

# 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 68°F.** 1,50 kg. / dm<sup>3</sup> (After mixing)

**Packaging** 500ml. + 250ml. = 750ml.  
1000ml. + 500ml. = 1500ml.

**Shelf life** In closed unopened container stored in a dark location between 41 - 77°F approx. 3 years.

**Mixing ratio**

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

**Mixing**

Stir up the individual components before mixing them together.

**Time for application**

	54°F.	68°F.	82°F.
	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 54°F. - maximal 86°F.  
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 38°F 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. FRP 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. / 11ft<sup>2</sup> by 0,5 mm film thickness

**Max. film thickness**

Maximum 15 mm. in one application

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**EPIFANES**  
Yacht Coatings

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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	54°F.	68°F.	82°F.
Sandable	36 hours	24 hours	18 hours
Recoatible	36 hours	24 hours	18 hours
Chemically dried	72 hours	60 hours	48 hours

**Notes on drying** Higher or lower temperatures will considerably accelerate or reduce the curing process. slow down and may affect the reaction and properties of the product.

If drying takes place at temperatures below 68°F. in combination with a high relative humidity, the absorption of moisture into the surface can create an adhesive layer (so-called amine blush). This is due to the hygroscopic properties of the hardener type.

This top layer must always be removed before sanding the primed parts. by wiping well with water + vinegar, water + ammonia, Epifanes Cleaning Thinner, Epifanes Fiberglass Degreaser 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 120G 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** Incase the filler is applied in multiple coats, it is essential to clean and sand every coat before application of the next coat.

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