Data Sheet

2C Epoxy Repair Filler 599

Two-component universal filler, easy to sand, for exterior and interior use

Field of application

For filling defective areas in wood and metal, for exterior and interior use. Particularly suited to fill cracks and holes in dimensionally stable components, e.g., wooden windows.

Properties

- Two-component Universal Filler on an epoxy resin base
- For interior and exterior use
- Good filling power
- Easy to sand
- Very good adhesion
- Can be coated with any alkyd or acrylic paint

Material description

Color shade	beige
Degree of gloss	matt
Max. layer thickness	Approx. 4 cm on horizontal surfaces Approx. 2 cm on vertical surfaces
Base material	Component A: Modified epoxy resin Component B: Modified amine
Density	Component A: Approx. 1.50 g/cm³ Component B: Approx. 1.35 g/cm
Flash point	Component A: >100°C Component B: >92 °C
Packaging	Set consisting of two cartridges, 300 ml each

Use

Mixing ratio	Mix volume fractions of the two components in a ratio of 1:1. Ensure thorough mixing of the two components.
Prereaction time	Apply immediately after mixing.
Thinning	Ready to use; do not dilute.
Tinting	Do not tint.
Compatibility	Do not mix with other types of materials.
Pot life (at +20°C)	Approx. 20 minutes. After the pot life has ended, neither dilute the material again nor continue to use it. Higher temperatures shorten the pot life.
Application	Cut off the cartridge's threaded tip immediately before use. Apply both components using a caulking gun in the quantity required, in strands of equal length on a mixing board, and mix until free of streaks, and an uniformly colored mass results. Thinly apply 2C Epoxy Repair Filler 599 in one or more coats, using a Japan filler knife or double blade spatula. The depth and breadth of the repair site (minimum thickness) must be ≥ 5 mm. A mixing board must be used for mixing because this is the only way to ensure bubble-free mixing of the components. Any potential air pockets must be pressed out from the mass using a spatula Do not heap up the repair mass on the mixing board, instead spread it out. Heaping up the mixed material leads to a reduction in the pot life, due to the heat of reaction.
Consumption	Depends on the respective size and scope of the damage.
Application temperature	Do not apply at an air and/or object temperature that is below +5 °C or above 30 °C. Work at least 3 °C over the dew point. The relative humidity must not exceed 80%.
Tool cleaning	Clean tools immediately after use with Epoxy Thinner 854.

Drying (+2°C, 65% relative humidity)

Surface dry after approx. 6 hours. Can be sanded and coated after approx. 8 hours. Fully stressable after approx. 7 days.
Lower temperatures and/or higher humidity delay (prolong) the drying time. Higher temperatures accelerate the drying and curing processes.

Storage

Store in a cool and dry location. Tightly close the opened cartridges with a screw cap.

Declaration

Product code	RE1 Comply with the specifications in the current Safety Data Sheet.

Coating build-up

Substrate preparation

The substrate must be solid, dry, clean, with good adhesiveness, load-bearing, and free of separating agents. Check existing coatings for their suitability, load-bearing capacity, and adhesive properties. Thoroughly remove defective and unsuitable coatings and dispose of them in accordance with the applicable regulations. Thoroughly sand intact two-component coatings. Hazardous particles and vapors may be released while reworking or removing old paint coats, e.g. as a result of sanding, paint removal by heat gun, etc. Perform such work in well ventilated areas only and ensure the use of appropriate protective equipment (including respiratory protective equipment) as required. Check wooden components for structural defects . Correctly and professionally resolve any defects. Mill cracks and open wood connections to a width of at least 5 mm and a depth of at least 5 mm. Remove rotten or damaged wood completely by milling it or sawing it off. Carefully remove wood dust. The wood moisture content must not exceed 15%. Pretreat and prime uncoated substrates as necessary. See also VOB Part C, DIN 18363, Section 3.

Impregnation/primer

Treat untreated, dimensionally accurate wooden components in exterior areas with Wood Preservative Primer 250 if required or as may be necessary due to the type of wood. Prime metal surfaces with 2K-Epoxi Varioprimer 865 or 2K-Epoxi Varioprimer S 864.

Applying repair filler

For window renovations, apply the 2C Epoxy Repair Filler 599 following impregnation.

Intermediate and top coats

Depending on the type of structural component, requirement and selection, after sanding, continue with the system build-up using alkyd resin or acrylic enamel paints.

Notes

Ensure adequate ventilation

Ensure proper ventilation during application and drying.

Further information

Follow the instructions in the data sheets of the products used.

Remark

This Data Sheet is based on extensive development work and years of practical experience. The translation corresponds to the current German version, in compliance with the German laws, regulations, standards and guidelines. Its content does not constitute a contractual legal relationship. The user/buyer is not released from the responsibility of checking our products to ensure they are suitable for the intended application. In addition, our general terms of business apply.

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