

AMFAIR 320 FAST

EPOXY FINE FAIRING COMPOUND

INTRODUCTION

AMFAIR 320 FAST is a two part epoxy fine filler designed for use over **AMFILL 96** to fill pin holes and small surface defects prior to the application of finishing coats of primers and paints. **AMFAIR 320 FAST** can also be applied to GRP composites, aluminium and steel substrates. Smooth application makes **AMFAIR 320 FAST** suitable for various applications that require a non-shrink, water resistant and highly adhesive epoxy fine filler.

MIXING INSTRUCTIONS

Mix **AMFAIR 320 FAST** Resin (white) and **AMFAIR 320 FAST** Hardener (white) at the following ratio:

By weight: 100 PARTS RESIN : 25 PARTS HARDENER

Mix the two components to thoroughly at a temperature above 15°C ambient. Mix to minimize air entrapment.

STANDARD SURFACE PREPARATION

All surfaces should be clean, dry prior to application.

For previously faired and painted surface: abrade with 150 to 200 grit paper. Wash surface with soap and water. Rinse thoroughly and allow to dry.

Note: If surface is in poor condition then all paint coatings should be removed before preparing substrate as above.

For GRP composites: Abrade with 80 to 150 grit paper. Remove all dust with an airline or vacuum before fairing.

For Steel: 80 grit Sand blast to mechanically key surface and to remove all oxidation. Apply suitable primer to surface prior to fairing.

For Aluminium: Abrade with 150 to 200 grit paper to mechanically key surface and to remove any oxidation and surface contamination. **AMFAIR 320 FAST** should be applied immediately to the prepared surface to prevent further oxidation.

APPLICATION

Apply with trowel, splining tool, pallet knife or stiff squeegee in one application.

Should a thickness of more than 2 to 3mm be required, then we recommend fairing first with **AMFILL 96**.

Should a second application of **AMFAIR 320 FAST** be required, it may be applied whilst the original **AMFAIR 320 FAST** surface is still soft and tacky. If the surface is touch dry then the surface should be prepared using the standard surface preparation technique.

SANDING

AMFAIR 320 FAST will become easier to sand if left longer than the minimum sanding period.

After full cure, sanding may be done with fine grit paper.

Minimum cure prior to sanding:	25°C 3 hours	15°C 6 hours
Full cure:	28 Days at 21 Deg C	

Note: As with all two-part epoxy systems the pot life is determined by the ambient temperature. The higher the ambient temperature the shorter the pot and ultimately, the working life of the product.

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PRIMING AND PAINTING

AMFAIR 320 FAST will accept most types of paint once it has achieved its full cure period. Prepare surface as outlined in “standard surface preparation”.

TECHNICAL SPECIFICATIONS

Resin colour	-	White
Hardener colour	-	White
Mixed colour	-	White
Density	-	1,5g/cm ³
Coverage (1,0 mm thickness)	-	1.5kg
Shrinkage (volumetric)	-	less than 0,15%
Tg	-	70°C (base resin unfilled)
Minimum working temperature	-	15°C (Recommended)
Maximum working humidity	-	98%
Pot life @ 15°C (500gm)	-	± 25 Minutes
Pot life @ 25°C (500gm)	-	± 12 Minutes
Gel time @ 15°C (1mm)	-	45 Minute
Gel time @ 25°C (1mm)	-	23 Minutes
Pack sizes	-	1.6 kg resin : 0.4 kg hardener
	-	5 kg resin : 1.25 kg hardener

SAFETY CONDITIONS

Use safety gloves and barrier cream. Do not inhale dust and protect eyes. Clean hands with suitable cleaner after use.

STORAGE

Shelf life is 1 year. Store in cool dry conditions. Dispose of empty containers responsibly.

The information give in this data sheet results from tests we have completed and are considered as correct. Our tests are carried out under specific conditions therefore we cannot guarantee that applications made under different conditions would give the same results. We therefore recommend that you conduct your own tests under your specific working conditions.