

PRO-FILL 101

LIGHTWEIGHT EPOXY FILLER

TECHNICAL DATA SHEET



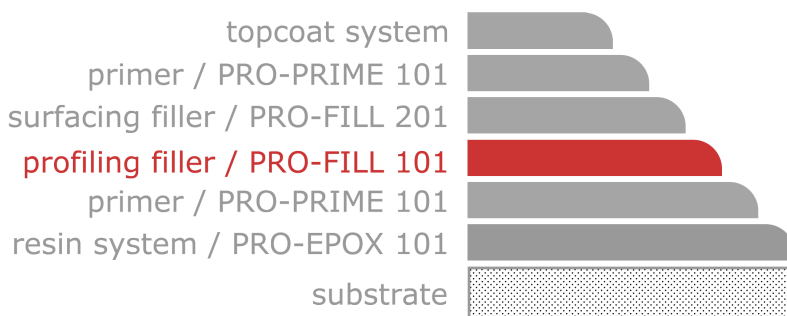
PRO-FILL 101 is a two-component epoxy profiling filler / fairing compound with excellent workability, for interior and exterior use, above and below the waterline. It is suitable for covering imperfections, filling repairs and profiling smooth surfaces. It can be used on all standard substrates, i.e. 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

To be used as part of a complete system as shown below.



The substrate must be adequately sealed using epoxy primer PRO-PRIME 101 before application of PRO-FILL 101. Following application and fairing, if further filling is required, the fast surfacing filler PRO-FILL 201 is also an option. PRO-FILL 101 and 201 must then also be sealed with PRO-PRIME 101.

Features

- 1 to 1 by volume,
- very easy to fair,
- up to 20 mm application thickness,
- negligible shrinkage,
- above and below the waterline,
- light red 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: Properties	
Mix ratio (by volume)	1:1
Colour of mixture	light red
Volume solids, %	100
Specific weight (of mixture), kg/lt	0.75
Shelf life (in controlled environment), years	2
Packaging, comp. A+B, lt	1, 4, 20

PRO-FILL 101: Curing speed			
	10 °C	20 °C	30 °C
Pot life, mins	70	50	30
Sandable, hrs	30	18	8

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

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

Re-coat & overcoat times

Sanding PRO-FILL 101 with 120-320 grit before overcoating with a surfacing 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: 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.]

Preparation & application

Both preparation and application should be carried out in optimal conditions, namely temperature in the range of 10-35 °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.

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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.

For dry surfaces, i.e. no water, oils, grease etc., 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. As an alternative, if necessary, use PRO-CLEAN IPA, the fast drying, residue free, isopropyl alcohol solvent.

In the case of oily / greasy substrates, using special cleaners containing solvents and/or chemicals will be necessary. It is important to ensure that no residues remain, either from the initial contaminants or from the cleaners.

Do not apply on substrates lacking cohesion. In such cases, unsound parts of the application surface must be removed and, if required, sealed using the primer PRO-PRIME 101.

Exotherm is low enough to allow application of layers in excess of 20 mm, 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 colour 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.

You are advised to first test the product, surface preparation and ambient conditions on a non-critical part of the application surface before proceeding with the full repair.

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.

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Quality control

PRO-FILL 101 is produced under ISO 9001/14001/45001.

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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