

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 Super Build 302 or Finishing Primer 401.

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[®] Finishing Primer 401.

3. Color

Color of mixture:		Sand
Base material:	P3033	Light Gray
Converter:	C3034	Beige

4. Coverage

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.

Volume Solids catalyzed without reduction: 100 %

Theoretical: 1 m² / l (41 sq. ft. per gallon) at a dry film thickness of 1 mm (0.04 inch, 40 mils).

Practical: 1 m² / l (41 sq. ft. per gallon) at a dry film thickness of 1 mm (0.04 inch, 40 mils).

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 onto sanded fillers such as ALEXSEAL[®] Fairing Compound 202. After finish sanding the ALEXSEAL[®] Fairing Compound 202 with 80 to 150 grit, the surface must be dusted off thoroughly before applying ALEXSEAL[®] Super Build 302.

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

ALEXSEAL[®] Fine Filler 303 should be sealed with ALEXSEAL[®] Finishing Primer 401 prior to topcoating.

To ensure optimum adhesion, the substrate must be ground and/or blasted with (36 to 60 grit) before fairing to ensure system adhesion. Full fairing systems require a heavily abraded substrate. Thin fairing systems of less than 3 mm (1 / 8 - 0.012 inch) will require a less aggressive profile to anchor the system.

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

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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

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
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 other products 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.					
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, direct or non-direct sunlight, and film thickness will effect actual times during application.					
During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 20°C (68°F)					

10. Packaging

P3033 ALEXSEAL® Fine Filler 303 2 Gal
C3034 ALEXSEAL® Fine Filler 303 Converter 1 Gal

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