SHERWIN-WILLIAMS.

## AEROSPACE COATINGS

## PRODUCT DATA

# JetFlex<sup>®</sup> Water Reducible Sprayfil

## CM0481505

### ADVANTAGES

- One component water reducible coating.
- Excellent process times.
- Low VOC, less than 1.2 lbs./gal. (144 g/L)
- 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.
- No flashpoint.
- Reduce and clean up with water.

### DESCRIPTION

**JetFlex<sup>®</sup>** Water Reducible Sprayfil is a one-component, low VOC, acrylic latex developed to fill and hide profile and surface imperfections on foam plastics, metal and wood for aircraft interior application.

### COATING PROPERTIES

Solids:	Base Component
By weight	66.9% ± 1.8%
By volume	49.6% ± 2.0%
Wt./Gal.	12.6 ± 0.2 lbs.
Sp. Gravity	1.51 ± 0.02
Color	White
V.O.C.	
As Packaged, Maximum	1.2 lbs./gal (144 g/L)
Gloss:	
60 degree	10 max
Theoretical Coverage	
Per dry mil	795 sq. ft. <sup>2</sup> /gal.
Per 25 microns	19.5 m <sup>2</sup> /L
Dry Film Weight	
Per dry mil	.0106 lbs./ft. <sup>2</sup>
Per 25 microns	51.8 g/m <sup>2</sup>
pH	7.7 – 8.3

### 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. *Avoid freezing. Freezing may destroy product.*  
Maximum Storage Temp: 100°F / 37°C

CM0481505: 1 year

## SURFACE PREPARATION

**General:** Surface should be free of grease, dirt, fingerprints, rust and other foreign matter to insure optimum adhesion.

**Plastic:** Clean thoroughly to remove contaminants and mold release agents. Use isopropyl alcohol or other suitable solvent cleaner. Test system integrity before use or consult your Sherwin-Williams aerospace representative for additional information.

**Metals:** Chemical treatment such as Zinc or iron phosphate is recommended.

## MIXING INSTRUCTIONS

JetFlex® WR Sprayfil is a single component product. No mixing is required. Material should be stirred prior to using. Do not shake because of tendencies for foaming and air entrapment.

## APPLICATION

This product may be applied by conventional, airless, air assisted airless, HVLP or electrostatic methods.

1. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
2. Make sure pots, guns, and lines are purged and cleaned.
3. Mix thoroughly and filter strain before spray applying. Keep container closed to prevent skinning of this fast dry coating.
4. Do not over reduce. Water reducible enamels must be applied at a higher viscosity than solvent based enamels. They apply and atomize easier at a higher viscosity level.
5. Use low to moderate atomizing pressures to minimize bubbling and air entrapment.
6. Use the following settings:

### Conventional Spray:

Reducer: DI Water  
DI water reduction : As needed up to 5%

### Airless Spray:

Pressure 2000-2400 psi (138-165 bar)  
Tip .011-.013"  
Reducer DI Water  
DI water reduction : As needed up to 10%

### Air Assisted Airless:

Air Pressure 15-30 psi (1.05-2.07 bar)  
Fluid Pressure 850-950 psi (58.6-65.5 bar)  
Cap/Tip .011-.013"  
Reducer DI Water  
DI water reduction: As needed up to 10%

### HVLP

Air Pressure 8-9 psi (0.55-0.62)  
Fluid Pressure 6-9 psi (0.41-0.62)  
Reducer DI Water  
Reduction Rate As needed up to 10%

7. Spray wet film for good film integrity.
8. Recommended dry film thickness is 2.0-2.5 mils (50-63 microns) – Wet 5-6 mils (127-152 microns). Do not exceed 4.0 mils dry film to avoid mudcracking and improper drying.

NOTE: Application of these product systems requires recommended temperature / humidity conditions and film thickness ranges.

## DRYING SCHEDULE

Dry times are based on the dry film thickness of 2.0 mils (50 microns).

### Air Dry Times (75°F / 25°C and 50% RH)

To Touch	10-15 minutes
To Handle	20-25 minutes
To Sand	30-40 minutes
To Recoat	30-40 minutes
Force Dry (140°F/ 60°C)	30 minutes

NOTE: High humidity will slow drying.

## EQUIPMENT CLEANUP

Clean equipment and lines immediately with water. If dried, clean with a blend of water and ammonia as soon as possible. After cleaning, flush equipment with Ketone grade solvents to prevent rusting.

## USE OF SYSTEMS STATEMENT

Because of the many types and compositions of substrates available, each user should test the coating on each substrate before production use. Customers must also verify FAR/ JAR 25.853 regulation compliance on their substrate and system.

Not intended for use on machine tool castings.

Gloss topcoats will show decreased gloss when applied over this product. Sand for best gloss holdout.

## 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.