## DESCRIPTION
- two component polyamide cured epoxy surface filler

## PRINCIPAL CHARACTERISTICS
- good adhesion to steel, cement based building materials and various plastics and wood
- ideal for use as a skim coat for filling grain on wood and profile on concrete and render
- good water and chemical resistance
- can be overcoated with alkyd, chlorinated rubber, vinyl, epoxy and polyurethane coatings

## COLOUR AND GLOSS
- white - eggshell

## BASIC DATA AT 20 °C (for mixed product)
- **Mass density**
  - approx. 1.4g/cm³

- **Solids content**
  - approx. 73% by weight

- **Recommended dry film thickness**
  - up to 2 mm

- **Theoretical spreading rate**
  - 5.2 kg/m² for 2 mm

- **Touch dry after**
  - approx. 1 hour

- **Overcoating interval**
  - min. 16 hours*
  - max. 10 days*

- **Full cure after**
  - 7 days*

- **Shelf life (cool,dry place)**
  - 12 months

- **Flashpoint**
  - base 17 °C - hardener 26 °C

- **Available pack size**
  - 5 kg

## RECOMMENDED SUBSTRATE CONDITIONS
- substrate must be dry and free from any contamination
- if substrate shows high absorption it is advisable to prime with 7406 Sigmacover 211
- substrate temperature must be above 5 °C and at least 3 °C above the dew point

*see additional data
INSTRUCTIONS FOR USE
- mixing ratio: by weight; base to hardener 83.5 : 16.5
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity

Induction time at 20 °C none
Potlife at 20 °C 4 hours*

APPLICATION TOOLS
- stainless steel filling knife, trowel or Swedish knife
- if necessary to smooth the surface of filler use thinner 91-92 (flashpoint 20 °C)

CLEANING SOLVENT 90-53 (flashpoint 30 °C)

SAFETY PRECAUTIONS
see safety sheet 1570 for information on LEL and TLV values

Overcoating table for epoxy and polyurethane paints

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>10 °C</th>
<th>15 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum interval</td>
<td>48 hours</td>
<td>24 hours</td>
<td>16 hours</td>
<td>8 hours</td>
</tr>
<tr>
<td>Minimum interval</td>
<td>21 days</td>
<td>14 days</td>
<td>10 days</td>
<td>7 days</td>
</tr>
</tbody>
</table>

Curing table

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>Touch dry</th>
<th>Dry to handle</th>
<th>Full cure</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 °C</td>
<td>120 minutes</td>
<td>6 hours</td>
<td>21 days</td>
</tr>
<tr>
<td>10 °C</td>
<td>60 minutes</td>
<td>4 hours</td>
<td>14 days</td>
</tr>
<tr>
<td>15 °C</td>
<td>45 minutes</td>
<td>3 hours</td>
<td>10 days</td>
</tr>
<tr>
<td>20 °C</td>
<td>30 minutes</td>
<td>2 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>30 °C</td>
<td>20 minutes</td>
<td>1 hour</td>
<td>5 days</td>
</tr>
</tbody>
</table>

Potlife at application viscosity; these figures are valid for approx. 5 ltr

<table>
<thead>
<tr>
<th>Paint temperature</th>
<th>Potlife</th>
</tr>
</thead>
<tbody>
<tr>
<td>15 °C</td>
<td>9 hours</td>
</tr>
<tr>
<td>20 °C</td>
<td>6 hours</td>
</tr>
<tr>
<td>25 °C</td>
<td>4 hours</td>
</tr>
<tr>
<td>30 °C</td>
<td>2 hours</td>
</tr>
<tr>
<td>35 °C</td>
<td>1 hour</td>
</tr>
</tbody>
</table>

REFERENCES explanation to product data sheets on information sheet 1551