

Epoxy Finishing Filler Fillers



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 - Part A - White. Part B - Yellow. Mixed - Cream (approx. RAL 1015).
Finish	Matt
Specific Gravity	1.62
Volume Solids	100%
Mix Ratio	Part A : Part B - 100 : 57.5 by volume, 100 : 50 by weight
Converter/Curing Agent	IAA651
Typical Shelf Life	6 Months
VOC (As Supplied)	47 g/lit
Unit Size	2.5kg (Part B) / 5kg (Part A)

DRYING/OVERCOATING INFORMATION

	Drying			
	10°C (50°F)	15°C (59°F)	23°C (73°F)	35°C (95°F)
Sandable	48 hrs	24 hrs	16 hrs	12 hrs
Pot Life	75 mins	60 mins	55 mins	25 mins

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.

Overcoated By	Overcoating Substrate Temperature							
	10°C (50°F)		15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max	Min	Max
Epoxy Finishing Filler	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Epoxy GP Coating	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Epoxy Surfacing Primer	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
High Build	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interprime 820	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	ext
Interprime 880	5 days	*	3 days	*	2 days	*	1 days	*
Interprotect	48 hrs	ext	24 hrs	ext	16 hrs	ext	16 hrs	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	All substrates must be primed, clean and dry. PREVIOUSLY PAINTED SURFACES In Good Condition Wash down with Super Cleaner, rinse with fresh water and allow to dry. Sand with 80-180 grade (grit) paper. In Poor Condition Remove all previous coatings and prime the substrate. If necessary fill with Interfill 830.
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.
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 Thinner No.7 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

Please refer to your local representative or visit www.international-yachtpaint.com for further information.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies. © AkzoNobel 2024.

	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 Thinners No.7 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 or Interfill 830.
Number of Coats	As required
Coverage	(Theoretical) - 1 m ² /L per coat @ a DFT of 1 mm.
Recommended DFT per coat	2000 microns dry (2mm) vertical, 5000 microns dry (5mm) horizontal substrate.
Application Methods	Batten, Knife, Trowel, 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/41°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. Reminders 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	<i>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 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.</i>