

SPRAYABLE FILLER 500

FINISHING FILLER
Two component

Edition February 13

**SPATULABLE AND SPRAYABLE EPOXY FILLER
APPLICABLE IN HIGH THICKNESS FILM
FAST DRY – EASY SANDABILITY
SUITABLE FOR APPLICATIONS IN IMMERSION**

FEATURES

Le **SPRAYBLE FILLER 500** is a flexible two component epoxy filler with high solids, spatula or spray gun application.

- has been developed for used on all surfaces, epoxy filler, composite materials, exterior or interior, over or under the water line
- High solids
- Very good adhesion on epoxy filler, and all composites
- Applicable in high thickness film per coat with spray gun, gravity gun, Airless, Air Mix or Pressure tank
- Excellent recoatability in short time
- Easy sandability 1 hour after a post cure at 60°C for a thick of 500 dry microns
- Can be sand with 80 to 400 orbital grit
- Recoatable without sanding from 2 to 72 h, it depends on dry time and storage condition.
- Directly applicable on polystyrenes foam if it's diluted with thinner D 347.
- Excellent temperature resistance

RECOMMENDED USES

Le **SPRAYBLE FILLER 500** is ideal for a use in :

- Finish filler applicable over filler MIXFILL to obtain a good preparation of surface.
- Can be apply without thinning with spatula for a film thickness inferior at 2 mm
- Finishing filler to osmosis treatment.
- Finishing filler for a perfect surface beforehand filler for dark or light colors of lacquers.

Le **SPRAYBLE FILLER 500** is compatible with systems MIXFILL 10, 30 , 100, 300, SPRAYABLE FILLER 700, EPOXYGUARD 455, EPOXY PRIMER EP 211 , UNDERCOAT EP 213, EP 215 HB and filler PU 228 HB or l'INTERFACE EPU 221

SPECIFICATION DATA

COATING TYPE : Finish epoxy filler

COLOR : Grey

GLOSS : Semi-gloss

COMPONENT : Two component

COMPONENT RATIO :

- Weight : 100 base / 50 Hardener
- Volume : 2 Base / 1 Hardener

INDUCTION TIME (at 15°C) : 5 minutes
Beyond 20 °C: Nothing

POT LIFE (at 20°C) :

- No thinning: 1 hour for kit 6L
- Thinning at 15% : 2 hours 30 for kit 6L

THINNER : EP N° 3 or D 347 for an application on polystyrene

DENSITY AT 23°C : 2 +/- 0.1 approx.

VOLUME SOLIDS : 92 +/-3 %

VOC : 101,66 g/l

THEORITICAL SPREADING RATE :

4,8 Sq.m/ l for 200 dry microns (2,4 Sq.m/kg for 200dry microns)

RECOMMENDED FILM THICKNESS PER COAT :

Spray gun : Dry : 250 microns / Wet : 300 microns
Application : 2 cross coat of 250 dry microns wet on wet.
Spatula : 1 to 2 mm of thickness (> 2 mm disadvised)

DRY TIME (for 200 dry microns) :

To handle: 12 h at 20°C, 2h at 40°C, 1h at 60°C
To dand : 24 h at 20°C, 4h at 40°C, 2h at 60°C
Maskable at 20°C : 8 h

DRY TIME TO RECOAT :

(at 20°C - 50 à 60 % HR pour 250µm secs) :
Maximum : 72 h at 20°C, 12h at 40°C, 6h at 60°C
Minimum : 24 h at 20°C, 4h at 40°C, 2h at 60°C
Let outgassing 30 minutes at 23°C before post curing
Sanding obligatory after dry time to recoat

TEMPERATURE RESISTANCE: 120°C

SURFACE PREPARATION

All surface to be coated must be free of grease, dust, dry spray, moisture.

SPRAYABLE FILLER 500 must be applied over a compatible primer or directly on epoxy filler or on sanding composi.

For application on polystyrene foam masters, it is possible to apply the **SPRAYABLE FILLER 700** directly with a spatula. If it is pulverized, you must **ONLY** use thinner **D 347**. It is recommended to test in advance and valid on a samble before application, because the foams do not all react in the same way.

Do not apply **SPRAYABLE FILLER 500** directly on metal. **SPRAYABLE FILLER 500** does not have anticorrosive properties. To obtain a low density filler used **SPRAYABLE FILLER 700**

Le **SPRAYABLE FILLER 500** can be applied on primers 140, 211, WOOD IMPREG 120, undercoat SF 700, EP213 and 215 HB EPOXYGUARD 455. can be recoat by systems SF 700, EP213 and 215 HB, EPU EPU 221, PU 228.

For all type of recoat,consult our technical department.

MIXING AND THINNING

For other type of packaging contact us.

Mix slowly by volume or weight, 2 parts of base with 1 part of hardener to obtain a smooth and homogeneous mixture.

After 5 minutes of induction time, if it's necessary, it is possible to diluate from 5 to 15 % of EP N°2 or D 347, if the temperature is < than 15°C (depends on application conditions or method).

You must check the viscosity with cup DIN or AFNOR.

Spray gun application : check the viscosity every 30 minutes. Don't forget to mix after every dilution add.

APPLICATIONS

APPLICATION METHOD		THINNING	TIP SIZES	PRESSURE
SPATULA	YES	NO		
ROLLER	YES (touch up)	0 to 15%		
SPRAY GUN	YES	10 to 15%	2,2 to 3	3 to 4 BARS
AIRLESS SPRAY	YES	0 to 10%	0,019 to 0,021 mm (40 to 60°)	60/1-150 to 200 Bars
AIRMIXTE SPRAY	YES	0 to 10%	0,019 to 0,021 mm	60/1-150 to 200 Bars

CONDITIONS FOR APPLICATION :

Optimum : 20 to 25 °C for 30 to 70 % HR

Limit : 15 to 35 °C for 30 to 75 % HR

The substrate temperature must be at least 3°C above the dew point to avoid any condensation - consult the conversion table available at Map Yachting.

VISCOSITY : 41 s to 37 s Coupe AFNOR n°4 with thinning of 12 to 15 %

PRECAUTIONS AND SHELF LIFE

See the material safety data sheet and product label for complete safety and precaution requirements

PACKAGING : KIT 0,9 or 6 Litres

CLASSE ONU : 1263

SHELF LIFE : 12 months in original unopened cans at + 5 and + 35 °C away from humidity - 9 to 12 months in tropical climate

FLASH POINT : >61°C

LABEL : Base = Xi : irritant

Hardener = Xn : Harmful



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