

APPLYING THE SECOND COAT OF RESIN

1

It is best to allow five to six hours to elapse after the first saturation coat has been completed at which time (at 20°C), the resin system will have firmly set up but will not be fully hard.

2

Using a sharp 80–100mm (3"– 4") Skarsten scraper with slightly rounded blade ends to avoid scouring the cloth, scrape off any surface nibs or exposed filaments including cloth overlaps and edge butts until you have a smooth, protrusion-free surface.

3

Follow on immediately with a second rolled coat of resin. This must be of sufficient film thickness to completely submerge and bury all the filaments of the cloth within the resin system. Allow to cure.

For further information refer to the Epiglass® HT9000® Epoxy Resin Guide.

FILLING & FAIRING

Your boat is not only under attack from the elements. Damage may also result from collision, abrasion and other mechanical damage. Fillers can be used for small scale repairs, and picking the right one for the job is essential if the result is to last.

CHOOSING THE RIGHT FILLER

Fillers are available with a number of different characteristics specific to how they will be used. Some have been formulated specially for filling and some for fairing and filling. It is important to ensure that you have selected the correct product for your job in hand. To assist in selecting the product, we have listed a range together with their appropriate uses.

| SOLUTION CHOICES | | |
|---|---|---|
|  INTERFILL® 833 |  EPIFILL® |  EPIGLASS® HT9000® |
| A low-to-medium density very smooth and creamy two-part epoxy filler suitable for all filling work and for the smaller fairing jobs. Can be used above and below the waterline. Easy 1:1 by volume mixing ratio. | A medium-to-high density two-part epoxy filler. Can be used above and below the waterline and is ideal for all manner of filling jobs. It is especially suitable for those jobs where compressive forces are high (ie. between keels and hulls). It is also ideal for use as a bedding material under deck fitting such as winches etc. Easy 2:1 mixing ratio. | Epiglass® HT9000® is a system whereby the user can intermix various HT extender powders with the epoxy resin to produce their own fillers and fairing materials. Refer to the Epiglass® HT9000® brochure for complete details on this range of products. |

If taking on a major profiling job, International has a range of professional epoxy fillers more suited to the task than those described above. For more information please call our helpline.



WARNING: APPLY FILLER FIRMLY TO SUBSTRATE TO ENSURE NO AIR BUBBLES ARE TRAPPED BENEATH THE SURFACE.

DO NOT USE POLYESTER BASED FILLER UNDER TWO-PART PAINT SYSTEMS.

GUIDELINES FOR USE

- | | |
|---|--|
| 1 | Epoxy Filler can be used above and below the waterline and is ideal for filling screwholes and hairline cracks in gelcoat, prior to repainting. |
| 2 | These epoxy compounds are 100% solids. Do not add thinners to these compounds as that will lead to shrinkage. Clean equipment with the recommended thinner. Refer to label or product datasheet. |
| 3 | When mixing epoxy compounds check the label to see what the pot life is for the temperature you are working in and mix only what can be used in that time. |
| 4 | To avoid flat spots when applying and sanding fillers on curved surfaces, use spreaders and sanding boards that are longer than the width of the area by at least half as much again. |
| 5 | No matter how smooth a finish you have achieved, when filling or fairing, all fillers must be sanded before overcoating to ensure good adhesion. |
| 6 | For screw holes and small repair areas, ensure that all dust is removed and clean the area by wiping with solvent. Over-fill the area to allow you to sand back to a flush finish. |

HINTS TO HELP YOU ACHIEVE A PERFECT RESULT EVERY TIME

- ✓ Take care when mixing; always use the correct mixing ratio, as this will ensure maximum bond strength. Avoid contaminating either base or hardener by using separate dispensing sticks and/or disposable spoons. To ensure an accurate measure out three equal parts (2 of base and 1 of hardener) along the edge of the mixing board.
- ✓ For small jobs look for the handyman blister pack.
- ✓ If applying to rotten, soft or spongy timber, totally remove all unsound timber before applying filler. (Refer to Everdure rot prevention page 50).
- ✓ Mix only enough for the job and allow curing over night before sanding.
- ✓ Epifill® can be washed off the skin with warm soapy water however; it is recommended that plastic disposable gloves be worn.
- ✓ Tools can be cleaned with International Epoxy Thinners #7.



INTERFILL® 835

An off white, two-part, ultra high build surfacing compound that can be applied by roller or spray.

May be used to fill low areas, typically around 0.5mm deep prior to applying primers and undercoats.

Makes an excellent choice of material for filling the residual weave pattern in epoxy sheathing jobs and minor holes and depressions in other filling jobs.

A very easy to use and very easy sanding product. Mixing ratio is 3:1 by volume.

Should be overcoated with Interprotect® after being sanded smooth.