

INTRODUCTION

Quick notes:

- 1-1,
- 101 is a lighter weight, thick layer option,
- 102 for large profiling repairs.

PRO-FILL 101 & 102 are two-component epoxy fillers / fairing compounds with excellent workability, for interior and exterior use, above and below the waterline.

- **PRO-FILL 101** is lighter weight, used to make thicker fillings.
- **PRO-FILL 102** is specifically formulated for re-building large profiles. Its workability allows for layers from 0 to 10 mm.

They can be used on all standard substrates, i.e. GRP, FRP and metals, which have been properly primed. Can also be applied on anti-corrosive & protective coatings.

APPLICATION METHOD

Apply using filling / palette knife, batten or trowel.

RECOMMENDED USAGE

The substrate must be adequately sealed using PRO-PRIME 100/200 series before application. Following application and fairing, if further filling is required, the fast filler PRO-FILL 201 is also an option. PRO-FILL series must then also be sealed with a PRO-PRIME series primer.

FEATURES

- 1 to 1 by volume and weight,
- very easy to fair,
- negligible shrinkage,
- above and below the waterline,
- light red (101) and light blue (102) colour makes filled areas easy to find.

LIMITATIONS

Not suitable for substrates which require movement accommodation, e.g. joined structures or wood subject to expansion / contraction.

PRODUCT DATA

PRO-FILL 101 / 102: Properties	
Mix ratio (by volume & weight)	1:1
Colour of mixture	Light red / light blue
Volume solids, %	100
Specific weight (of mixture), kg/lt	0.8 / 1.1
Shelf life (in controlled environment), years	2
Packaging, comp. A+B, lt	1, 4, 20

CURING SPEED

PRO-FILL 101 / 102: Curing speed			
	10 °C	20 °C	30 °C
Pot life, mins	70	50	30
Sandable, hrs	48	36	24

[Determined in controlled laboratory conditions. To be used as a guide only.]

PRO-FILL 101 and 102 will continue to cure for 2-7 days. This does not prevent re-coating.

RECOAT AND OVERCOAT TIMES

Sanding PRO-FILL 101/102 with 120-320 grit before overcoating with a filler or primer is best practice. For small repairs or when the required application thickness is not achieved in one go, use the following minimum times for overcoating without sanding.

PRO-FILL 101 / 102: Minimum overcoat times			
	10 °C	20 °C	30 °C
Minimum time before overcoating (filled or primed) without sanding, hrs	8	4	2.5

[Determined in controlled laboratory conditions. To be used as a guide only.]

SURFACE PREPARATION AND APPLICATION

Quick notes:

- Clean greasy contaminants using CLN-01, if present,
- fair dry contaminants and clean using dry cloths and, optionally, CLN-01.

Both preparation and application should be carried out in optimal conditions, namely temperature in the range of 10-30 °C (ambient, substrate and product) and normal humidity levels. Following application, if temperature drops, curing will proceed, even close to 0 °C, albeit at lower speeds.

The application surface must be primed and clean, free of dust, salt, water, grease, oil, wax, silicone, rust and other contaminants deposited over time or during the repair process. If the recoat window of the primed surface has expired, abrade surface accordingly.

In the case of oily / greasy substrates, use the **CLN-01** cleaner and ensure that no residues remain.

For surfaces free of grease and oils, the recommended way of cleaning it is by dry cloth assisted by vacuum dust extractor or compressed air (free of compressor oils). Use a large cloth, apply very lightly and change sides continuously so as to remove dust instead of pressing it on the substrate. Low grade grinding will help with more persistent residues and improve adhesion. Avoid using wet or waxed tissues.

Do not apply on substrates lacking cohesion. In such cases, unsound parts of the application surface must be removed and, if required, sealed using a PRO-PRIME series primer.

Exotherm is low enough to allow application of layers in excess of 20 mm (for PRO-FILL 101), especially at lower temperatures. You are advised to build thickness gradually in order to keep air entrapment at a minimum.

Mix equal volumes of each component until a uniform color has emerged. Do not thin. In hot weather, you may spread out the mix on the tray in order to prolong its pot life. Apply with filling knife in more than one direction.

PACKAGING

1, 4 and 20 lt (total volume of both components).

STORAGE & SHELF LIFE

At least 24 months from the date of manufacture in the original sealed container. Store away from excessive heat and humidity.

SAFETY

Apply in well-ventilated spaces. Follow personal safety guidelines relating to epoxy products, including the use of proper mask and protective clothing. Avoid physical contact with the uncured substances.

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