

## Megafiller

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### Product description

This is a two component epoxy fairing compound/filler. It is an ultra lightweight, very flexible, solvent free product. It has excellent application and sanding properties, strong adhesion and minimal shrinkage. Suitable for correctly prepared primed surfaces on carbon steel, aluminium, composite and wood substrates.

### Scope

The Application Guide offers product details and recommended practices for the use of the product.

The data and information provided are not definite requirements. They are guidelines to assist with efficient and safe use, and optimum service of the product. Adherence to the guidelines does not relieve the applicator of responsibility for ensuring that the work meets specification requirements. Jotuns liability is in accordance with general product liability rules.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

### Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

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### Surface preparation

The required quality of surface preparation can vary depending on the area of use, expected durability and if applicable, project specification.

When preparing new surfaces, maintaining already coated surfaces or aged coatings it is necessary to remove all contamination that can interfere with coating adhesion, and prepare a sound substrate for the subsequent product.

Inspect the surface for hydrocarbon and other contamination and if present, remove with a pH-neutral detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area using fresh water.

Paint solvents (thinners) shall not be used for general degreasing or preparation of the surface for painting due to the risk of spreading dissolved hydrocarbon contamination.

### Process sequence

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter, treatment of welds and application of an epoxy primer is complete. It is important that all hot work is completed before coating commences.

### Coated surfaces

#### Verification of existing coatings including primers

When the surface is an existing coating, verify with technical data sheet and application guide of the involved products, both over coatability and the given maximum over coating interval.

#### Organic primers/intermediates

New Jotun Yachting epoxy primer:

Clean, dry and undamaged compatible coating.

The coating should be clean, dry and undamaged. Remove any contamination prior to carrying out any operation; it is strongly recommended to promote adhesion by sanding with aluminium oxide or silicone carbide sand paper with grit P80-P120 and then vacuum cleaning.

Cured Jotun Yachting epoxy primer:

Exceeding maximum recoat intervals will require cleaning/abrading by orbital sanding or hand sanding with aluminium oxide or silicon carbide sand paper with grit P80-P120, followed by vacuum cleaning. Before sanding, check if the coating is clean, dry and undamaged. If required, additional coats should be applied.

### Other surfaces

Epoxy filler:

Clean, dry and undamaged compatible fairing compound.

Sand the surface to remove irregularities and promote adhesion (orbital or hand sanding with aluminium oxide or silicon carbide sand paper with grit P40-P120). Remove any contamination that could interfere with the intercoat adhesion by vacuum cleaning. Removal of any other contamination should be discussed with your local Jotun coating advisor.

## Application

### Acceptable environmental conditions - before and during application

Before application, test the atmospheric conditions in the vicinity of the substrate for the dew formation according to ISO 8502-4.

Air temperature	15 - 35	°C
Substrate temperature	15 - 35	°C
Relative Humidity (RH)	10 - 85	%

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3 °C (5 °F) above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

## Product mixing

### Product mixing ratio (by volume)

Megafiller Comp A	1 part(s)
Megafiller Comp B	1 part(s)

### Product mixing ratio (by weight)

Megafiller Comp A	1 part(s)
Megafiller Comp B	1 part(s)

### Product mixing

Mix the two components thoroughly until an even colour.

It is recommended that each component is thoroughly pre-mixed to a uniform consistency before mixing component A and B together. The components should be mixed together preferably at 15 °C - 25 °C. At lower temperatures the product thickens and is more difficult to mix.

### Induction time and Pot life

**Paint temperature** **23 °C**

Pot life 30 min

Increase of temperature will reduce the pot life. Pot life is dependant on the amount mixed.

### Thinner/Cleaning solvent

Do not add thinner.

Cleaning solvent: Jotun Thinner No. 17

### Application data

#### Other application tools

Trowel, pallet knife, fairing board or other suitable tools.

## Film thickness per coat

#### Typical recommended specification range

Dry film thickness	500 - 10000 µm
Wet film thickness	500 - 10000 µm
Theoretical spreading rate	2 - 0.01 m <sup>2</sup> /l

In order to minimize shrinkage stress within the dry film and to prevent possible air entrapment, a typical DFT of 5 mm is recommended per layer. However a maximum of 10 mm DFT per layer can be applied without affecting product performance.

Jotun's Megafiller is a cosmetic fairing compound to be applied up to a total maximum DFT of 30 mm over multiple layers. Localized application above the total maximum DFT value is possible in low-stress areas, but needs to be discussed with your Jotun Technical Service and Support representative.

For further advice please contact your local Jotun office.

## Drying and Curing time

Substrate temperature	15 °C	23 °C	35 °C
Surface (touch) dry	24 h	16 h	4 h
Dried/cured for sanding	48 h	22 h	16 h
Dried/cured for service	14 d	7 d	3 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and at the typical DFT for the product.

For best possible adhesion and performance of the product, it is required to sand the filler between overcoating. See Surface Preparation section for more details.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Dried/cured for sanding: The state of drying when a coating film can be sanded without the sandpaper sticking or clogging.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Maximum over coating intervals

To secure lasting adhesion to the subsequent product or coats, all surfaces shall be sanded, clean, dry and free from any contamination (for more information, please refer to Surface preparation section). To avoid irreversible contamination of the freshly sanded and cleaned surface, the filler should be overcoated as soon as possible with another coat or subsequent product. This will reduce the risk of poor intercoat adhesion.

## Quality assurance

The following information is the minimum required. The specification may have additional requirements.

- Confirm that installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm that the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendations in the AG, and are held during the application
- Confirm that each coat meets the DFT requirements in the specification
- Confirm that the coating has not been adversely affected by rain or other factors during curing
- Observe that adequate coverage has been achieved on corners, crevices and edges.
- Observe that the coating is free from any defects.
- Observe that the uniformity and colour are satisfactory

All noted defects shall be fully repaired to conform to the coating specification.

### Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

### Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

### Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

### Colour variation

Colour variation may occur from batch to batch.

### Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

## Symbols and abbreviations

min = minutes

h = hours

d = days

°C = degree Celsius

° = unit of angle

µm = microns = micrometres

g/l = grams per litre

g/kg = grams per kilogram

m<sup>2</sup>/l = square metres per litre

mg/m<sup>2</sup> = milligrams per square metre

psi = unit of pressure, pounds/inch<sup>2</sup>

Bar = unit of pressure

RH = Relative humidity (% RH)

UV = Ultraviolet

DFT = dry film thickness

WFT = wet film thickness

TDS = Technical Data Sheet

AG = Application Guide

SDS = Safety Data Sheet

VOC = Volatile Organic Compound

MCI = Jotun Multi Colour Industry (tinted colour)

RAQ = Required air quantity

PPE = Personal Protective Equipment

EU = European Union

UK = United Kingdom

EPA = Environmental Protection Agency

ISO = International Standards Organisation

ASTM = American Society of Testing and Materials

AS/NZS = Australian/New Zealand Standards

NACE = National Association of Corrosion Engineers

SSPC = The Society for Protective Coatings

PSPC = Performance Standard for Protective Coatings

IMO = International Maritime Organization

ASFP = Association for Specialist Fire Protection

## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

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If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.

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