



ADVANTAGES

- Ideal for filling and covering composite surfaces and imperfections
- Meets the flammability requirements (heat release, smoke density and vertical burn) requirements of FAA FAR 25.853 up to 3 mils
- Excellent sanding characteristics
- Quick drying increases shop productivity
- Sand on product in under 30 minutes.
- Reduces process time for topcoat preparation
- Resistance to film shrinkage
- Simple 4:1 mix ratio
- Available in two colors – white and gray
- Easy to spray, spread or brush on the composite

JetFlex®

Interior Composite Filler

CM0981030 – Gray CM0981035 - White

DESCRIPTION

CM0981030 and CM0981035 are high quality two-component urethane fillers that provides performance, versatility and productivity. Sherwin-Williams' JetFlex® Composite Surface Fillers provides resistance to film shrinkage, easy sanding, flexibility and spreadability. This product is intended for use on interior composites for aircraft and parts and meets the flammability requirements of FAA FAR 25.853. These products are ideal to fill and cover surface imperfections to create a smooth surface for topcoat applications.

COATING PROPERTIES

Solids:	As applied
By weight	66.8% ± 1.0%
By volume	46.0% ± 1.0%
Wt./Gal.	11.70 ± 0.2 lbs.
Sp. Gravity	1.413 ± 0.02
Color	Gray and White
Viscosity–Sprayable	
Gardner Signature #2 Zahn Cup	18-20 seconds
ISO 2431 3mm	70-75 seconds
Admixed V.O.C. (Mixed 4:1:1 with CM0110944)	
U.S. Exempt Solvent	3.25 lbs./gal. (389 g/L)
Non-Exempt Solvent	3.89 lbs./gal. (467 g/L)
Useable Pot Life	
at 77°F / 25°C (CM0110102 or CM0110944)	2 Hours
at 77°F / 25°C (CM0110030)	30 Minutes
Theoretical Coverage	
Per dry mil	738 ft.² / gal.
Per 25 microns	18.11 m² / L
Dry Film Weight	
Per dry mil	0.01 lbs. / ft.²
Per 25 microns	54.76 g / m²

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

CM0981030:	7 years	CM0120677:	2 years	CM0110944	7 years
CM0981035	7 years	CM0110102:	7 years	CM0110030	7 years

SURFACE PREPARATION

Abrade the composite surface or filler with a 240 or 320 grit sandpaper or other comparable procedure.

Surface should be dry and free of oil, dust, or overspray.

MIXING INSTRUCTIONS

Shake primer component for 10-15 minutes before admixing.

Admix by Volume:

- | | |
|----------------|--|
| 4 Parts | JetFlex® Composite Surface Filler
CM0981030 or CM0981035 |
| 1 Part | Primer Hardener
CM0120677 |
| 1 Part | Reducer (Select from below)
CM0110102 - Standard Reducer
(Recommended use)
or
CM0110944 - US Exempt Reducer
(For low VOC use)
or
CM0110030 - Accelerated Reducer
(For Touch-Up Use) |

For spreadable use, add Hardener only. Always add the Hardener into the Primer Component.

For sprayable application, add the required volume of Reducer.

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 equipment and HVLP. Please consult your Sherwin-Williams representative for specific equipment settings

1. Make sure guns are purged and cleaned.
2. Mix thoroughly and filter strain before spray applying.
3. Apply 2 or more medium/wet coats at a gun distance of 5" to 7".
4. Allow each coat to flash 5 to 10 minutes.
5. 6-9 psi HVLP / 25-45 psi Conventional.

Always air-blow and tack-wipe the surfaces to be painted.

Best spray application results are obtained by applying two or more smooth medium-wet coats with 5-15 minutes between coats.

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 up to 5 mils (125 microns).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min</u>
To DA (orbital) Sand (using CM0110102)	1-2 Hours
To DA (orbital) Sand (using CM0110030)	45 Minutes

<u>Force Dry</u> (140°F / 60°C)	
To DA (Orbital) Sand (using CM0110102)	30 Minutes
To DA (Orbital) Sand (using CM0110030)	20 Minutes

With composites, if force curing it is recommended that the composite be degassed prior to application of the filler.

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

SANDING RECOMMENDATIONS

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

Note: Once sanded, topcoat within 7 days. After 7 days, solvent clean and scuff.

If the cured primer is inadvertently sanded through, a light coat of corrosion primer as a spot repair 0.5 mil (12 microns) will be required prior to spraying topcoat. Allow primer to dry a minimum of 30 minutes before overcoating.

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


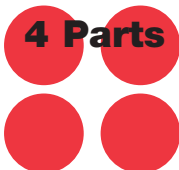




Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent 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.

JetFlex® Interior Composite Filler

CM0981030 (Gray)

CM0981035 (White)

- 1** Shake the CM0981030 or CM0981035 for 10-15 minutes before admixing.
- 2** Add in order shown below. The Adduct and reducer should be mixed into the primer component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0981030 Composite Filler - Gray CM0981035 Composite Filler - White	4 Parts 	4 Gal.	1 Gal.	15.2 L	3.8 L
 CM0120677 Epoxy Adduct	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0110102 Reducer	1 Part 	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** For repairs or touch-up areas, use CM0110030 Accelerated Reducer in place of the CM0110102 Reducer.
- 4** Filter strain and apply.