

PRODUCT INFORMATION SHEET

Epifanes Epoxy Filler 1500

Shrinkfree epoxy filler

Type	Chemical drying
Base	Solvent and phenolfree epoxy resin
Properties	A very strong two-component chemical and water resistant light-weight filler based on epoxy resins. Shrink free, low odor. Can fill up to 1.5 cm. in one single application.
Field of application	Fiberglass/GRP - Steel - Wood - aluminum : in two-component epoxy systems above and below the waterline in conjunction with the appropriate primers.
Colour	Off white (after mixing)
Density mixed product	1,90 kg/ dm ³
Packing	750ml. - 1500ml.
Shelf life unmixed	In closed container stored in a dark location between 5 - 25°C. approx. 2 years.

Mixing ratio		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

Potlife after mixing	at 12°C	at 20°C	at 28°C
	45 minutes	30 minutes	15 minutes

Potlife is dependent on mixture volume

Conditions during application and drying
Temperature minimal 12°C. - maximum 28°C.
Relative air humidity minimal 50% - maximum 75%

Temperature of substrate must be 3°C. above dew point.

Thinner Do not thin

Application tools Filling knife.

Coverage @ 1/2mm. filling filmthickness 1000ml. / 1.1m²

Drying times @ 20°C. / 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 20°C. 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.

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Filmthickness Max. 1.5 cm. without sinking

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

Recoatibility

	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
Filler	Epifanes Epoxy Finishing Filler	

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.

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.

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. New polyester must be at least 14 days old and free of chemicals. Degrease bare fibreglass with Epifanes Fibreglass Prep Cleaner in order to remove all wax. In order to obtain a good adhesion to the rough side of fibreglass, it is necessary to first remove the waxy layer with Scotch-Brite.

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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