



Jet Glo Express™

840 Series Factory Packed Colors Y and Z Intermix Colors

ADVANTAGES

- 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.
- 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.
- Unlimited colors available.

DESCRIPTION

Jet Glo Express™ is a high-performance, multi-component polyester urethane, designed for exterior use on high performance general aviation and commercial aircraft. This coating was designed to meet performance requirements of MIL-PRF-85285 Revisions C and D, AMS 3095A, BMS 10-72, BAMS 565-009, Type II, Class A.

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)		
U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)	
Non-Exempt Solvent	<3.5 lbs./gal (420 g/L)	
Useable Pot Life		
at 77°F / 25°C	4 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	CM0840A00:	2 years
CM0840A03:	2 years	CM0840A05:	2 years
		CM0840A01:	2 years
		CM0840A07:	2 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 Primer Product Data Sheets (High Solids Corrosion Primers CM0483928 and CM0483505 and Sanding Surfacers CM0480920 and CM0481810); training guides; and your Sherwin-Williams Representative for complete details.

Topcoat Surface

For best adhesion of trim colors to the cured urethane base coat, a thorough scuff sanding is recommended. Scuff sanding and cleaning will assure long-term durability and adhesion of the applied coating. Refer to Sherwin-Williams' process and training guides for cleaning.

MIXING INSTRUCTIONS

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*

* Available Activators for 6-8 Hr Tape Times:

Temperature	Relative Humidity	
	0 - 65%	65% +
60-75°F (16-24°C)	CM0840A07	CM0840A05
70-85°F (21-30°C)	CM0840A05	CM0840A03
80 - 95°F (27-35°C)	CM0840A03	CM0840A01
95°F+ (35°C+)	CM0840A01	CM0840A00

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

Add the Hardener and Activator into the Base Component.

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

Check viscosity. If a lower viscosity is needed, reduce with CM0110093 Jet Glo Express Reducer, up to a maximum of ½ part.

It is recommended to filter strain admixed and reduced paint before placing material in containers for spraying.

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

HIDING COAT

In order to improve on opacity for weak hiding strong organic colors in Jet Glo Express, the following system may be used to get hiding in 2-3 coats. This system should be used in color matching as well in order to minimize possible color discrepancies.

Hiding coat* for Yellow Mixes (Mix by Volume):

ZXXXXX (Final Color)	2 Parts
CM0840040 Yellow Oxide Base	1 Part
CM0840000 White Base	1 Part

Hiding coat* for Red and Orange Mixes (Mix by Volume):

ZXXXXX (Final Color)	2 Parts
CM0840059 Light Red Oxide Base	1 Part
CM0840000 White Base	1 Part

*This hiding coat color is still mixed 2:1:1 for application. Apply the hiding coat followed by two coats of the final color.

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. Make sure pots, guns, and lines are purged and cleaned.
2. Mix thoroughly and filter strain before spray applying.
3. 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
3. Always air-blow and tack-wipe the surfaces to be painted. Assure that the aircraft is properly grounded for potential static buildup.
4. Best application results are obtained by applying two medium wet coats, allowing a 30-45 minute "tack-off" period between coats.
5. If the dry time between coats exceeds 24 hours, the surface should be thoroughly abraded.
6. Recommended dry film thickness is 2-3 mils (50-75 microns). Some 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).

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.

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- 1** Shake the color component CM0840XXX - Factory packed colors or YXXXXX or ZXXXXX - Intermix colors for 10 - 15 minutes before admixing.
- 2** Add in order shown below. The Hardener and Activator should be mixed into the color component. Stir as components are added.





Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0840XXX or YXXXXX or ZXXXXX Color	2 Parts	2 Gal.	1 Qt.	7.6 L	.95 L
 CM0840081 Hardener	1 Part	1 Gal.	1 Pt.	3.8 L	.48 L
 CM0840AXX Select appropriate Activator from chart below:	1 Part	1 Gal.	1 Pt.	3.8 L	.48 L

Relative Humidity 0-65%	Relative Humidity 65%+	Temperature
CM0840A07	CM0840A05	60-75°F (16-24°C)
CM0840A05	CM0840A03	70-85°F (21-30°C)
CM0840A03	CM0840A01	80-95°F (27-35°C)
CM0840A01	CM0840A00	95°F+ (35°C+)

- 3** Allow admix to induct 30 minutes.
- 4** Check viscosity. If a lower viscosity is needed, reduce with CM0110093 Jet Glo Express™ Reducer, up to a maximum of 1/2 part.
- 5** Filter strain and apply.

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Spot-In & Touch Up Procedure

Order of Addition		Volume
	CM0840XXX or YXXXXX or ZXXXXX Color	2 Parts
	CM0840081 Hardener	1 Part
	CM0840A03 Activator	1 Part
	CM08181HR Accelerator	1/2 Part

If further reduction is needed, use only CM0110093 Jet Glo Express™ Reducer.

Repair Instructions:

- 1 For best results, the repair process should be done using a two gun method.
- 2 Apply the Jet Glo Express™ over the repaired area carrying out the wet edge just beyond the repair.
- 3 If needed, apply second coat to achieve hiding of the color.
- 4 Lightly feather the outer edge of the repair.
- 5 Immediately after the final coat, melt the feathered edge using CM0110510 Spot-In Thinner.

Buffing Blend Area:

- 1 Allow finish to cure at least two hours before buffing or sanding. (High mils will require a longer dry time.)
- 2 If sanding is needed, use 2000 or 2500 grit paper wet.
- 3 Buff Blend Area by mechanical polisher using a machine glaze. Be sure to polish away from the outer edge of the repair.