

Epifanes Epoxy Finishing Filler

Shrinkfree fine epoxy finishing filler

Type	Chemical drying									
Base	Solvent and phenolfree epoxy resin									
Properties	A strong two-component finishing filler. Very fine and shrink free. Provides a very smooth surface. Apply in thin layers only.									
Field of application	Fiberglass/GRP - Steel - Wood - aluminum : a fine epoxy finishing filler on use on Epifanes Epoxy Filler 1500 in two-component paint systems above and if needed below the waterline.									
Colour	Light grey (mixed product)									
Density mixed product	1,70 kg/ dm³									
Packing	750ml.									
Shelf life unmixed	In closed container stored in a dark location between 41 - 77°F approx. 1 year.									
Mixing ratio	<table><tr><td></td><td>By volume</td><td>By weight</td></tr><tr><td>Base component A</td><td>100</td><td>100</td></tr><tr><td>Curing component B</td><td>50</td><td>50</td></tr></table>		By volume	By weight	Base component A	100	100	Curing component B	50	50
	By volume	By weight								
Base component A	100	100								
Curing component B	50	50								
Mixing instruction	Both components should be mixed separately and then together thoroughly until colour is uniform. No induction time									
Potlife after mixing	<table><tr><td>at 59°F</td><td>at 68°F</td><td>at 82°F</td></tr><tr><td>40 minutes</td><td>20 minutes</td><td>10 minutes</td></tr></table> Potlife is dependent on mixture volume	at 59°F	at 68°F	at 82°F	40 minutes	20 minutes	10 minutes			
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40 minutes	20 minutes	10 minutes								
Conditions during application and drying	Temperature minimal 54°F - maximum 82°F Relative air humidity minimal 50% - maximum 75% Temerature of substrate must be 5°F above dew point.									
Thinner	Do not thin									
Application tools	Filling knife.									
Coverage @ 0,1mm. filling filmthickness	750ml. / 4m²									
Surface preparation	Prefeably apply on degreased and sanded primer system. Do not apply directly on bare steel or bare aluminium. Application between primercoats is advised (sandwich). All surfaces must be dry, clean, free of wax, grease or other contamination.									

Fiberglass	Steel	Wood	Aluminium
At least 14 days old. Degreased with Epifanes Fiberglass Prep Cleaner and sanded with P220-280	Free of rust, well degreased and coarsly sanded with P60-80	Degreased with Spraythin-ner PV and sanded with P220-240	Well degreased and coarsly sanded with P60-80

Suitable primer Epifanes Epoxy Primer - Epifanes Epoxy HB Coat
Dry, cleaned, well degreased and sanded with P 120-150.

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Drying times @ 68°F / 65% RAH

Sandable	Recoatable	Through hardened
24 hours	24 hours	48 hours

Higher or lower temperatures will speed up / slow down the hardening and may influence the chemical reaction and properties of the product.

Drying at temperatures below 68°F combined with a high relative air humidity may cause the intake of humidity in the wet film leading to a amine blush on the surface. This sticky layer must be removed at all times using water with amonium, acetone or Epifanes Fibreglass Prep Cleaner.

Best sandable properties are between 24 and 48 hours.

Filmthickness

Max. 1 mm.

Suitable primer

Epifanes Epoxy Primer - Epifanes Epoxy HB Coat
Dry, degreased and sanded with P120-150

Recoatability

	Above the waterline	Below the waterline
One-comp.	Epifanes Multi Marine Primer	-
Two-comp.	Epifanes Epoxy Primer Epifanes Epoxy HB Coat Epifanes Interimcoat Epifanes Poly-urethane Primer	Epifanes Epoxy Primer Epifanes Epoxy HB Coat Epifanes Interimcoat

Application instructions

Prior to sanding this filler must be cleaned with a suitable degreaser or water with amonium. This will assist in the sanding. If the filler is applied in several layers, it is recommended to sand each layer with abrasive paper nr. 80-100. The final coat may be sanded with abrasive paper nr. 100-120.

Smaller repairs may also be topcoated with one-component primers/topcoats. Larger repair areas should always be topcoated with two-component primers/topcoats. If desired followed by a one-component finish.

Safety

The user of this product should obey all all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product.

Although 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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