

# Spray Fair 328

Technical Data Sheet:  
153-30 / **P3280**

- 1. Introduction** ALEXSEAL® Spray Fair 328 is an epoxy-based, sprayable filler surfacer, which provides the ideal product for yachts that require filling and fairing.
- ALEXSEAL® Spray Fair 328 has excellent application, sanding and anti-sagging properties. It is designed to be easy to mix and apply, while the cured film provides an excellent surface for re-coating with other ALEXSEAL® products.
- 2. Range of application** ALEXSEAL® Spray Fair 328 is used for fairing all appropriately prepared surfaces and can be used for surfaces above the waterline only.
- 3. Color**
- |                   |        |
|-------------------|--------|
| Color of mixture: | Tan    |
| Base material:    | Tan    |
| Converter:        | Yellow |
- 4. Coverage** Coverage for ALEXSEAL® Spray Fair 328 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: 71 % (vol.)
- Theoretical:** 3 m<sup>2</sup> / l (33 sq. ft. per gallon) at a dry film thickness of 900 microns (36 mils).
- Practical:** 2 m<sup>2</sup> / l (22 sq. ft. per gallon) at a dry film thickness of 900 microns (0.04 inch, 36 mils).
- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination.
- To ensure optimum adhesion, the substrate must be ground and /or blasted with (36 to 60 grit) before priming 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. Priming is required on most substrates before application of ALEXSEAL® Spray Fair 328.
- For metal substrates - optimum mechanical and corrosion resistance values are achieved by proper surface preparation and substrate priming with ALEXSEAL® Protective Primer 101.
- For GRP substrate, use ALEXSEAL® Finish Primer 442, Finishing Primer 401 or Super Build 302. The ALEXSEAL® Primer should be sanded with 60 - 80 grit, after over night dry, before application of ALEXSEAL® Spray Fair 328.
- For custom applications over substrates including epoxy resins, contact your ALEXSEAL® representative.
- 6. Trade names**
- |               |       |                                    |
|---------------|-------|------------------------------------|
| Base Material | P3280 | ALEXSEAL® Spray Fair 328           |
| Converter     | C3287 | ALEXSEAL® Spray Fair 328 Converter |
| Reducer       | R3040 | ALEXSEAL® High Build Epoxy Reducer |
- 7. Mixing ratio**
- |                            |       |                                    |
|----------------------------|-------|------------------------------------|
| 1 part by volume           | P3280 | ALEXSEAL® Spray Fair 328           |
| 1 part by volume           | C3287 | ALEXSEAL® Spray Fair 328 Converter |
| 10 - 25 % reduction (vol.) | R3040 | ALEXSEAL® High Build Epoxy Reducer |
- Example: 1 : 1 : 1/5 - 2/5 = 10 - 20 % reduction

**Professional Use Only**

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## 8. Application

Fluid Nozzle Size	2.2 - 2.8 mm (0.08 - 0.110 inch) - Conventional & HVLP
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI) - Conventional & HVLP
Pot Pressure	1 to 1.5 bar (15 to 20 PSI) - Conventional & HVLP
Airless Equipment	Tip 0.43 - 60 to 0.60 - 60 mm (0.017 - 60 to 0.024 - 60)
Airless Equipment	Pressure 3.0 to 5.0 bar (43 to 72 PSI)

The components of ALEXSEAL® Spray Fair 328 have different colors to ensure thorough mixing. After mixing, the color of the material should be a homogeneous tan color. If they are not mixed thoroughly, it could result in an improperly cured batch. Mixing can be done mechanically with a slow turning dough mixer or manually. The mixing in of air bubbles should be avoided.

Apply 3 coats to a wet film thickness (WFT) of 375 - 500 microns (15 - 20 mils) per coat. This will achieve a dry film thickness (DFT) of 800 - 1075 microns (32 - 43 mils) for a 3 coat application, using 20 % reduction. Maximum dry film thickness per coat is 500 microns (12 mils). Maximum recommended film thickness during a spray application is 3 coats totaling 1500 microns (60 mils) WFT, or 1075 microns (43 mils) DFT. Do not apply more than 3 coats without allowing to cure overnight and sanding the surface.

ALEXSEAL® Spray Fair 328 should be block sanded with 80 - 120 grit. Block sanding with 120 grit or finer will help prevent sand scratch print through in the finished system.

**Note:** This is a solvent based sprayable fairing compound. Solvent entrapment can be caused by heavy film thickness when over coating too quickly with the same product or other products, and by low temperature or slow drying time. Mankiewicz Gebr. & Co. will not accept liability for any damages.

## 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	8 hrs	8 hrs	8 hrs	8 hrs	8 hrs
Dry to sand	3 - 4 days	2 days	1 day	1 day	N/A
Fully cured	2 weeks	1 week	5 days	4 days	N/A
Recoat after tack up with additional ALEXSEAL® Spray Fair 328	4 hrs	2 hrs	1 hrs	1 hrs	24 hrs

Recoating of ALEXSEAL® Spray Fair 328 over itself within the recommended times above is important to avoid trapping of solvents. Trapped solvents will cause blistering and splitting of this coating as well as retarding the time to sand. Max 3 coats in one application, sand after 24 hrs dry before additional application.

ALEXSEAL® Spray Fair 328 is porous. It must be sealed with ALEXSEAL® Super Build 302 before applying a final primer or topcoat. 302 can be applied after the surface has been fully cured and block sanded with 80 to 120 grit. Finishing the block sanding with 120 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, 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).

## 10. Packaging

P3280	ALEXSEAL® Spray Fair 328	1 Gal
C3287	ALEXSEAL® Spray Fair 328 Converter	1 Gal
R3040	ALEXSEAL® High Build Epoxy Reducer	1 QT & 1 Gal

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