

PRO-FILL 301

FAST EPOXY FINISHING FILLER

TECHNICAL DATA SHEET



INTRODUCTION

Quick notes:

- 1-1 by volume,
- fast curing,
- for detailing jobs.

PRO-FILL 301 is a two-component fast epoxy filler, which cures to produce a smooth finish, for interior and exterior use, above the waterline. Suitable for detailing 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 series epoxy primers before application of the PRO-FILL fillers.

FEATURES

- 1 to 1 by volume,
- fast
- very easy to fair,
- above the waterline only,
- light grey colour makes filled areas easy to find but also easy to cover.

LIMITATIONS

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

PRODUCT DATA

PRO-FILL 301: Properties	
Mix ratio (by volume)	1:1
Colour of mixture	light grey
Volume solids, %	100
Specific weight (of mixture), kg/lt	1.45
Shelf life (in controlled environment), years	2
Packaging, comp. A+B, lt	1, 4

CURING SPEED

PRO-FILL 301: Curing speed			
	10 °C	20 °C	30 °C
Pot life, mins	60	30	15
Sandable, hrs	5.0	3.0	1.5

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

PRO-FILL 301 will continue to cure for 2-5 days. This does not prevent re-coating.

RECOAT AND OVERCOAT TIMES

Sanding PRO-FILL 301 with 220-400 grit before overcoating 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 301: Minimum overcoat times			
	10 °C	20 °C	30 °C
Minimum time before overcoating (with fillers or primers) without sanding, hrs	3.5	1.5	0.5

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

SURFACE PREPARATION AND APPLICATION

Quick notes:

- First clean greasy contaminants using PRO-CLEAN X, if applicable,
- then fair and clean dry contaminants using dry cloths, and optionally PRO-CLEAN IPA.

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.

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 **PRO-CLEAN X**, the xylene based cleaner. Ensure that no residues remain, either from the initial contaminants or from the cleaner.

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. As an alternative, use **PRO-CLEAN IPA**, the fast drying, residue free, isopropyl alcohol solvent.

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.

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 directions.

PACKAGING

1, 4 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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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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