



**PRODUCT DATA SHEET**  
**AMFILL 96**  
**LIGHTWEIGH EPOXY FILLER**

INTRODUCTION

AMFILL 96 is a LIGHTWEIGHT two part epoxy filler. Smooth application and easy sanding qualities makes AMFILL 96 suitable for various applications that require a non-shrink, water resistant and highly adhesive epoxy filler.

MIXING INSTRUCTIONS

Mix AMFILL 96 Resin (white) and AMFILL 96 Hardener (grey) at the following ratio:

100 PARTS RESIN to 30 PARTS HARDENER by **WEIGHT**

AMFILL 96 can be mixed by VOLUME at a ratio of 100 parts resin to 35 parts hardener. This is **not recommended** however, due to volumetric changes caused by temperature fluctuations and product “settling” following manufacture.

Mix the components at a temperature above 15°C ambient. Mix to minimize air entrapment. The contrasting colour of the hardener (GREY) will assist in obtaining a consistent mixture.

STANDARD SURFACE PREPARATION

Abrade with medium to fine grit paper and remove dust with compressed air or vacuum. Wipe with acetone prior to applying AMFILL 96. AMFILL 96 may be applied to epoxy, polyester, wood, steel, aluminium and concrete surfaces. On aluminium surfaces the prepared surface should be coated with a layer of AMT laminating resin LR-20/LH-281. This surface should be fully cured, abraded, vacuumed clean and or de-greased prior to applying AMFILL 96. Ensure that all surfaces are fully cured, cleaned and prepared prior to the application of AMFILL 96.

APPLICATION

Apply with trowel, splining tool or pallet knife in a 2 – 5mm thickness in one application. AMFILL 96 may be applied up to 15mm thick in cooler temperatures (between 15 – 20°C)

SANDING AMFILL 96

AMFILL 96 will become easier to sand if left longer than the minimum sanding period. After full cure, sanding may be done with finer grit paper.

	<u>25°C</u>	<u>15°C</u>
Minimum cure prior to sanding	16 hours	24 hours
Full cure	7 days	14 days

AMFILL 96 may be planed using hand or power tools prior to final contour sanding.

Should over-coating with AMFILL 96 be required, it may be applied whilst the original AMFILL 96 surface is still soft and tacky. If the surface is fully cured prepare the surface using the standard surface preparation technique.

### PRIMING AND PAINTING AMFILL 96

AMFILL 96 will accept most types of paint once it has achieved its full cure period. Prepare AMFILL 96 surface for painting by following paint manufacturers surface prep recommendations.

### TECHNICAL SPECIFICATIONS

Resin colour	-	White
Hardener colour	-	Grey
Mixed colour	-	Light grey
Density	-	0,50g/cm <sup>3</sup>
Coverage (1,0 mm thickness)	-	± 500gm
Shrinkage (volumetric)	-	less than 0.25%
Heat deflection temperature	-	70°C (base resin unfilled)
Minimum working temperature	-	13°C
Maximum working humidity	-	98%
Pot life @ 15°C	-	± 1 hour
Pot life @ 25°C	-	± 30 minutes
Working life @ 15°C	-	3 hours
Working life @ 25°C	-	1 hour
Pack size	-	2.6 kg Resin + 0.78kg Hardener (± 6.75 litres) 0.52kg Resin + 0.16kg Hardener ((± 1.4 litres)

### HEALTH AND SAFETY

Use safety gloves and barrier cream. Do not inhale dust and protect eyes. Clean hands immediately with hand cleaner if in contact with AMFILL 96.

### STORAGE

Shelf life is 1 year. Keep in a cool environment. Base resin and hardener can separate if stored for long periods. Therefore mix both components separately before mixing for use.

*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.*

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