
PRODUCT DATA SHEET: CERAM-KOTE Fairing Compound

Description

CeRam-Kote *Fairing Compound* is a course, high-viscosity 100% putty ideal for surface leveling and sanding. It has excellent workability and sandability. The *High Viscosity Fairing Compound* has a creamy consistency and is designed to cure tack-free even in large masses. Because of its higher viscosity, it is an excellent choice when fairing vertical areas, particularly where thicknesses greater than 1/8" are involved. CeRam-Kote Fairing Compound cures well even in a feather edge.

Suggested Uses:

- General tooling applications
- General purpose filler
- Filling thin or thick sections
- Fairing thick vertical areas
- Refurbishing pools with spalled areas

TECHNICAL DATA

Volume Solids: 100%

Weight Solids: 100%

VOC: 0 lb/ gallon

Surface Preparation:

Bonding strength depends on proper preparation of the surface to be protected for long-term performance of the product. The substrate should be free of oil, grease and salt/chloride contamination. Steel, aluminum, titanium, other metal substrates: Specifications call for a white metal (NACE 1, SSPC-SP5, Swedish Standards SA-3) finish with a 2.0-2.5 mil (50 - 62.5 microns) anchor profile. Surface preparation should be no less than a near white metal (NACE 2, SSPC-SP10, Swedish Standards SA 2 ½) finish. Concrete: Acid-etch concrete twice or until no additional "bubbling" occurs. Rinse liberally with fresh water between applications. Allow to dry at least 24-hours. Cleanliness is the most important step to produce a coated surface that will perform and last. Call Freecom, Inc. for surface preparation recommendations of materials such as aluminum, brass, plastic, fiberglass and/or concrete.

Mixing Ratio:

Two (2) parts of Part A to one (1) part of Part B by volume.
Two and a half (2.5) parts of Part A to one (1) part of Part B ratio by weight.

Mixing:

CeRam-Kote Fairing Compound is packaged in two cans, Part A (base) and Part B (curing agent). Pour the Part B (curing agent) into the Part A (base). Combine Part A (base) and Part B (curing agent) and *stir* until both parts are thoroughly mixed, paying particular attention to the sides and bottom of the can.

It is recommended to use a folding motion when mixing in order to minimize air entrapment into the system.

Pot Life & Shelf Life:

Solvent-free coatings have a limited pot-life. It is also recommended that one does not mix more than what can be used within 20 or 30 minutes. Once the Part A (base) and Part B (curing agent) are mixed together, it is recommended that the mixture be poured out onto a mixing board. This will increase he length of working time.

Pot life for CeRam-Kote Fairing compound at 72°F (22.2°C) is approximately twenty minutes. Colder temperatures will increase the pot life and warmer temperatures will decrease the pot life. Keep cans out of direct sunlight to prevent heat buildup. CeRam-Kote Fairing Compound has an indefinite shelf life. Preferred storage/usage is a dry enclosed area under 85°F (29°C) /used within two (2) years. However, if stored more than two years above 85°F (29°C), call Freecom Technical Support prior to use.

Application:

The mixed system can be applied by trowel, pallet knife or other suitable dispenser. The system can be applied in thicknesses up to one-inch (1") without fear of exotherm. Since this product is easy to sand, CeRam-Kote Fairing Compound does not need to be fine-faired during application.

The ideal ambient temperature for application is 60° F to 77°F (15°C to 25°C). Below these temperatures, the components are difficult to mix and spread on the surface. Above these temperatures, the sag resistance of the fairing compound will be reduced slightly as the temperature increases. The working time of CeRam-Kote Fairing Compound will also decrease with the increase in temperature. Surface temperature must also be taken into consideration – in direct sunlight the substrate can achieve much higher temperatures than the ambient temperature. A maximum surface temperature of 110°F (43°C) is recommended.

If applying other CeRam-Kote coatings over the top of the CeRam-Kote Fairing Compound, then can be applied as soon as the surface is stiff enough. This is typically 3 – 5 hours after fairing application, but depends on the thickness of the fairing and ambient temperatures. If applied during this period, the need to sand the surface of the fairing compound is eliminated. If the system is left to cure for longer than 6 – 8 hours, then the fairing compound will need to be left for a further 8 – 10 hours and then sanded before overcoating.

Climate:

Use CeRam-Kote Fairing Compound only if the substrate temperature and ambient air temperature is above 40°F (4.4°C). No coating should be permitted when substrate is wet from rain or dew, when surfaces are less than 5°F (3°C) above the dew point and holding or when relative humidity is greater than 85%.

Cleanup:

Clean equipment with MEK or Acetone. Material left on any equipment will solidify and damage equipment. Use precautionary measures applicable to any catalyzed material.

Safety:

See individual product label for safety and health data. A Material Safety Data Sheet is available upon request.

10/13/04