



MIX FILL 30 – MIX FILL 10

FILLER

Edition juin 08

FORMULATED FILLERS FOR SANDABLE COATING

DESCRIPTION

Appearance: Powders

Type: Formulations based on hollow microspheres and inorganic fillers

Compatibility: Epoxy, polyester, vinylester and polyurethane resins

Application: Manufacturing of putties for sandable coating from medium to fine grain

Temperature resistance: over 100°C (fillers only)

Chemical resistance: Water, acids and organic bases, solvents

Mix Fill 30: Economical, relatively hard. Use for important thickness, fairing.

Mix Fill 10: soft, ease of sanding, fine grain. Used before the polyurethane or epoxy primer

	MIX FILL 30	MIX FILL 10
Application	Undercoat	Coating before finishing
Application thickness	3 cm	Less than 1cm
Apparent density g/l	300	100
Density of the mix g/l + 30	730	680
Color of the mix	Cream	Grey
Tolerance of the mix ratio	Excellent	Very good
Hardness for sanding	Medium	Soft
Abrasive clogging	Low clogging	Very low clogging
Mix ratio SR 1610 / SD 2613 (R/H)	100 g / 47 g	100 ml / 50 ml (2/1 by volume)
Mix ratio for 100 g R/H + 3 g	77g	27g
Mix ratio for 100 ml R/H + 30 ml	270 ml	270ml
Cost indicator		
- Price for filler only	1	3,6
- Price for mix in kg	1	1,5
- Price for mix in litre	1	1,4

R/H : Resin /Hradener

REACTIVITY

	à 20°C	à 25°C
Pot-life of SR 1610 / SD 2613 on 500 g mix	60 min	35 min
Working time of 3 mm thick coat of putty	2h	1h30
Putty in a coat of 3 mm sandable after	20h	16h

PACKAGING

Mixfill 10

Volume of kits	Weight of kits	SR 1610	SD 2613	Fillers
660 Liters of fillers	448,80 kg	1 x 240 kg	4 x 28,2 kg	4 x 24 kg
165 Liters of fillers	112,20 kg	2 x 30 kg	1 x 28,2 kg	1 x 24 kg
28 Liters of fillers	18,70 kg	1 x 10 kg	1 x 4,7 kg	2 x 2 kg
14 Liters of fillers	9,35 kg	1 x 5 kg	1 x 2,35 kg	1 x 2 kg
3 Liters of fillers	2,96 kg	1 x 1,05 kg	1 x 0,49 kg	1 x 0,42 kg

Mixfill 30

Volume of kits	Weight of kits	SR 1610	SD 2613	Fillers
895 Liters of fillers	652,80 kg	1 x 240 kg	4 x 28,2 kg	6 x 50 kg
258 Liters of fillers	188,20 kg	2 x 30 kg	1 x 28,2 kg	6 x 50 kg
37 Liters of fillers	26,70 kg	1 x 10 kg	1 x 4,7 kg	2 x 6 kg
18 Liters of fillers	13,35 kg	1 x 5 kg	1 x 2,35 kg	1 x 6 kg
4 Liters of fillers	2,79 kg	1 x 1,05 kg	1 x 0,49 kg	1 x 1,25 kg

SURFACE PREPARATION

Epoxy : laminated wood, sandwich structures

degreasing (water-soluble detergent, spirit) sanding, dust removal.

NB : the order of operation must be respected !

Direct application if prepared with **Peeltex** (peel ply), remove the Peeltex just before painting (protection of the surface against workshop pollution).

Immersed steel :

SA 2.5 sandblasting or ST 3 needle gun : coarseness 25-75 microns

Application of one coat of **AEROPRIM EP 140**, then a coat of **UNDERCOAT EP 215 HB**

NB: If the Mixfill system can be applied directly on the **AEROPRIM EP 140**, a cleaning of the surface with Ethanol followed by a light sanding with Scotch Brite 3M (medium grit) is required.

Nevertheless, it is safer to apply a coat of **UNDERCOAT EP 215 HB** in order to have a coat thick enough for sanding before applying the Mixfill without going through the **AEROPRIM EP 140**. The recoating time is longer with this coat of **UNDERCOAT EP 215 HB**.

Aluminium:

Degreasing, sanding with 24/36 or fine sandblasting

Apply one coat of **WASH PRIMER WP 110**, then one coat of **AEROPRIM EP 140**

Old or osmosed polyester composite

Degreasing then sanding, Sandblasting or planing of the gelcoat.

- Substrate with less than 300 microns of porosity (sanded surface 80/120): 1 coat of **UNDERCOAT EP 215**, let polymerise for 24 hours at ambient temperature (above 15°C).

- Sandblasted substrate, Fiber or chopped strand mat highly agressed, high porosity :one coat of epoxy resin without solvent. Application of **Mix Fill** just after, before the epoxy resin is gelled , or on cured resin completely degreased and sanded with 80/120.

Consult our paint manual or our technical department for more informations.

PROPORTIONS / MIXING

Respect the resin / hardener ratio, Mix thoroughly the components.

Measure out accurately and use the adapted tools, in accordance with the prepared quantity.

Incorporate the **Mixfill** filler in several stages to the mix resin / hardener

For quantities over 300 ml of putty, use a slow mechanical stirrer.



ESTIMATED CONSUMPTION

A coating of 1 mm onto 1 m² uses 1 liter of mix

WEATHER CONDITION

The temperature of the substrate will be 3°C higher than dew point.
Avoid applying in wet weather and when the ambient temperature is below 15°C
Keep packaging closed, away from moisture, at a temperature of 15 to 30°C.
Protect the coating from rain for 7 days.

FOLLOWING COATS

The first coating must be completely sanded and free of dust before a new application.

- **SR 1610 / SD 2613 / Mix Fill 10** :coating for finish. Medium to fine sanding prior painting.
- **Seacoat EP 215 HB** : - 2 coats on the areas that are not immersed.
- 3 to 4 coats on the immersed areas.

SANTE

SD 2613 is corrosive :

- Avoid any contact with skin and eyes.
- Handle with disposable or rubber gloves

Do not wash hands with solvent but with soap or **Proclean** and water.
In confined spaces, ventilate the working area.
During the sanding phases, wear a dust mask.

Waste

Respect the environment : Do not throw away into the waste pipe.