

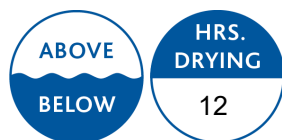
Technical datasheet EN- 403

Epifanes Epoxy Filler 1500

June 2022



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

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

Type Chemisch drogend

Base Phenol free epoxy

Colour Light Grey

Density at 20°C. 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 5 - 25°C approx. 3 years.

Mixing ratio

| | In volume | In weight |
|-----------|-----------|-----------|
| Base A | 100 | 100 |
| Hardner B | 50 | 50 |

Mixing

Steer up the individual components before mixing them together.

Time for application

| 12°C. | 20°C. | 28°C. |
|---------|---------|---------|
| 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 12°C. - maximal 30°C.
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 3°C 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. GRP 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. / 1.1m² by 0,5 mm film thickness

Max. film thickness

Maximum 15 mm. in one application

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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 | 12°C. | 20°C. | 28°C. |
|------------------|----------|----------|----------|
| Sandable | 36 hours | 24 hours | 18 hours |
| Recoatible | 36 hours | 24 hours | 18 hours |
| Chemically dried | 72 hours | 60 hours | 48 hours |

Remark drying Higher or lower temperatures will speed up / slow down drying of this filler and may have an influence on product features.

In case of drying at low temperatures in combination with high rel. air humidity, a sticky amine blush may be formed on the filler.

Always remove this amine blush before sanding the filler by washing down with water + vinegar and/or ammonium, Epifanes Cleaning Solvent 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 P120 dry.

| Recoatibility | 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 In case the filler is applied in multiple coats, it is essential to clean and sand every coat before application of the next coat.

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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