



# TECHNICAL DATA SHEET

## Phenolic Surfacer

**ThistleBond 'Phenolic Surfacer'** is a high performance fast drying two pack epoxy filler/surfaces specifically developed for use on GRP surfaces prior to the application of **ThistleBond 'MA9 Tie-Coat'** or **ThistleBond 'MA3 Tie-Coat'**.

**ThistleBond 'Phenolic Surfacer'** is based on a well established blend of high molecular weight epoxy resins and a range of fine inorganic pigments and fillers combined with a specially formulated polyamine adduct which react together to produce an effective product to fill imperfections and blowholes and thus prevent pin holing of subsequent **ThistleBond Coating Systems**.

**ThistleBond 'Phenolic Surfacer'** is an easy to apply and sand product which produces a smooth surface for subsequent painting.

**Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.**

### SURFACE PREPARATION

All areas to be filled must be free from grease, dust, dirt or moisture.

Surface debris should be removed by abrasive paper, mechanical abrasion or manual scraping. Finally the surface to be repaired should be solvent wiped with **ThistleBond 'SFE Thinners'** to ensure removal of mould release fluids.

### MIXING

**ThistleBond 'Phenolic Surfacer'** is a two component product comprising a resin and hardener component which must be mixed together prior to use.

The resin component should be thoroughly stirred to incorporate any slight separation then the total contents of the hardener container should be added and stirring continued until a smooth streak free paste is achieved.

The mixed material must be used within 4 hours of mixing at temperatures of 20°C (68°F).

### APPLICATION

Application should not be carried out when the temperature is below 7°C (45°F).

The mixed **ThistleBond 'Phenolic Surfacer'** should be smeared over the surface and worked well into the surface with a clean rag or squeegee. Alternatively the mixed material can be applied with a stopping or filling knife in a thin film to ensure maximum penetration into the substrate.

Excess material should be immediately wiped off with a clean rag prior to overcoating with the chosen **ThistleBond 'MA9 Tie-Coat'** or **ThistleBond 'MA3 Tie-Coat Systems'**.

All equipment must be cleaned IMMEDIATELY after use with **ThistleBond 'SFE Thinners'**.

### PHYSICAL CONSTANTS

<b>Mixing Ratio</b>	2 parts resin to 1 part hardener by volume.	
<b>Appearance</b>	Resin	Off white paste
	Hardener	Beige paste
<b>Drying &amp; Cure Times at 20°C (68°F)</b>	Usable Life	4 hours
	Hard Dry	8 hours
	Minimum overcoating	4 hours
	Maximum overcoating	8 hours
	Final Cure	7 days
<b>Volume Solids</b>	60%	
<b>V.O.C.</b>	400 gm/litre	
<b>Shelf Life</b>	Use within 5 years of purchase. Store in original sealed containers at temperature between 5°C (40°F) and 30°C (86°F).	

## HEALTH AND SAFETY

As long as normal good practice is observed **ThistleBond 'Phenolic Surfacers'** can be safely used.

Protective Gloves should be worn to prevent skin contact.

Vapour masks should be worn for spray application.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

## PACKAGING

Supplied in 2.5 litre packs.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests. Detailed specifications are available on request from the company.

FOR FURTHER INFORMATION PLEASE CONTACT

# ThistleBond

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