

Technical Data

PENGUIN EPOXY FILLER



Product description

Penguin Epoxy Filler is a high-density hand-applied two-component epoxy fine/finishing filler that leaves a smooth and strong surface. It has good resistance to water and solvent, has very strong cohesion/adhesion properties and is more flexible than most epoxy fillers. Sandability is good with an approximate Shore D hardness of 75. Note: Penguin Epoxy Filler has a much lower viscosity than Penguin Lightweight Filler.

Recommended use

Penguin Epoxy Filler is suitable for above and below-water application, when part of an approved Jotun system. Normally used to finish surfaces treated with Penguin Lightweight Filler, in preparation for sealing with a solvented epoxy coating.

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (μm)	100	3000	1000
Film thickness, wet (μm)	100	3000	1000
Theoretical spreading rate (m^2/l)	9.8	0.33	1.0

Physical properties

Colour	Off-white
Solids (vol %)*	98 \pm 2
Flash point	>55°C \pm 2 (Setaflash)
Specific gravity	0,92 lbs/gal (110 gms/ltr) USA-EPA Method 24
VOC	10 gms/ltr UK-PG6/23(97). Appendix 3

*Measured according to ISO 3233:1998 (E)

Surface preparation

The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

Apply at a temperature between 10°C and 35°C. The temperature of the substrate should be minimum 3°C above the dew point of the air. The temperature and the relative humidity should be measured in the vicinity of the substrate.

Application data

Mixing ratio (volume)	1:1
Mixing	1 part base : 1 part hardener (by volume, not by weight). Mix the two components thoroughly until the colour is an even offwhite colour. Mix by towel or through an approved filler mixing machine.
Pot life (23°C)	45 minutes. (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 17 to clean equipment.
Note	This product shall not be thinned. May be sanded after 16-24 h (dependent on temperatures)

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Typical film thickness
- * One coat on top of inert substrate

Substrate temperature	10°C	23°C	40°C
Surface dry	16 h	13 h	7 h
Dry	48 h	14 h	10 h
Cured	14 d	7 d	3 d
Dry to recoat, minimum	8 h	5 h	2 h
Dry to recoat, maximum¹	60 h	48 h	32 h

1. Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Instructions for use:

Apply Penguin Epoxy Filler onto suitable epoxy products such as Penguin Lightweight Filler, Penguin Epoxy HB, Penguin Antipest o Megaprimer. May also be applied over prepared polyurethanes such as Megagloss. For maximum intercoat adhesion, sand each layer of Penguin Epoxy Filler. Seal Penguin Epoxy Filler with two coats of a suitable epoxy coating such as Megaprimer. Note: Penguin Epoxy Filler may be mixed with Penguin Lightweight Filler. However, mixing in this way should be done in a controlled way - consult Jotun.

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care.

Packing size

1 litre Comp. A and 1 litre Comp. B

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

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