



Jet Glo Express™

840 Series Factory Packed Colors
Y and Z Intermix Colors

ADVANTAGES

- Qualified to SAE AMS 3095.
- Qualified to MIL-PRF-85285D, Type I, Class H. (See Jet Glo Express 1:1 series Product Data Sheet for details.)
- Fast dry times. (Improves shop processing flow)
- Same proven performance as Jet Glo®, but in a high solids system.
- Good buffing characteristics.
- Chemical resistant, including Skydrol and other hydraulic fluids.
- Superior stain resistance.
- Exhibits outstanding gloss, and gloss retention upon weathering.
- Excellent flow and leveling.
- Excellent Distinctness of Image (DOI).
- Contains less than 3.5 lbs/gal. (420 g/L) of VOC.
- Very low HAPS content - <2% by weight.
- Free of lead and chromate hazards.
- A comprehensive solid color palette is available.

DESCRIPTION

Jet Glo Express™ is a high-performance, four-component polyester urethane, designed for exterior use on high performance general aviation and commercial aircraft. This coating is qualified to SAE International's AMS 3095 and MIL-PRF-85285D, Type I, Class H.

COATING PROPERTIES

Solids:	Base Component	Admixed
By weight	61.6 - 85.8%	57.9 - 68.7%
By volume	52.4 - 72.6%	49.9 - 53.3%
Wt./Gal.	8.3 - 13.1 lbs.	8.2 - 10.3 lbs.
Sp. Gravity	0.996 - 1.572	0.984 - 1.236

Viscosity–Sprayable

Gardner #2 Zahn Cup (Signature Series)	16-20 seconds
ISO 2431 3mm Cup –Sheen	45-65 seconds

Admixed V.O.C.

Mixed 2:1:1:1 for “Y” Colors (90%+ white) or Mixed 2:1:1:1/2 for “Z” Colors Using CM0110093, CM011099, CM0110208 or CM0110944	
U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)

Useable Pot Life

at 77°F / 25°C, 0-65% R.H. (CM0840A01)	4 Hours
If using CM0840A07 Activator	1.5 Hours

Gloss:

60 degree	90+ units
20 degree	80+ units

Theoretical Coverage

Per dry mil	800-960 ft. ² / gal.
Per 25 microns	19.6 - 23.6 m ² / L

Dry Film Weight

Per dry mil	0.0059 – 0.0083 lbs. / ft. ²
Per 25 microns	29 - 41 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

CM0840XXX (Y or Z-colors) Base Component: 3 years

CM0840081: 2 years

CM0840A01: 2 years

CM0840A02: 2 years

CM0840A03: 2 years

CM0840A05: 2 years

CM0840A07: 2 years

Reducers - CM0110093, CM0110099, CM0110208, and CM0110944: 7 years

Aerosol Touch –up Kits: 1 year, Cool, Dry Storage Required.

SURFACE PREPARATION

Primed Surface

Jet Glo Express™ should be applied to a surface that has been coated with an approved, properly prepared and applied Sherwin-Williams Aerospace primer system.

Refer to Sherwin-Williams Corrosion Primer and Sanding Surfacers Product Data Sheets data sheets or contact your Sherwin-Williams Representative for complete details.

Topcoat Surface

For best adhesion to trim colors or repairs, the Jet Glo Express surface should be thoroughly abraded (no gloss) with 240 or 320 grit sandpaper and/or red abrasive pads once it is cured (dry-to-tape) and sandable.

MIXING INSTRUCTIONS (FOUR PART MIX)

Shake color component for 10-15 minutes before admixing.

Admix by Volume:

2 Parts	Jet Glo Express™ Color (Y- and Z- Intermix Color Numbers)
1 Part	Jet Glo Express™ Hardener CM0840081
1 Part	Jet Glo Express™ Activator* See Activator Selection below.
% Part	Jet Glo Express™ Reducer See Solvent Selection below

Note: The fourth component solvent addition is required to reduce to acceptable spraying viscosity and pot life.

Add the Hardener and Activator into the Base Component.

Admixed product should be allowed a 30-minute induction time for optimum application performance.

ACTIVATOR SELECTION

* **Available Activators for 6-8 Hr Tape Times:**

<u>Temperature</u>	<u>Relative Humidity</u>	
	<u>0 - 65%</u>	<u>65% +</u>
60-75°F (16-24°C)	CM0840A07	CM0840A05
70-85°F (21-30°C)	CM0840A05	CM0840A03
80 - 95°F (27-35°C)	CM0840A03	CM0840A02
95°F+ (35°C+)	CM0840A01	CM0840A01

If force curing (up to 180°F/ 85°C), use CM0840A01 Activator.

NOTE: CM0840A02 may also be used in cooler, low humidity conditions (below 0-65%) where an extended wet edge is required. Example: A full fuselage respray.

SOLVENT SELECTION

Y- colors, (above 90% of white pigment content)

Use ¾ part up to a maximum of 1 part addition solvent

Z- colors, (below 90% of white pigment content)

Use ¼ part up to a maximum of ½ part addition solvent

Note: Refer to can label to establish Y or Z code

Select from one of the available Jet Glo Express™ Reducers:

CM0110944	Fast Reducer
CM0110099	Medium Reducer
CM0110208	Medium Reducer (Ideal for Riveted aircraft)
CM0110093	Slow Reducer

Note: CM0110208 may also be blended with any of the above solvents to control post flow.

This additional reduction may change the application VOC to greater than 3.5 lbs./gal. (420 g/L).

CM08181HR Accelerator can be used for spot-in and repair. Please see attached Spot-In and Touch Up Procedure product mixing guide for details.

SPECIAL HIDING COAT MIXING

Establish that the final color requires the high hide system by pre-spraying **Black and White** coupons for acceptable opacity & color match to customer's specifications before the aircraft repaint.

In order to improve opacity for weak hiding strong organic (Z) colors, the following system may be used to achieve full opacity in 2-4 coats. This system should be used in color matching in order to minimize possible color discrepancies.

Hiding coat mixing (by Volume):

ZXXXXX (Final Color)	1 Part
CM0840103 Matterhorn White	1 Part

This hiding coat color is mixed at the following ratio: 2:1:1:1/2

Apply one closed film coat of the hiding coat. Allow 30-45 minutes to dry followed by two to three medium wet coats of the true topcoat color. Allow 30-45 minutes between coats.

Note: Activator choice, high / low temperatures, air flow, & AC skin temperature will influence intercoat overcoating times.

Touch test: Touch a suitably masked but painted area, Express is ready to recoat when it will not readily transfer to a gloved hand.

APPLICATION

This product can be applied using conventional airspray, HVLP, electrostatic airspray or air assisted airless equipment. Consult your Sherwin-Williams representative for specific equipment settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix thoroughly and filter strain before spray applying.
3. Equipment Settings (i.e. Conventional settings):
Spray atomizing pressure: 50-60 psi (3.45-4.15 bar)
Pot pressure: 10-12 psi (0.69 – 0.83 bar) using a 60' fluid hose (3/8" diameter)
Delivery Rate: 8-10 fluid oz (236-295 mL) per minute

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

Electrostatic users: Ensure that the aircraft is properly grounded for potential static buildup.

Best application results are obtained by applying two medium wet coats, allowing a 30-45 minute "tack-off" period between coats.

Once dry to tape, it is recommended that the surface should be thoroughly abraded with 240 or 320 grit sandpaper and/or red abrasive pads.

Recommended dry film thickness is 2-3 mils (50-75 microns).

Note: Certain colors may require thicker films to achieve complete hiding.

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 2-3 mils (50-75 microns) and mixed according to the activator instructions identified above.

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

Tack Free	3-4 Hours
To Tape	6-8 Hours

Recoat Time: (maximum) 24 Hours

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.

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.