

TECHNIFILL™ XP R1160 resin is a low density, solvent free, epoxy paste, formulated for use with TECHNIFILL XP H1160 hardener to cure at ambient temperature, producing a filler that is suitable for fairing in marine and industrial applications. The thixotropic nature of TECHNIFILL XP has been designed for good hold-up on vertical surfaces.

This lightweight formulation is easy to sand, and will bond well to a variety of substrates including fibreglass and wood; metal surfaces need to be prepared with a suitable primer to ensure good adhesion.

*Note: Technifill XP is recommended for use under light coloured paints. It is advisable to prepare a test sample for trial, if a dark colour is being considered.*

*Due to the wide variation in paint systems available, users should satisfy themselves as to performance under their chosen system.*

Contact ATL Composites for specific information.

**MIX RATIO**

1 part hardener to 1 part resin by volume

Take care to assure that the components are thoroughly mixed to uniform colour before applying.

*Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.*

UNCURED PROPERTIES		
	R1160	H1160
Physical State	blue thixotropic paste	white thixotropic paste
Specific Gravity g/ml @ 25°C	0.95	0.92

CURE CHARACTERISTICS	
Pot Life -100g @ 25°C (in air)	20 - 30 minutes
Cured to a solid state @ 25°C	12 - 16 hours
Minimum application temp.	15°C

THIN FILM CURE @ 20°C			
	10mm film	5mm film	2.5mm film
Touch Dry	2 hours	2.75 hours	3.25 hours
Sandable*	4 hours	5.5 hours	6.5 hours

\* 40 grit sandpaper

**APPLICATION**

The surfaces to be filled or faired should be dry and free from contaminants such as oil or dust.

- Timber surfaces require a priming coat of neat epoxy mix to seal the surface prior to filling.
- Fibreglass or painted surfaces should be thoroughly sanded prior to filling to provide good adhesion.
- Aluminium and steel surfaces should be coated with an epoxy high-build primer (as per the paint company’s recommendation), then sanded to a 80 grit finish prior to filling.

Avoid excessive air entrapment by mixing slowly, and ensure that no unmixed resin or hardener is left on the sides, or the bottom, of the container, as this can lead to soft spots in the coating. The use of a flat board for mixing is recommended, as this makes mixing easier and enables larger quantities to be mixed at one time.

In fairing applications, the resin/hardener mixture is trowelled onto the surface. Adopt a trowel action that does not cause excessive air entrapment. Sufficient TECHNIFILL XP should be applied so that no hollows will remain after the final sanding.

TECHNIFILL XP may be sanded after four to twelve (4-12) hours, depending on ambient temperature. Full strength may take up to four (4) days. Avoid inhalation of dust when sanding.

Once fairing is completed TECHNIFILL XP **must** be coated with one coat of “neat” WEST SYSTEM brand R105 resin/H206 hardener mix above the waterline, and at least two coats below the waterline. Sealing is necessary for maximum moisture and solvent resistance.

**COVERAGE**

Depending on porosity and surface roughness, one litre of mixed TECHNIFILL XP will cover approximately 1 m<sup>2</sup> at 1mm thickness.

**CLEAN UP**

Equipment contaminated with uncured TECHNIFILL XP resin and hardener mix can be cleaned up with warm water.

PACK SIZES				
Order Code		Order Code		PACK
Resin		Hardener		
RB1160	1L	HB1160	1L	2L
RC1160	4L	HC1160	4L	8L
RD1160	20L	HD1160	20L	40L

### STORAGE

TECHNIFILL XP R1160 resin and TECHNIFILL XP H1160 hardener will keep for 1 year if kept in original containers, at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

### HEALTH AND SAFETY

TECHNIFILL XP R1160 resin and TECHNIFILL XP H1160 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves, safety glasses, and dust masks.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

**Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

**Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 31/7/12