

Fine Filler 303

Technical Data Sheet: 154-22
P3033

1. Introduction

ALEXSEAL® Fine Filler 303 is a solvent-free, epoxy-based filler which cures without shrinking into a water resistant solid coating. This is an ideal product to use between ALEXSEAL® Fairing Compound 202 and ALEXSEAL® Super Build 302 or ALEXSEAL® Finish Primer 442.

ALEXSEAL® Fine Filler 303 is fast drying and has excellent sanding characteristics.

The cured film offers superior mechanical resistance values.

2. Range of application

ALEXSEAL® Fine Filler 303 is used to even out imperfections on appropriately prepared surfaces and can be used for surfaces above and below the waterline. If ALEXSEAL® Fine Filler 303 is used below the waterline it must be sealed with ALEXSEAL® Super Build 302 and ALEXSEAL® Finish Primer 442.

3. Color

Color of mixture: Sand
Base material: Light Gray
Converter: Beige

4. Coverage

Volume Solids mixed material: 100 %

Coverage for ALEXSEAL® Fine Filler 303 will be based on the depth of filling required as well as the size of the surface to be faired.

Note: Coverage rates are figured for base and converter.

| | m ² / liter | m ² / gal | sq. ft. / gal | @ DFT in μm (mils) |
|--------------------|------------------------|----------------------|---------------|--------------------|
| Theoretical | 1 | 3.8 | 41 | 50 (2) |
| Practical | 1 | 3.8 | 41 | 50 (2) |

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust, grease, oil and other contamination.

ALEXSEAL® Fine Filler 303 may be applied as a high film surfacer over ALEXSEAL® primers and fillers or gel coat and raw resin lay-up. The surface must be sanded with 80 - 150 grit. Fiberglass resin should be ground with 36 - 60 grit and / or sand blasted. The surface and the bottom of any fiberglass profile should be dull and abraded with no shiny spots.

ALEXSEAL® Fine Filler 303 should be sealed with ALEXSEAL® Super Build 302 and ALEXSEAL® Finish Primer 442 prior to topcoating.

Optimum mechanical resistance values are achieved by proper surface preparation.

6. Trade names

Base Material P3033 ALEXSEAL® Fine Filler 303
Converter C3034 ALEXSEAL® Fine Filler 303 Converter

7. Mixing ratio

2 parts by volume P3033 ALEXSEAL® Fine Filler 303
1 part by volume C3034 ALEXSEAL® Fine Filler 303 Converter

ALEXSEAL® Fine Filler 303 must not be reduced

Professional Use Only

Page 1 of 2

The information contained in this data sheet is based on our level of research and development. Revisal by the user with regard to the intended aim is necessary due to the diverse processing and application possibilities. revision January 2011

Fine Filler 303

Technical Data Sheet: 154-22
P3033

8. Application

Application equipment: Trowels, spatulas, straight edge materials

The components of ALEXSEAL® Fine Filler 303 have different colors to control the mixing process. After mixing, the color of the fillers should be a homogeneous color. If the base and converter are not mixed thoroughly, it could result in an improperly cured batch. Mixing can be done mechanically with slow turning dough mixers or manually. Do not use drill mixers. The mixing in of air bubbles should be avoided.

The material can be easily applied by spatula or trowel; inclusion of air pockets should be avoided. Applying the product to the surface in thin layers and working up to the desired thickness before pulling the product out with a straight edge will help avoid creating air pockets in the applied product.

For equipment cleaning use R4042 ALEXSEAL® Epoxy Primer Reducer. ALEXSEAL® Fine Filler 303 should be block sanded with 100 - 150 grit. Block sanding with 150 grit or finer will help prevent sand scratch print through in the finished system.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

| Temperature for minimum time | 15°C (60°F) | 20°C (68°F) | 25°C (77°F) | 30°C (85°F) | Max Time |
|------------------------------|-------------|-------------|-------------|-------------|----------|
| Pot Life – approx. | 2 hrs | 90 min | 45 min | 30 min | N/A |
| Dry to sand | 48 hrs | 24 hrs | 18 hrs | 12 hrs | N/A |
| Tape Dry | 48 hrs | 24 hrs | 18 hrs | 12 hrs | N/A |
| Fully Cured | 9 days | 7 days | 5 days | 3 ½ days | N/A |

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will effect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

Recoating of ALEXSEAL® Fine Filler 303 over itself should follow minimum dry to sand times. Scratch sanding with 80 to 120 grit is recommended to ensure adhesion between the layers of 303. Overcoating with 302 and 442 can be applied after the minimum time and after the surface has been block sanded with 100 to 150 grit. Finishing the block sanding with 150 grit or finer will help prevent sand scratch print through in the final finish.

10. Packaging

| | | |
|-------|-------------------------------------|-------|
| P3033 | ALEXSEAL® Fine Filler 303 | 1 Gal |
| C3034 | ALEXSEAL® Fine Filler 303 Converter | ½ Gal |

Professional Use Only

Page 2 of 2

The information contained in this data sheet is based on our level of research and development. Revisal by the user with regard to the intended aim is necessary due to the diverse processing and application possibilities. revision January 2011