

## Mix Fill 30 - Mix Fill 10

### Formulated Fillers For Sandable Coating

#### Description

|                                |   |
|--------------------------------|---|
| <b>Appearance:</b>             | Powders   |
| <b>Type:</b>                   | Formulations based on hollow microspheres and inorganic fillers         |
| <b>Compatibility:</b>          | Epoxy, polyester, vinylester and polyurethane resins                    |
| <b>Application:</b>            | Manufacturing of putties for sandable coating from medium to fine grain |
| <b>Temperature resistance:</b> | over 100°C (fillers only)   |
| <b>Chemical resistance:</b>    | Water, acids and organic bases, solvents                                |

**Mix Fill 30:** Economical, relatively hard. Use for important thickness, fairing.

**Mix Fill 10:** Soft, ease of sanding, fine grain. Used before the polyurethane or epoxy primer

|                                      | Mix Fill 30                                    | Mix Fill 10              |
|--------------------------------------|--|--------------------------|
| Application                          | undercoat                                      | Coating before finishing |
| Applicable thickness                 | 3 cm   | Less than 1cm            |
| Apparent density g/l                 | 300  | 100                      |
| Density of the mix g/l $\pm$ 30      | 730  | 680                      |
| Colour of the mix                    | Cream  | Grey                     |
| Tolerance of the mix ratio           | Excellent                                      | Very good                |
| Hardness for sanding                 | Medium   | Soft                     |
| Abrasive clogging                    | Low clogging                                   | Very low clogging        |
| Mix ratio SR 1610 / SD 2613 (R/H)    | 100 g / 47 g or 100 ml / 50 ml (2/1 by volume) |                          |
| Mix ratio for 100 g R/H $\pm$ 3 g    | <b>77 g</b>                                    | <b>27 g</b>              |
| Mix ratio for 100 ml R/H $\pm$ 30 ml | <b>270 ml</b>                                  | <b>270 ml</b>            |
| Cost indicator                       |  |                          |
| Price for filler only                | 1  | 3.6                      |
| Price for mix in kg                  | 1  | 1.5                      |
| Price for mix in liter               | 1  | 1.4                      |

R/H : Resin / Hardener

#### Reactivity

|   | @ 20°C | @ 25°C |
|---|--------|--------|
| Pot-life of <b>SR 1610 / SD 2613</b> on 500 g mix | 60'    | 35'    |
| Working time of 3 mm thick coat of putty          | 2 h    | 1 h 30 |
| Putty in a coat of 3 mm sandable after            | 20 h   | 16 h   |

#### Packaging Mixfill 10

| Volume of the kits  | Weight of the kits | SR 1610     | SD 2613     | Fillers     |
|---------------------|--------------------|-------------|-------------|-------------|
| 660 liters of putty | 448.80 kg          | 1 x 240 kg  | 4 x 28.2 kg | 4 x 24 kg   |
| 165 liters of putty | 112.20 kg          | 2 x 30 kg   | 1 x 28.2 kg | 1 x 24 kg   |
| 28 liters of putty  | 18.70 kg           | 1 x 10 kg   | 1 x 4.7 kg  | 2 x 2 kg    |
| 14 liters of putty  | 9.35 kg            | 1 x 5 kg    | 1 x 2.35 kg | 1 x 2 kg    |
| 3 liters of putty   | 1.96 kg            | 1 x 1.05 kg | 1 x 0.49 kg | 1 x 0.42 kg |

### Mixfill 30

| Volume of the kits  | Weight of the kits | SR 1610     | SD 2613     | Fillers     |
|---------------------|--------------------|-------------|-------------|-------------|
| 895 liters of putty | 652.80 kg          | 1 x 240 kg  | 4 x 28.2 kg | 6 x 50 kg   |
| 258 liters of putty | 188.20 kg          | 2 x 30 kg   | 1 x 28.2 kg | 2 x 50 kg   |
| 37 liters of putty  | 26.70 kg           | 1 x 10 kg   | 1 x 4.7 kg  | 2 x 6 kg    |
| 18 liters of putty  | 13.35 kg           | 1 x 5 kg    | 1 x 2.35 kg | 1 x 6 kg    |
| 4 liters of putty   | 2.79 kg            | 1 x 1.05 kg | 1 x 0.49 kg | 1 x 1.25 kg |

## Surface Preparation

### Epoxy : Laminated Wood, Sandwich Structures

Degreasing( water-soluble detergent, spirit ), sanding, dust removal.

**NB:**The order of operations must be respected !

Direct application if prepared with **Peeltex** ( peel ply), remove the **Peeltex** just before painting

( protection of the surface against workshop pollution )

### Immersed steel

SA 2.5 sandblasting or ST 3 needle gun : coarseness 25-75 microns

Application of one coat of **Seaprim EP 140**, then a coat of **Seacoat EP 215 HB**

**NB:** If the Mixfill system can be applied directly on the **Seaprim EP 140**, a cleaning of the surface with Ethanol followed by a light sanding with Scotch Brite 3M (medium grit) is required.

Nevertheless, it is safer to apply a coat of **Seacoat EP 215 HB** in order to have a coat thick enough for sanding before applying the Mixfill without going through the **Seaprim EP 140**. The recoating time is longer with this coat of **Seacoat EP 215 HB**.

### Aluminium:

Degreasing, sanding with 24/36 or fine sandblasting

Apply one coat of **Wash Primer WP 110**, then one coat of **Seaprim EP 140**

### Old Or Osmosed Polyester Composite

Degreasing then sanding, Sandblasting or planing of the gelcoat.

→ Substrate with less than 300 microns of porosity ( sanded surface 80/120 ): 1 coat of **Seacoat EP 215**, let polymerise for 24 hours at ambient temperature ( above 15°C ).

→ Sandblasted substrate, Fiber or chopped strand mat highly aggressed, high porosity :one coat of epoxy resin without solvent. Application of **Mix Fill** just after, before the epoxy resin is gelled , or on cured resin completely degreased and sanded with 80/120.

Consult our paint manual or our technical department for more informations.

## Proportions / Mixing

Respect the resin / hardener ratio, Mix thoroughly the components.

Measure out accurately and use the adapted tools, in accordance with the prepared quantity.

Incorporate the **Mixfill** filler in several stages to the mix resin / hardener

For quantities over 300 ml of putty, use a slow mechanical stirrer.

## Estimated consumption

A coating of 1 mm onto 1 m<sup>2</sup> uses 1 liter of mix

### Weather conditions



The temperature of the substrate will be 3°C higher than dew point.

Avoid applying in wet weather and when the ambient temperature is below 15°C

Keep packaging closed, away from moisture, at a temperature of 15 to 30°C.

Protect the coating from rain for 7 days.

### Following coats

The first coating must be completely sanded and free of dust before a new application.



**SR 1610 / SD 2613 / Mix Fill 10** :coating for finish. Medium to fine sanding prior painting.



**Seacoat EP 215 HB** : - 2 coats on the areas that are not immersed.  
- 3 to 4 coats on the immersed areas.

### Health and safety

**SD 2613** is corrosive : - Avoid any contact with skin and eyes.

- Handle with disposable or rubber gloves

Do not wash hands with solvent but with soap or **Proclean** and water.

In confined spaces, ventilate the working area.

During the sanding phases, wear a dust mask.

### Waste



Respect the environment :Do not throw away into the waste pipe.

The informations that we give by writing or verbally, in the context of our technical assistance and our trials, do not engage our responsibility. We advice the users of SICOMIN's epoxy system, to verify by some practical trials if our products are suitable for the envisaged processes and applications. The use, the implementation and the transformation of the supplied products, are not under our controle and your responsibility only will respond for it.

If our responsibility should nevertheless be involved, it would be, for all the damages, limited to the value of the goods supplied by us and implement by you. We guaranty the non-reproachable quality of our products, in the general context of sales and delivery.