

Technical data sheet
FILL 4
Moulding compound
Application:

- Composite manufacturing industry
- manufacture of waterborne vessels (boats: motorboats and sailing yachts)
- other products made of composite (laminated) materials

Properties:

- excellent filling properties
- very good adhesion to polyester fibre glass laminates
- low shrinkage
- high compressive strength
- universal curing system

CHARACTERISTICS	FILL 4	STANDARD
Density	1.7 – 1.8 g/cm ³	PN-EN ISO 2811-1
Gel time at 20°C BPO hardener	4 - 7 min	--
Gel time at 20°C MEKP hardener	10 - 20 min	--
Colour	black	--
Shrinkage	< 1 %	PN EN ISO 3521
Compressive strength	> 85 MPa	PN-EN ISO 604 : 2006
Glass transition temperature	57 °C	DIN EN ISO 6721
Curing time (BPO at 2%)	2 - 3 h	--
Curing time (MEKP at 2%)	4 - 6 h	--

CAUTION: Tests were made with 2% Metox 50 hardener.

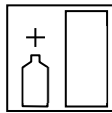
SUBSTRATES

polyester, vinyl ester and epoxy laminates	degrease with the PLUS 780 a remover, dry sand P80 – P120, and degrease again.
plywood, wood	dry sand with P80 – P120 and remove dust,

CAUTION

The compound should not be applied directly on wash primers, one-component acrylic or nitrocellulose products.

MIXING RATIO

	COMPOUND HARDENER	Ratio by weight
		100g 2.0-3.0 g


COATABILITY


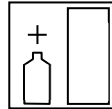
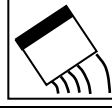
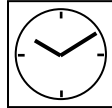
Polyester, vinyl ester or epoxy laminates (resins), polyester putties, and acrylic primers

APPLICATION CONDITIONS

The minimum application temperature is +10°C at air humidity from 30 to 70%.

APPLICATION

	Clean and sand the surface
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	Degrease the surface with PLUS 780
	Observe the required amount of hardener. Mix the components thoroughly until a uniform colour is obtained. Weight quantity of components: Add 100 g of FILL 4 to 2.0-3.0 g of hardener. Gel time at 20°C: 4 to 20 min, depending on the hardener in use
	Apply with a trowel
	The curing time is 2 to 6 h at 20°C with 2% of hardener.
SUPPLEMENTARY PRODUCTS	
Hardener – methyl ethyl ketone peroxide; MEKP (e.g. METOX 50). Hardener – benzoyl peroxide; BPO (e.g. BETOX 50PC)	
EQUIPMENT CLEANING	
THIN 850 acrylic thinner or NC solvent.	
PACKAGING	
25 kg	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
FILL 4	6 months / 20°C
SAFETY	
See the Safety Data Sheet.	
NOTES	
Intended for professional use only.	
OTHER INFORMATION	
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