



JetFlex[®] Polyurethane Primer

CM0480930

ADVANTAGES

- Excellent adhesion to plastic substrates.
- Excellent sealing properties.
- Ease of application.
- Excellent intercoat adhesion with JetFlex[®] topcoats.
- Meets the performance requirements of Boeing BMS 10-83, Type IV.

DESCRIPTION

CM0480930 JetFlex[®] Primer is a white, two-component polyurethane coating designed for aircraft interior plastic substrates. This product is used as a primer to promote adhesion for the JetFlex[®] Aircraft Interior Finish. Meets the performance requirements for Boeing BMS 10-83, Type IV.

COATING PROPERTIES

Solids:	Base Component
By weight	54.1 ± 2.0%
By volume	35.6 ± 1.9%
Wt./Gal.	10.3 ± 0.25 lbs.
Sp. Gravity	1.23 ± 0.02
Color	White
Admixed V.O.C. (Mixed 7:1:4)	
U.S. Exempt Solvent	<5.4 lbs./gal. (647 g/L)
Non-Exempt Solvent	<5.4 lbs./gal. (647 g/L)
Useable Pot Life at 77°F / 25°C	16 Hours
Theoretical Coverage	
Per dry mil	403 ft. ² / gal.
Per 25 microns	9.88 m ² / L
Dry Film Weight	
Per dry mil	0.0093 lbs. / ft. ²
Per 25 microns	45.2 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

CM0480930: 2 years
CM0120930: 1 year
CM0110845: 7 years

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

Shake primer component for 10-15 minutes before admixing.

Admix by Volume:

7 Parts	Polyurethane Primer CM0480930
1 Part	Primer Catalyst CM0120930

Add the Catalyst into the Primer Component.

Reduce approximately 50% with CM0110845 JetFlex Reducer if needed.

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, HVLP, Graco Pro 4500 air electrostatic, or Graco Pro 4500 air assisted airless electrostatic. Please consult your Sherwin-Williams representative for specific equipment settings.

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.
4. Equipment
Pressure Gun: DeVilbiss or equivalent
Tip: E
Air Cap: 704
Pot Pressure: 5-10 psi (0.35 – 0.69 bar)
Atomizing: 45-50 psi (3.10 – 3.45 bar)
5. Best results are obtained by a double wet cross coat application.
6. Recommended dry film thickness is 1.0-1.1 mils (25-28 microns) – Wet 3.8 – 4.2 mils (96 - 106 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 1.0-1.1 mils (25-28 microns).

<u>Air Dry Times</u> (75°F / 25°C and 50% RH)	<u>Min.</u>	<u>Max.</u>
Dust Free	15 minutes	
Dry Through		1 Hour

Bake 30 minutes at 140°F (60°C) recommended for complete cure.

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.

USE OF SYSTEMS STATEMENT

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

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.