
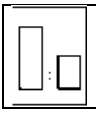



SPRAYABLE FILLER 500

Data Sheet n° 2

Editing Septembre 2022

<p>TYPE OF PRODUCT :</p>	<p>SPREADABLE OR SPRAYABLE EPOXY PRIMER IN HIGH THICKNESS</p>
<p>PROPERTIES :</p>  <p>Information Products</p>	<p>SPRAYABLE FILLER 500 is an epoxy primer flexible two-component: with very high dry extract, very low shrinkage, applicable with a spatula or pneumatic application. Water resistant, it accepts to be applied on the living works. Very high dry extract. Very high adhesive power on epoxy coatings, and composites of any kind, wood and derivatives, metals. Applicable in very high thicknesses by layer, with gravity gun, Air Mix or Pressure Pot. Very easy to sand. Ease of recovery in very short times. Very easy to sand 1 hour after stoving at 60°C for thicknesses of 500 µm. Sandable in both 80 and 400 grit. Recoatable without sanding from 2 to 72 hours depending on drying and storage conditions. Can be applied directly to foams (including polystyrene) if diluted with D 347. Excellent temperature resistance.</p>
<p>COMPONENTS :</p>  <p>Hardeners Thinners</p>	<p>Sprayable Filler 500 Hardener</p> <p>Thinners</p> <p>EP No. 3 D347</p> <p>DILUTION:</p> <p>FILLING KNIVES from 0% to 5% PNEUMATIC GUN from 5% to 10%</p>
<p>SPECIFICATIONS :</p>  <p>Standards and Qualifications</p>	<p>MAP YACHTING <i>Paint Systems</i> SPEC</p> <p>For the latest missing updates, please check with us at sales@map-yachting.com</p>

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Surface Preparation



All surfaces to be covered must be free of dirt, pollution due to grease, water vapour, (consult the dew point table) dust or mould. In order to ensure a perfect finish, and to obtain an excellent quality of surface tension, the interfaces or undercoats must be perfectly smooth, and free of drips or orange peel and sanded with very high quality abrasives to the FEPA standard.

SPRAYABLE FILLER 500 can receive PU225HB or PU228HB primers, previously sanded and cleaned.

It can be coated with the PORE FILLER PU225HB and PU228HB systems to obtain a perfect surface, after sanding, devoid of porosity, an essential condition for obtaining a perfect finish as well as excellent gloss retention over time.

SPRAYABLE FILLER 500 can also be used on primers, EP 211, IM409, EP 215HB+, and fillers MIX FILL 27-10, GREENFILL 80, MIX FILL 100.

Manual



Mixing
ratio

(by volume
and weight)

Volume : **2** Base / **1** Hardener

Weight : **100** g Base / **50** g Hardener

Allow products to acclimate to ambient site temperature before use. Base should be mixed thoroughly for at least 5 minutes using a clean disperser mounted on an explosion-proof stirrer. Then add the part of hardener by pouring it slowly and continuing to mix until a liquid with a smooth and homogeneous unctuous appearance is obtained. Since the two components are of different viscosity, the edges of the mixing container should be carefully scraped with a spatula. Mixing containers should have flat bottoms and perfectly smooth edges



Duration
Dying

Nothingness



Initial
application
viscosity
(at 23°C)

41 s to 37 s AFNOR cup n°4 (with dilution of 12% to 15%)



Remark

The viscosity should be checked using AFNOR cup no. 4 and readjusted if necessary. A viscosity check is recommended every 1/2 hour. Do not forget to mix well after each readjustment by diluting. Viscosity measurements are provided for guidance only and should not be used as quality control parameters.

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Shelf life of the mixture at 20°C

1 Hour (without thinner for a 3 liter kit)
2 Hours (at 15% EP No. 3 Thinner for a 3 liter kit)



Remark

Dry film weight for a thickness of 1000µm: 2100g/m²



Dry film thickness

200µm – 1500µm

Applications & Recommendations



Conditions

<u>Hardeners :</u>	Sprayable filler 500	Sprayable filler 500
Temperature:	15 - 20°C	20 - 35°C
Hygrometry :	30 - 70%	30 - 70%



Note

The quality of application of all coatings will be influenced by the spray equipment chosen and by the temperature, humidity and airflow of the paint application area. When first applying the product, it is recommended that test panels be prepared to identify the best equipment settings to use to optimize the performance and appearance of the coating. SPRAYABLE FILLER 500 can be applied under conditions outside the limits indicated. Care should be taken to ensure a satisfactory result. Please contact your MAP YACHTING Paint Systems technician to determine proper application techniques and choice of thinners when environmental conditions are outside the recommended range.



Remark

The quality of the coating may be degraded by humidity during its crosslinking phase.

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Materiel

Pressure pot
Pistol: AZ1
Nozzle + Needle: 2.5mm to 3.5mm
Paint flow: 170 - 280 ml/min
Air cap:
Gun pressure: 2.5 – 3.5 Bars
Product Pressure: 1-1.5 Bars

Gravity gun
Pistol: AZ3
Nozzle + Needle: 2.5 mm to 3.5mm
Paint flow: 140 - 250 ml/min
Air cap:
Gun pressure: 3 – 3.5 Bars

Filling knife
Flexible “Japanese” type



Number of layer

Apply in 2 coats a wet film of 200µm to 500µm. The layers must be closed and homogeneous.



Material cleaning

Do the first cleaning with cleaning thinner (noble solvent without water and not recycled) and finish cleaning with the application solvent of the MAP YACHTING Paint Systems system.

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Physical properties
USE LIMIT TEMPERATURE: +120 °C

Time to Drying
 (at 23°C – 40 à 60 % RH)

DRYING TIME (for 200µm dry):

 Touch dry: 12 hrs at 20°C, 2 hrs at 40°C, 1 hr at 60°C
 Sandable: 24 hours at 20°C, 4 hours at 40°C, stoving 2 hours at 60°C*
 Maskable at 20°C: 8 hours

Recovery
 (at 23°C – 40 à 60 % RH)

COVERAGE (At 23°C - 50 to 60% RH for 250µm dry):

 Minimum: 24 hours at 20°C, 4 hours at 40°C, 2 hours at 60°C
 Maximum: 72 hrs at 20°C, 12 hrs at 40°C, 6 hrs at 60°C
 Leave to degas for 30 minutes at 23°C before steaming*
 Beyond the maximum recoat times, sanding is mandatory.

THEORETICAL YIELD

 4.8 m² / l for 200µm dry (4 m²/kg for 100µm dry without loss)

Dry extract in mixed volume

92 +/-3 %

Mix density at 20°C

2,1 +/-0,05%


Compounds Organic Volatiles

Base : 110 g/l Hardener : 320 g/l

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ASPECT
(at 60°)

Satin



Colors

Grey



Flash Point

Base and hardener : PE> 93 °C



Storage

Store the product in a dry place and at a temperature between + 10°C and + 25°C according to the specifications of MAP YACHTING Paint Systems. Store in original unopened containers. Storage temperature may vary depending on OEM specification requirements. Refer to container label for specific information on storage time.

Lifetime
+10°C à 25°C

The information is given for closed containers in the original packaging, i.e. 12 months according to the commercial specifications of MAP YACHTING Paint Systems for the base of SPRAYABLE FILLER 500 and 12 months for the hardener. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety instructions

Comply with all local safety, disposal and transportation regulations. Carefully check the Safety Data Sheet (SDS) and label of each product before using it.

Safety Data Sheets are available on request.

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The information contained in this data sheet is not intended to be exhaustive and is based on the current state of our knowledge and on the laws in force: anyone using the product for purposes other than those specifically recommended in the data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended use does so at its own risk. It is always the responsibility of the user to take all necessary measures to meet the requirements set by local rules and legislation. Always read the Material Data Sheet and Technical Data Sheet for that product, if available. All advice we give or statements we make about the product (whether in this data sheet or elsewhere) are correct to the best of our knowledge, but we have no control over the quality or condition of the substrate or on the many factors affecting the use and application of the product. Therefore, unless we agree otherwise in writing, we accept no liability whatsoever for the performance of the product or for any loss or damage arising from the use of the product. All products supplied and technical advice given are subject to our terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to change from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check that this data sheet is up to date before using the product. Brand names mentioned in this data sheet are registered trademarks or licensed to:

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