SHERWIN-WILLIAMS

AEROSPACE COATINGS

PRODUCT DATA

Fill Bond™ Aerospace Putty

Epoxy Version

CM0480007

EP007 and EP007S Cartridges

ADVANTAGES

- Designed specifically for use in the aerospace industry.
- Excellent spreadability and sandability with high film build.
- The unique cartridge application accurately admixes the product, reduces prep time and eliminates waste.
- Extremely flexible.
- Sand in 2-6 hours.
- 20 minute workable pot life.
- Sag resistant.
- VOC compliant - contains less than 2.9 lbs. of VOC per mixed gallon or 350 grams per liter.
- Designed to properly adhere to aircraft substrates such as aluminum and composites.

DESCRIPTION

Fill Bond™ Aerospace Putty is a high build filler ideal for filling seams, rivets and small spot repair areas. Fill Bond provides good adhesion to properly pretreated aluminum and composites. It is chrome and lead hazard free as well as free of isocyanates. It has excellent spreadability, flexibility and film build up which makes it an excellent alternative for conventional Polyester body filler.

COATING PROPERTIES

Solids:	**Base Component**	**Admixed**
By weight	82.7%	82.7%
By volume	70.5%	71.7%

Admixed V.O.C.	
U.S. Exempt Solvent	2.05 lbs./gal.(246 g/L)
Non-Exempt Solvent	1.99 lbs./gal.(238 g/L)
Color:	Light Gray
Workable Pot Life at 77°F / 25°C, ≤ 50% R.H.	15- 20 min
Theoretical Coverage	
Per dry mil	1122 $ft.^2$/gal.
Per 25 microns	27.5 m^2/L
Dry Film Weight	
Per dry mil	0.0086 lb. / $ft.^2$
Per 25 microns	42.2 g / m^2

SHELF LIFE

Shelf Life is applicable only for materials stored in unopened and undamaged original factory filled containers.

Minimum Storage Temp. 40ºF / 4ºC
Maximum Storage Temp. 100ºF / 37ºC

CM0480007:	3 years
CM0120007:	1 year
EP007 and EP007S:	1 year from date of package

SURFACE PREPARATION

Fill Bond can be applied over pretreated aluminum, composite, or over preprimed areas using as a Sherwin-Williams corrosion resistant primer. For optimum adhesion and corrosion protection of aluminum substrates, it is recommended to apply Fill Bond over a primed substrate.

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

Fill Bond should be applied over the selected corrosion preventative primer within 12 hours of the primer application at 77ºF (25ºC). If overnight cured (>16 hours), a light scuff sanding or Scotchbriting is recommended.

MIXING INSTRUCTIONS

Admix by Volume:

4 Parts	Epoxy Primer **CM0480007**
1 Part	Epoxy Adduct **CM0120007**

Proper mixing is achieved by dispensing from a cartridge through a static mixer.

CARTRIDGE APPLICATION

- Shake any new or partially used cartridge for 5 minutes before every use.
- Remove retaining cap and inserts from cartridge nozzle.
- Affix static mixer to cartridge nozzle.
- Tighten retaining cap securely onto cartridge threads
- Insert cartridge into manual or pneumatic dispensing gun housing.

To begin using, point cartridge assembly up and slowly dispense material into the static mixer. Dispense first 6 inches (15 cm) of unmixed material into waste container. Repeat this process for each new or partially used cartridge.

For detailed instructions on cartridge use, refer to the dispensing gun manufacturer's operating instructions.

If the cartridge is not used for 10-15 minutes, the static mixer should be replaced.

Discard used static mixer, clean cartridge, and return inserts and retaining cap for proper storage.

Material can be dispensed directly to the area to be filled or onto a CS100W Clean Sheet Mixing Board.

APPLICATION

1. Air blow and tack cloth wipe with a urethane grade tack cloth. Area does not need to be wiped with a damp solvent rag unless the sanded surface has been contaminated.
2. Fill Bond can be spread over the substrate with a putty knife, semi-rigid plastic spreader (such as AC91111) or rigid edge applicator.
3. Spread a uniform thin coat of the mixture on the area in one direction applying pressure to eliminate air/pinholes. Taper the material beyond the area to be filled.
4. If necessary apply a second coat after 50-60 min air-drying, in a cross direction from the first coat. Taper the material beyond the filled area. Multiple coats of dry film thickness could be built up to 50 mils (1250 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 55ºF / 13ºC before, during, and after application.

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2-10 mils (50-250 microns).

Air Dry Times

(77°F / 25°C, 50% RH)

Tack free	50-60 Minutes
Light sanding	2-6 Hours
DA (Orbital) Sanding	8-12 Hours

Force Dry Times

(120°F / 49°C, 50% RH - Allow 30 min. flash prior to bake)

Light sanding	15-25 Minutes
DA (Orbital) Sanding	2 Hours

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

SANDING RECOMMENDATIONS

Proper sanding is required for good intercoat adhesion. It is recommended to sand using a 220, 240 or 320 grit paper. After sanding, an intermediate primer or surfacer is recommended for optimum appearance.

If the primer is inadvertently sanded through, a spot repair will be required prior to spraying topcoat.

Maximum recoat time after sanding: Up to 7 days.
After 7 days, solvent clean the area if necessary, re-scuff and sand.

EQUIPMENT CLEANUP

Use clean Ketone–type solvents such as CM0110308 MEK.

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.