

PRO-FILL 603

BLACK FILLER PASTE FOR CFRP PARTS

TECHNICAL DATA SHEET



INTRODUCTION

Quick notes:

- 1-component acrylic paste,
- for surface re-finishing (very small imperfections),
- 30-minute drying time.

PRO-FILL 603 is a black colored, one component filling paste for carbon fiber component re-finishing. It is a very fast drying product and produces a smooth and hard finish. Use to fill very small imperfections only, e.g. pinholes, scratches, blemishes and to make last minute improvements to the surface before top coating.

APPLICATION METHOD

Apply using flexible spreader.

RECOMMENDED USAGE

PRO-FILL 603 has been developed for use in the cosmetic restoration of carbon fiber components. Due to its speed of drying and ease of fairing, it is faster and easier to make CFRP surfaces level using PRO-FILL 603 before top-coating rather than using multiple layers of epoxy or other topcoats to fill and overcoat.

FEATURES

- 1 component,
- very easy to fair, in just 30 minutes,
- black color makes filled areas unnoticeable.

LIMITATIONS

- Use for the smallest of imperfections only. For bigger defects, use **PRO-FILL 303**.

PRODUCT DATA

PRO-FILL 603: Product data	
Colour	black
Viscosity, approx., cP	10,000
Specific weight, kg/lt	1.54
Volume solids, %	51
Shelf life (in controlled environment), years	1
Packaging, ml	100

PRO-FILL 603: Drying time			
	10 °C	20 °C	30 °C
Pot life, secs	90	60	45
Sandable, mins	25	25	25

SURFACE PREPARATION

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 clean, free of dust, salt, water, grease, oil, wax, silicone, rust and other contaminants deposited over time or during the repair process.

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.

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.

MIXING & APPLICATION

Quick notes:

- Stir product in container before using,
- take small quantity and apply immediately,
- apply thin layers only.

Stir product in container before using as solvent separation can be expected. Keep in mind that you are constrained by the very small pot-life of the product, usually less than a minute. Only take a small quantity out of the container and apply immediately in very thin layers with a spreader in one or two directions. Do not feather around the imperfections to be filled or use thicker layers as this will just take more time to fair.

Contrary to epoxy fillers, PRO-FILL 603 will shrink during drying, so after about 30 minutes, before fairing, check to see if another layer is needed. The best way to achieve the right thickness is via for multiple thin layers, not fewer thicker layers.

FAIRING & CLEANING

Quick notes:

- Light pressure fairing only,
- dry or wet cleaning, no solvents.

Fair very lightly with whatever grade you are preparing the rest of the surface for overcoating. Clean with dry cloth only. Do not use solvents or cleaners. Water or mild soap can, of course, be used.

Use PRO-CLEAN X to clean equipment.

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

100 ml.

STORAGE & SHELF LIFE

At least 12 months from the date of manufacture in the original sealed container. Store away from excessive heat and humidity.

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SAFETY

Use in well ventilated spaces away from sparks or open flames. Follow personal safety guidelines, including the use of proper mask, gloves and protective clothing. Avoid physical contact with the uncured substance.

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