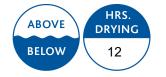
Technical datasheet EN- 403 Epifanes Epoxy Filler 1500

Shrink free two-component epoxy filler





PRODUCT DESCRIPTION

A very strong two-component chemical and water resistant filler based on epoxy resins. This filler is 100% shrink free and has a low odor. It can fill up to 1.5 cm in one single application

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Field of use: It can be used on all surfaces with minimal movement. It can fill small holes in the gelcoat underneath the waterline before it is overcoated. Also for filling holes above the waterline this is an excellent filler to smooth out the surface. It can be overcoated with Epifanes Epoxy Primer, Poly-urethane Primer and even Epifanes Multi Marine Primer. When the hole is larger than 1 by 1 cm it is advised to use a primer before application. Otherwise the Filler can be applied directly to the surface.

PRODUCT INFORMATION				
Туре	Chemisch drogend			
Base	Phenol free epoxy			
Colour	Light Grey			
Density at 68°F.	1,50 kg. / dm³ (After mixing)			
Packaging	500ml. + 250ml. = 750ml. 1000ml. + 500ml. = 1500ml.			
Shelf life	In closed unopened container stored in a dark location between 41 - 77°F approx. 3 years.			
Mixing ratio		In volume	In weight	
	Base A Hardner B	100 50	100 50	
Mixing	Stir up the individual components before mixing them together.			
Time for application	54°F.	68°F.	82°F.	
	40 min.	30 min.	10 min.	
	Potlife depends on the amount of product that is mixed together			
Application	Filling knife.			
Environment	Conditions during application Temperature minimal 54°F maximal 86°F. Relative air humidity minimal 50% - maximal 85%			
	Do not apply wet-in-wet. There can not be to much temperature difference between the surface and the filler. Also, the surface temperature has to be at least 38°F above dew point.			
Surface preparation	All surfaces have to be dry and clean. Contamination on the surface like any form of oil or waist can prevent adhesion to the surface. FRP structures have to be at least 14 days old and free from paraffin. Small scratches and holes can be filled directly after cleaning and sanding with a course grid. Larger segments has to be primed first. Apply the Epoxy Primer first on to the surface and sand this with a medium to course grid after drying.			
Coverage	1000ml. / 11ft ² by 0,5 mm filn			
Max. film thickness	Maximum 15 mm. in one appli	cation		
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Suitable primers	Epifanes Epoxy Primer - Epifanes Epoxy HB Coat - Epifanes Multi Marine Primer (after curing for at least 72 hours.)			
Drying	54°F.	68°F.	82°FC.	
Sandable	36 hours	24 hours	18 hours	
Recoatable	36 hours	24 hours	18 hours	
Chemically dried	72 hours	60 hours	48 hours	
Notes on drying	 Higher or lower temperatures will considerably accelerate or reduce the curing process. slow down and may affect the reaction and properties of the product. If drying takes place at temperatures below 68°F. in combination with a high relative humidity, the absorption of moisture into the surface can create an adhesive layer (so-called amine blush). This is due to the hygroscopic properties of the hardener type. This top layer must always be removed before sanding the primed parts. by wiping well with water + vinegar, water + ammonia, Epifanes Cleaning Thinner, Epifanes Fiberglass Degreaser or acetone. 			
Sanding	It is important to clean the surface well with Epifanes Cleaning Solvent or Acetone. This to prevent any amine blush. After cleaning, sand the surface with 120G dry.			
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Recoatablility	One component	Two component
Above the waterline	Epifanes Multi Marine Primer	Epifanes Epoxy Primer Epifanes Epoxy HB Coat Epifanes Poy-urethane Primer
Below the waterline	Epifanes Antifouling Primer CR	Epifanes Epoxy Primer Epifanes Epoxy HB Coat Epifanes Interimcoat
Additional remark	Incase the filler is applied in multiple coats, it before application of the next coat.	t is essential to clean and sand every coat

Allthough the facts and suggestions in this product information sheet are based on our own research and field experiences and are believed reliable, we cannot simply be held responsible for performance or results obtained through the use of this product. Ineffectiveness or other unintended consequences may result, because of such factors as weather, conditions, presence or other materials or the manner of preparation, use or application all of which are beyond W. Heeren & Zoon's control. All such risks are assumed by user.

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