

FEATURES

- Excellent build and filling qualities
- Light-weight
- Easily applied without specialised equipment
- Excellent sanding properties
- Very good thermal stability
- Excellent water resistance
- Compatible with many substrates including suitably primed steel, aluminium, gel-coat, epoxy laminates, composites etc.
- May be applied direct to fresh epoxy laminate and composites
- May reduce labour input during the fairing stages of new builds

RECOMMENDED USES

Altex Yacht & Boat Epoxy High Build Surfacer is a two-component new technology high build epoxy surfacer and profiling compound.

AY&B Epoxy High Build Surfacer is designed to fill and profile minor imperfections such as found on epoxy glass lay-ups, sanded epoxy fairing compounds, and repair sites on damaged structures.

AY&B Epoxy High Build Surfacer is NOT a fairing compound and should NOT be overbuilt.

The recommended maximum dry film thickness per coat is 0.5mm (500 microns).

AY&B Epoxy High Build Surfacer may be applied by spray or squeegee, or a combination of both.

AY&B Epoxy High Build Surfacer is suitable for service above and below water however in immersion service a full epoxy barrier system should be applied over the sanded Altex Epoxy High Build Surfacer.

Limitations:

AY&B Epoxy High Build Surfacer should always be sealed with AY&B Epoxy Barrier Undercoat, or AY&B Polyurethane Undercoat, to ensure there is no loss of gloss in the applied AY&B Elite® Polyurethane finish coat.

SPECIFICATION DATA

Coating Type:	High Build Epoxy Surfacer
Colour:	Straw
Packaging:	5 and 10 litre – 2 component kit
Mix Ratio:	4 : 1 by volume
Gloss:	Flat
Flash Point:	> 5°C
Thinner:	Altex Thinning Solvent #12
Pot Life:	3 hours at 25°C
Induction Time:	15 minutes
Storage:	Store under cool, dry conditions
Density:	1.1 kg/litre
VOC:	255 g/litre
Volume Solids:	70%

Theoretical Coverage Rate:

1.4 square metres per litre at 500 microns dry

Recommended Film Thickness Per Coat:

430-720 microns wet to obtain 300-500 microns dry

Application: Spray, Squeegee

Dry Times (500 µm DFT / 50% R.H. / 25°C):

Touch Dry	2 hours
Dry to Sand	24 hours
Minimum Recoat	24 hours - sanded
Maximum Recoat	Unlimited, must be sanded
Fully Cured	7 days

Application Conditions:

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	35°C	35°C	90%
Optimum	16-24°C	16-24°C	16-24°C	30-70%

This product requires the substrate/surface temperature to be above the dew point

SURFACE PREPARATION

All surfaces should be primed, except for coarsely sanded fairing. Suitable primers include:

- AY&B Epoxy Primer
- AY&B Epoxy Barrier Undercoat

Aluminium surfaces should be anti-corrosive primed using AY&B Epoxy Aluminium Primer followed by a tie / prime coat of one of the primers listed above.

Bare wooden surfaces should be sealed and conditioned with AY&B Everseal followed by a tie / prime coat of one of the primers listed above.

Caution: Wooden substrates may move and crack two component coatings.

The number of coats of AY&B Epoxy High Build Surfacer required for a job is entirely dependant on the original surface roughness and the final required degree of fairness.

Very rough surfaces should be filled and faired with a proper 100% volume solids epoxy fairing compound, such as the AY&B Epoxy Resin and Microballoon mixture.

Very few projects would require fewer than two applications, and often, on irregular or coarse laminates four or more coats may be necessary. Sanding between coats is recommended.

We strongly recommend the use of guide coats when sanding.

To avoid solvent entrapment and to minimise cure shrinkage effects, always allow 24 hours (absolute minimum overnight) cure and avoid applying in excess of 500 microns DFT (720 microns WFT).

AY&B Epoxy High Build Surfacer should always be sanded before over-coating or re-coating.

DIRECTIONS FOR USE

Mixing:

AY&B Epoxy High Build Surfacer is a two-component product supplied in 5 and 10 litre kits which contain the correct ratio of ingredients. Separately power mix the Part A and Part B portions to obtain a smooth homogeneous condition. After pre-mixing slowly add the Part B to the base whilst continuing to agitate. After the converter addition is complete continue to mix slowly until homogeneous. The mix requires a 15 minute induction time before using.

The pot life of the mixed material is 3 hours at 25°C. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Thinning:

Thinning is not normally required; however, at lower temperatures or when using light equipment, **small** amounts (15% or less) of Altex Thinning Solvent #12 may be added to the mixed material.

Clean-up:

Use Altex Thinning Solvent #12

Application:

AY&B Epoxy High Build Surfacer can be applied by either conventional air spray, airless spray equipment or squeegee.

Typical spray set-ups are as follows:

Air Spray Pressure pot, 15-20 psi; line pressure 60 psi; 2.8mm tip

Airless Spray Graco – Electric Mark V pump, 2500 psi; 0.025-0.027" tip

Air-Assisted Airless

Graco – Electric Mark V pump, 1500 psi; line pressure 60 psi; 0.019-0.021" tip

(Note : Other equipment equivalent to the above may be used.)

Ventilation:

It is very important for the safety of the applicator and to obtain proper performance that good ventilation is provided to all portions of the working area. It is equally important to bring into the area dry, fresh air to remove all solvent vapours. Since solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of any enclosed area. Ventilation should be maintained throughout the cure period.

Sanding:

Typically, first sand with 80-120 grit, non stearate sandpaper. Sand again, prior to undercoating with 150-220 grit.

PRECAUTIONS

For Professional Use: Read and follow all the caution statements on this Product Data Sheet, the product label and the Safety Data Sheet (SDS) for health and safety information prior to use.

Epoxy High Build Surfacer is flammable. Keep away from heat, sparks and open flame. Use with adequate ventilation. May cause eye and skin irritation. Do not breathe vapour or spray. Wear suitable protective clothing such as gloves and eye and face protection.

WWW.ALTEXBOATPAINT.COM

Head Office New Zealand
Altex Coatings Ltd
 91-111 Oropi Road
 Greerton, Tauranga 3112
 Ph: +64 7 541 1221
 Fax: +64 7 541 1310

Head Office Australia
Resene Paints (Aust) Ltd
Industrial & Marine Division
 7 Production Avenue, Molendinar
 Queensland 4214
 Ph: +61 7 5512 6600
 Fax: +61 7 5512 6697

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