

PRODUCT DESCRIPTION

Epoxy Finishing Filler is a two-pack, shrink-free, finishing filler based on epoxy resins. It is both easy to apply and sand. Can be used above and below the waterline.

PRODUCT INFORMATION

| | |
|---------------------------|--|
| Colour | IAA650-Cream - Part A - White. Part B - Yellow. Mixed - Cream (approx. RAL 1015). |
| Finish | Matt |
| Specific Gravity | 1.65 |
| Volume Solids | 100% |
| Mix Ratio | 100 Part A : 51.5 Part B by Volume. 100 Part A : 50 Part B by Weight., Converter/Curing Agent - IAA651 |
| Typical Shelf Life | 1 yrs |
| Unit Size | 7.5 kg , 225 kg |

DRYING/OVERCOATING INFORMATION

Drying

| | 10°C | 15°C | 23°C | 35°C |
|----------|------|--------|-------|-------|
| Sandable | | 24hrs | 16hrs | 12hrs |
| Pot Life | | 30mins | | |

Note: Pot life reduces as temperature and mix volume increases. Pot life refers to the Working Pot Life. It is recommended not to prepare a larger volume than required for immediate use.

Overcoating Substrate Temperature

| Overcoated By | 10°C | | 15°C | | 23°C | | 35°C | |
|-----------------------------------|-------|-----|-------|-----|-------|-----|-------|-----|
| | Min | Max | Min | Max | Min | Max | Min | Max |
| Clear Wood Sealer - Fast Dry | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Clear Wood Sealer Std (Polygrond) | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Epoxy Finishing Filler | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Epoxy GP Coating | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Interprime 880 | 5days | - | 3days | - | 2days | - | 1days | - |
| Midcoat Flat HS | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Sikkens Epoxy Barriercoat GP | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |
| Sikkens Epoxy Heavycoat | 48hrs | ext | 24hrs | ext | 16hrs | ext | 16hrs | ext |

Note: All overcoating times are approximate. Overcoating Times are the Minimum Recoat Time with Sanding. When being overcoated, the surface must be dry, clean, grease- and dust-free.

APPLICATION AND USE

Preparation

PREVIOUSLY PAINTED SURFACES:

In Good Condition: Wash down with International's Super Cleaner, rinse with fresh water and allow to dry.

In Poor Condition: All previous coatings should be removed back to solid material and filled with Epoxy LG Filler.

EPOXY LG FILLER: Sand smooth. Remove all sanding residue using a clean air line and sweeping with a clean brush or broom. Vacuum clean for best results.

For further sanding recommendations please see the leaflet "The Importance of Good Sanding Practise".:

Method

Apply the filler by float, to ensure proper wetting and compression, it is necessary to pass a trowel over the wet filler coat from the bottom upwards and in the opposite direction, removing excess filler. Apply one or several coats of Epoxy Finishing Filler, depending on substrate deviation and profile required. Sand between coats with 120 grade (grit) paper. For sanding final layers refer to "The Importance of Good Sanding Practices" leaflet.

Hints

Mixing Ensure the correct volume mix ratio is used. If the components are too thick, e.g. due to

stockholding at lower temperatures, stir each component separately. Mix the components thoroughly until a homogeneous mix of a uniform colour is achieved.

Thinning Do not thin under any circumstances.

Cleaner Sikkens Epoxy Thinners or Degreaser (Oplosser).

Ventilation and Humidity Control To achieve sufficient curing, the maximum relative humidity should not exceed 80%.

Other The film thickness depends on many factors, such as roughness of the substrate, method and conditions of application. In the temperature range between 10°C and 15°C (under 10°C no curing will take place). A tacky coat may form at the surface after application. Sanding and adhesion properties may be affected if product applied and/or cured at temperatures between 10°C and 15°C. If product applied and/or cured at temperatures between 10°C and 15°C then the surface should be cleaned with lukewarm water or Epoxy Thinners and allowed to dry prior to application of subsequent coatings. To minimise potential formation of 'tacky coat', it is recommended to apply, allow to dry and cure Epoxy Finishing Filler at temperatures above 15°C. To prevent pores, apply the last Epoxy Finishing Filler coat in a thin layer.

Some Important Points

Ambient temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Substrate temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Product temperature should be no less than 10°C/50°F and maximum 35°C/95°F. The substrate temperature must be at least 3°C above the dewpoint to prevent condensation. It is recommended not to apply the product under adverse weather conditions. Coverage depends on several factors, including shape of the yacht, surface roughness, method of application being used and conditions of application. In underwater applications the filler system should always be over-coated with a complete underwater paint system (see individual specifications).

Compatibility/Substrates

GRP. Can be used over Epoxy GP Coating, Epoxy Heavycoat, Epoxy LG filler, Midcoat Flat HS or UC Gloss HS.

Number of Coats

As required

Coverage

(Theoretical) - 1.00 (m²/lt) @ a DFT of 1 mm.

Recommended DFT

1000 microns dry (2mm) vertical, 5mm horizontal substrate

Application Methods

Knife, Trowel, Batten, rule and float.

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage

GENERAL INFORMATION:

Exposure to air and extremes of temperature should be avoided. For the full shelf life of this product to be realised ensure that between use the container is firmly closed and the temperature is between 5°C/40°F and 35°C/95°F. Keep out of direct sunlight.

TRANSPORTATION:

The product should be kept in securely closed containers during transport and storage.

Safety

GENERAL: Avoid contact with skin and eyes. Epoxy Finishing Filler can cause dermatitic skin reactions. Always use gloves and goggles and keep skin protected with overalls. Any accidental skin contact should be immediately washed off with soap and water. Do not eat, drink or smoke in mixing or application areas. Wear suitable respiratory protective equipment. Read the label safety section for Health and Safety Information, also available from our Technical Help Line.

DISPOSAL: Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal.

Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit. Disposal of remainders must be arranged for in consultation with the authorities.

IMPORTANT NOTES

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no responsibility for the performance of the product or for any loss or damage (other than death or personal or injury resulting from negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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