

## 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 an alkaline 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. Paint thinners can be used to treat small localized areas of contamination such as marks from marker pens. Use clean, white cotton cloths that are turned and replaced often. Do not bundle used solvent saturated cloths. Place used cloths into water.

### Process sequence

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter and treatment of welds 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 Megayacht epoxy primer:

Clean, dry and undamaged compatible coating.

Remove any contamination that could interfere with the intercoat adhesion with an alkaline emulsifying detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by low-pressure waterjetting method to Wa 1 (ISO 8501-4) using fresh water.

Cured Jotun Megayacht 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. The minimum DFT of the existing primer, according to its relevant TDS, must remain after sanding. If required additional coats should be applied.

### Other surfaces

Epoxy filler:

Clean, dry and undamaged compatible fairing compound.

Sand the surface to remove irregularities. Remove any contamination that could interfere with the intercoat adhesion by vacuum cleaning. Cured filler, exceeding maximum recoat intervals will require abrading by orbital sanding or hand sanding with aluminium oxide or silicon carbide sand paper with grit P60-P100.

## 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. Mix by trowel or with an approved filler mixing machine.

It is recommended that each component is thoroughly pre-mixed to a uniform consistency before mixing component A and B together.

### Induction time and Pot life

**Paint temperature** **23 °C**

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Pot life 30 min

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

The temperature of base and curing agent is recommended to be 18 °C or higher when the product is mixed.

### Thinner/Cleaning solvent

Do not add thinner.

Cleaning solvent: Jotun Thinner No. 17

For cleaning of equipment only.

### Application data

#### Other application tools

#### Application with other tools

Pallet knife or other suitable tools.

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## Film thickness per coat

### Typical recommended specification range

Dry film thickness	300 - 10000 µm
Wet film thickness	300 - 10000 µm
Theoretical spreading rate	3.2 - 0.01 m <sup>2</sup> /l

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

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
Walk-on-dry	72 h	18 h	12 h
Dry to over coat, minimum	12 h	8 h	2 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.

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

**Walk-on-dry:** Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

**Dry to over coat, minimum:** The recommended shortest time before the next coat can be applied.

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

## Maximum over coating intervals

Maximum time before thorough surface preparation is required. The surface must be clean and dry and suitable for over coating. Inspect the surface for chalking and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by low-pressure water cleaning using fresh water.

If maximum over coating interval is exceeded the surface should in addition be carefully roughened to ensure good inter coat adhesion.

## Areas for atmospheric exposure

Average temperature during drying/curing	15 °C	23 °C	35 °C
Itself	4 d	3 d	2 d
epoxy	4 d	3 d	2 d

## Quality assurance

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

- Confirm that all welding and other metal work has been completed before commencing pre-treatment and surface preparation
- 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 the required number of stripe coats have been applied
- 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, edges and surfaces where the spray

- gun cannot be positioned so that its spray impinges on the surface at 90° angle
- Observe that the coating is free from defects, discontinuities, insects, abrasive media and other contamination
  - Observe that the coating is free from misses, sags, runs, wrinkles, fat edges, mud cracking, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build
  - 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

Some coatings used as the final coat may fade and chalk in time when exposed to sunlight and weathering effects. Coatings designed for high temperature service can undergo colour changes without affecting performance. Some slight colour variation can occur from batch to batch. When long term colour and gloss retention is required, please seek advice from your local Jotun office for assistance in selection of the most suitable top coat for the exposure conditions and durability requirements.

### 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

This Application Guide supersedes those previously issued.

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.

For your nearest local Jotun office, please visit our website at [www.jotun.com](http://www.jotun.com).

IMO = International Maritime Organization  
ASFP = Association for Specialist Fire Protection

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## 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.

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

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