

**DESCRIPTION**

Variopox Filler is a two component filler based on epoxy resins with fine extenders.

**PRINCIPAL CHARACTERISTICS**

- Excellent adhesion to wood, steel, polyester and other surfaces provided pretreated with suitable primers;
- Water vapour impermeable;
- Resistant to various chemicals;
- Easy to sand;
- Semi-flexible;
- Suitable for permanent immersion in (sea) water.

**COLOURS AND GLOSS**

Light green - Flat

**BASIS PROPERTIES (AT 23 °C AND 50% R.H.)**

Density	:	approx. 1,9 g/cm <sup>3</sup> (mixed product)
Solid content	:	approx. 100 % (volume)
Dust dry after	:	approx. 2 hours
Full cure after	:	approx. 2 days, see additional information
Recoating interval	:	min. 2 days, see additional information max. unlimited, provided clean and dry
Shelf life	:	separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	:	base component 150 °C hardener 112 °C

**SPREADING RATE**

at 500 µm (d.f.t.) : 1,1 m<sup>2</sup>/kg

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

**SUBSTRATE CONDITION AND TEMPERATURE**

Steel	:	dry and free from any contamination such as rust, grease, oil and loose particles, grit blasted to ISO Sa 2½ and pre-treated with IJmopox ZF primer;
Wood	:	dry and free from any contamination such as grease, oil and loose particles, moisture content maximum 12%, pre-treated with Variopox Injection resin and sanded with grit paper P120;
Reinforced polyester	:	dry and free from any contamination such as grease, oil, loose particles, sanded with grit paper P120-180 and degreased with Double Coat degreaser;
Other substrates	:	clean and dry, in good condition, free from any contamination and loose particles, pre-treated with IJmopox ZF primer or Variopox Injection resin.

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

**INSTRUCTIONS FOR USE**

Before use, mix base and hardener components thoroughly.

Mixing ratio : 67,0 base : 33,0 hardener (by weight)  
67,0 base : 33,0 hardener (by volume)

Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : none  
 Pot life : 15 minutes at 25 °C  
 30 minutes at 20 °C  
 40 minutes at 15 °C

Application with :

	Putty knife
Type thinner	n.a.
% of thinner	
Nozzle orifice	n.a.
Nozzle pressure	n.a.
Cleaning	Double Coat Degreaser

Do not add any solvent to Variopox Filler.

#### ADDITIONAL INFORMATION

- Recoating and curing of Variopox Filler:

	15 °C	20 °C	25 °C
Minimum, with IJmopox ZF primer or IJmopox HB coating, after sanding with P120-180	3 days	2 days	1 day
Maximum, with IJmopox ZF primer or IJmopox HB coating, after sanding with P120-P180	unlimited	unlimited	unlimited
Fully cured after	4 days	2 days	2 days

We recommend to apply to Variopox Filler first a coat of IJmopox ZF primer or IJmopox HB coating before a finishing coat of Double Coat is applied. Only small repairs of Variopox Filler can be recoated directly with Double Coat. In that case we recommend to apply two touch-up coats.

- Pot life  
Do not continue application when the pot life is about to end. As the reaction between base and hardener has progressed, a poor adhesion will be the result.

#### SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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#### Disclaimer

*Although the information and recommendations are presented in good faith and believed to be correct at date of issue, De IJssel Coatings B.V. makes no representations as of the completeness or accuracy thereof. In no event De IJssel Coatings B.V. will be responsible for damages of any nature whatsoever resulting from the use of this information.*