

## Sherwin-Williams Aerospace Jet Glo Express™ Spot-In Repair Procedure

The following procedure identifies three different levels of repair:

- Primer and Topcoat Repair (damage through to the substrate)
- Topcoat Repair (no priming required)
- Polish (scratches, orange peel, etc.)

### **Primer and Topcoat Repair:**

- Identify area for repair.
- Use P320 D/A papers to abrade the IMMEDIATE area identified for repair.
- Use Farecla P1500 wet & dry papers dampened with clean water or a D/A fitted with 1500 papers to abrade the P320 repaired area & un-sanded surrounding area (Use a 1 to 3 ratio, **See Key below**).
- Degrease the area using an appropriate cleaning solvent such as IPA (Isopropyl Alcohol) or Ketone blend.
- Mix corrosion resistance primer as per product data sheet.
- Apply over repair area only.
- Allow to air dry (2 hours).
- **Primer force drying option:** Apply heat using Infrared Hotspot lamp to primer area for 5 minutes, simultaneously laser the surface to monitor the surface temperature, DO NOT exceed surface skin temperature of 150°F / 60°C.
- Use 1500 wet and dry of 1500 D/A papers to lightly abrade the primer area.
- Use Farecla Profile 200 Cut Compound (Product 57035) to abrade un-sanded topcoat around the immediate area.
- Solvent wipe the area using IPA
- **Jet Glo Express Mixing Options:** Mix Express as per the Product Data Sheet using Activator CM0840A05 or CM0840A07. Reduce with CM0110093 or CM0110099 Reducer. Allow a 15-minute induction.
- Apply two light coats over the sanded repair area only.
- Allow 5 minutes to flash off between coats.
- Add 50% by volume of CM0110093 or CM0110099 Reducer to the above admixed paint and stir thoroughly.
- Extend one coat past the first two coats.
- Allow a 5-minute flash off and then allow to air or force dry.
- **Topcoat force drying option:** Apply heat using Hotspot lamp to area, simultaneously last the surface, DO NOT exceed surface skin temperature of 150°F / 60°C

**Key:** 1-to 3 ratio area. The area for repair should be 1/3<sup>rd</sup> of the area that is prepared for the fade out.

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## Topcoat Repair:

- Identify area for repair.
- Use P320 D/A papers to abrade the IMMEDIATE area identified for repair.
- Use Farecla P1500 wet & dry papers dampened with clean water or a D/A fitted with 1500 papers to abrade the P320 repaired area & surrounding area (Use a 1 to 3 ratio, **See Key below**).
- Use Farecla Profile 200 Cut Compound (Product 57035) around sanded area.
- Degrease the area using an appropriate cleaning solvent such as IPA (Isopropyl Alcohol) or Ketone blend.
- **Jet Glo Express Mixing Options:** Mix Express as per the Product Data Sheet using Activator CM0840A05 or CM0840A07. Reduce with CM0110093 or CM0110099 Reducer. Allow a 15-minute induction.
- Apply two light coats over the sanded repair area only.
- Allow 5 minutes to flash off between coats.
- Add 50% by volume of CM0110093 or CM0110099 Reducer to the above admixed paint and stir thoroughly.
- Extend one coat past the first two coats.
- Allow a 5-minute flash off and then allow to air or force dry.
- **Topcoat force drying option:** Apply heat using Hotspot lamp to area, simultaneously last the surface, DO NOT exceed surface skin temperature of 150°F / 60°C

## Polishing:

- Use Farecla 1500 or 2000 Abrasive papers to abrade the newly repaired/original area to remove the gloss.
- Wipe area dry on a regular basis to check that the orange peel / profile represents the original profile of the surrounding area.
- Apply appropriate Farecla products as identified below:
  1. **For Y-Colors**  
Apply Farecla **Advanced Total** onto the surface by hand over the sanded / surrounding area.
  2. **For Z-Colors especially dark colors such as black and navy**  
Apply Farecla **G10** onto the surface by hand over the sanded / surrounding area.
- Spray on clean water.
- Use an Electric Polisher/Buffer @ 1500 / 1800 rpm fitted with a lambs wool head to apply light pressure to the surface, keep the polisher moving in sweeping motions across the repair.  
**Note:** Do not excessively polish the feathered edge of the localized paint repair  
**Note:** Do not allow the panel to get too hot to the touch
- Remove any excess polish by hand on a regular basis and observe the gloss recovery.
- Repeat as necessary.

**Note:** Farecla products are available from Sherwin Williams Aerospace and its distributor network. Search [www.swaerospace.com](http://www.swaerospace.com) for a list of locations.