

1. Introduction

ALEXSEAL Spray Fair 328 is an epoxy-based, 2 components sprayable filler, which provides the ideal product for yachts that require filling and fairing. ALEXSEAL Spray Fair 328 has excellent application, sanding and anti-sagging properties. It is designed to be easy to mix and apply, while the cured film provides an excellent surface for re-coating with other ALEXSEAL products.

2. Range of application

ALEXSEAL Spray Fair 328 is used for fairing all primed and appropriately prepared surfaces. It can be used for surfaces above the waterline only.

3. Color

Color of mixture: Tan
Base material: Tan
Converter: Yellow

4. Coverage

Volume Solids catalyzed without reduction: 71 %

Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	@ DFT in μm (mils)
Theoretical	0.6	2.1	23	900 (36)
Practical				
Conventional Air Spray Equipment	0.5	2.0	22	900 (36)
HVLP Air Spray Equipment	0.6	2.4	26	900 (36)
Airless Equipment	0.7	2.8	30	900 (36)

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust, grease, oil and other contamination. To ensure optimum adhesion, the substrate must be ground and /or blasted with (P36 to P60 grit) before priming. Full fairing systems require a heavily abraded substrate. Thin fairing systems of less than 3 mm (1/8 - 0.012 inch) will require a less aggressive profile to anchor the system. Priming is required on most substrates before application of ALEXSEAL Spray Fair 328.

For **metal substrates** - optimum mechanical and corrosion resistance values are achieved by proper surface preparation and substrate priming with an ALEXSEAL Protective Primer 161.

For **GRP substrate**, use ALEXSEAL Finish Primer 442 or Super Build 302. The ALEXSEAL Primer should be sanded with P60 - P80 grit, after overnight dry, before application of ALEXSEAL Spray Fair 328.

For applications over substrates including epoxy resins, contact your ALEXSEAL representative.

6. Trade names & Packaging

P3280 ALEXSEAL Spray Fair 328 1 Gal
C3287 ALEXSEAL Spray Fair 328 Converter 1 Gal
R3040 ALEXSEAL High Build Epoxy Reducer 1 QT & 1 Gal

7. Mixing ratio

1 part by volume P3280 ALEXSEAL Spray Fair 328
1 part by volume C3287 ALEXSEAL Spray Fair 328 Converter
10 - 25 % reduction (vol.) R3040 ALEXSEAL High Build Epoxy Reducer
Example: 1 : 1 : 1/4 = 12.5% reduction
Example: 1 : 1 : 1/2 = 25% reduction

The amount of reducer required may vary depending on the application conditions.

8. Application

Note: Thick viscosity requires the use of a large nozzle and a pressure pot.
Fluid Nozzle Size Pressure Pot 2.2 - 2.8 mm (0.08 - 0.110 inch) - Conventional & HVLP
Atomizing Pressure 3.0 to 5.0 bar (44 to 73 PSI) - Conventional & HVLP

Professional Use Only

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Spray Fair 328

Technical Data Sheet: 153-30
P3280

Pot Pressure 1 to 1.5 bar (15 to 22 PSI) - Conventional & HVLP
 Airless Equipment Tip 0.50mm / 60° to 0.60mm / 60° (0.020 / 60° to 0.024 / 60°)
 Inlet Pressure 3 – 5 bar (44 to 70 PSI)

The components of ALEXSEAL Spray Fair 328 have different colors to ensure thorough mixing. After mixing, the color of the material should be a homogeneous tan color. If they are not mixed thoroughly, it could result in an improperly cured paint. Mixing can be done mechanically with a slow turning dough mixer or manually. The mixing in of air bubbles should be avoided.

Application by Spraying

Apply 3 coats to a wet film thickness (WFT) of 400 - 500 microns (16 - 20 mils) per coat. This will achieve a dry film thickness (DFT) of 700 - 900 microns (28 - 36 mils) for a 3 coat application, using up to 25 % reduction. Maximum dry film thickness per coat is 500 microns (20 mils). Maximum recommended film thickness during a spray application is 3 coats totaling 1500 microns (60 mils) WFT, or 900 microns (36 mils) DFT. Do not apply more than 3 coats without allowing to cure overnight and sanding the surface.

ALEXSEAL Spray Fair 328 should be block sanded with P80 – P120 grit. Block sanding with 120 grit or finer will help prevent sand scratch print through in the finished system.

Note: This is a solvent based sprayable fairing compound. Solvent entrapment can be caused by heavy film thickness when over coating too quickly with the same product or other products, and by low temperature or slow drying time. Mankiewicz Gebr. & Co. will not accept liability for any damages.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Time
Pot Life	8 hrs	8 hrs	8 hrs	8 hrs	8 hrs
Dry to sand	3 - 4 days	2 days	1 day	1 day	N/A
Fully cured	2 weeks	1 week	5 days	4 days	N/A
Recoat after tack up with additional ALEXSEAL® Spray Fair 328	4 hrs	2 hrs	1 hrs	1 hrs	24 hrs

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will affect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

Recoating of ALEXSEAL Spray Fair 328 over itself within the recommended times above is important to avoid trapping of solvents. Trapped solvents will cause blistering and splitting of this coating as well as retarding the time to sand. Max 3 coats in one application, sand after 24 hrs dry before additional application. ALEXSEAL Spray Fair 328 is porous. It must be sealed with ALEXSEAL Super Build 302 before applying a final primer or topcoat. ALEXSEAL Super Build 302 can be applied after the surface has been fully cured and block sanded with 80 to 120 grit. Finishing the fairing by block sanding with 80-120 grit or finer will help prevent sand scratch print through in the final finish.

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