TOTALBOAT POLYESTER FAIRING COMPOUND

- For Fairing and Cosmetic Repairs
- High-Build, Fast-Cure Formula
- Easy to Spread, Easy to Sand
- High-Viscosity, Sag-Resistant

TotalBoat Polyester Fairing Compound is a lightweight polyester resin-based marine filler and fairing compound featuring optimal strength and sanding qualities. It's great for quick cosmetic repairs on composite surfaces above the waterline. Includes MEKP catalyst.

SURFACE PREPARATION SOLVENT: Acetone

CLEANUP: Acetone. Once cured, it must be removed mechanically.

CATALYST: MEKP (methyl ethyl ketone peroxide), 9% active (included with purchase of TotalBoat Polyester Fairing Compound)

THINNER/REDUCER: Do not thin this product.

COLORANTS/TINTS: Not commonly added. They can be added at a small percentage if they are compatible with polyester resin. Always perform and cure a test sample whenever adding tints or colorants.

WAX ADDITIVE: This product contains wax.

Exothermic Reaction!

The cure of TotalBoat Polyester Fairing Compound is an exothermic reaction and will generate heat. It is not uncommon for a mass of catalyzed polyester resin left in a mixing cup to reach 200-300°F during the cure cycle.

SAFETY AND PERSONAL PROTECTIVE EQUIPMENT:

Always use proper safety equipment, clothing, and PPE in accordance with the Safety Data Sheet for this product, and any surface preparation materials. Only use polyester resin-based products with adequate ventilation.

SURFACE PREPARATION

Acceptable Substrates: Polyester resin,* gelcoat surfaces,* TotalBoat Polyester Structural Repair Putty,* cured epoxy surfaces where any amine blush has been removed, other fully cured FRP substrates, wood substrates

Unacceptable Substrates: Uncured epoxy substrates, epoxy fairing materials, plastics, glass, uncured vinyl ester resins, ceramics, masonry, concrete.

* TotalBoat Polyester Fairing Compound can be applied directly to any catalyzed, uncured polyester resin-based products. Any cured polyester resin-based products must be dewaxed, all other surface contaminants removed, then sanded before applying Polyester Fairing Compound.

General Surface Preparation for All Substrates:

- All amine blush, dirt, dust, grease, oil, water, and wax must be removed from the substrate before performing any further surface preparation. Abrading the surface with any of these substances present will only grind the contamination in, leading to a possible adhesion failure.
- For fine fairing applications with a depth less than 1/8" thick, abrade the surface with 80- to 180-grit sandpaper. For larger crevices and fairing applications deeper than 1/8" thick, abrade the surface with 40- to 80-grit sandpaper.
- Remove all sanding residue with a vacuum and/or an air hose.
- Wipe the surface clean with a clean, lint-free cotton rag dampened with acetone.

APPLICATION CONDITIONS

- The recommended application conditions for this product are 60-90°F and 0-90% relative humidity.
- Do not apply this product when dew, rain, or other contaminants may be present, as they may affect the cure of this product.

CATALYZATION

- Polyester Fairing Compound requires MEKP (methyl ethyl ketone peroxide) as a catalyst to cure. This is not to be confused with the solvent MEK (methyl ethyl ketone), as they are different materials, and serve different purposes.
- The ideal percentage of catalyst is 1%, but may vary from 1-2% by weight, based upon ambient temperature and the desired working time.
- For small, quick repairs, the maximum 2% can be added, but working time is short. For most applications, it is strongly recommended to use the minimal percentage of catalyst to ensure sufficient working time.
- 14-16 drops of MEKP catalyst per ounce of Polyester Fairing Compound will provide a working time of 10-15 minutes (at 77°F, 100-gram mass of Polyester Fairing Compound).
- Applying too much catalyst may lead to cracking and a brittle product once it has cured.
- Under-catalyzation can lead to a much longer cure time than desired or an insufficient cure with poor sanding properties.
- Immediately mix the catalyst into the fairing compound with a stir stick. Mix thoroughly, as areas that are not exposed to catalyst will not cure. The working time of this product starts when the catalyst has been introduced. This

can take 2-4 minutes depending on the mass that is being catalyzed.
- Cooling the catalyzed fairing compound will help extend the pot life and working time, while warming the material will shorten the working time dramatically. Once the catalyst has been added to this product it cannot be undone.

ADDING PIGMENTS AND TINTS:
- Though it is not common, Polyester Fairing Compound can be tinted with TotalBoat Pigment Dispersions, or other polyester resin-safe colorants before it has been catalyzed.
- To ensure optimal working and cured properties, avoid using more than 1% of any tints by weight or volume.
- Always perform a test sample with any desired tints before using it on the final project.
- This includes the catalyzation of Polyester Fairing Compound and then sanding it smooth to ensure the desired result.

APPLICATION
- Immediately after TotalBoat Polyester Fairing Compound has been catalyzed and mixed, spread the product to the desired substrate with a putty knife, spreader, or trowel.
- Work quickly to maximize the working time.
- Once cured, sand the product with the desired sandpaper.
- Apply more Polyester Fairing Compound as needed.
- Polyester Fairing Compound is not considered a finish product, and should be primed, painted, or gelcoated after it is sanded.
- This material should not be considered waterproof. For underwater applications where this product may be exposed to water, always apply a barrier coat such as TotalBoat TotalProtect over the top, as directed on the label, to prevent water intrusion, blistering, or other material failures.

STORAGE & DISPOSAL
Storage:
- Keep container tightly closed in a cool, well-ventilated place under 70°F.
- Store away from food, drink, animal food, and any sources of ignition.

Disposal of Empty Bottles:
- Do not empty remaining contents into drains. Dispose of contents and containers in accordance with local, regional, national, and international regulations.

Shelf Life:
- Polyester Fairing Compound has a limited shelf life and will, over time, gel in the container without the addition of catalyst.
- The shelf life is dependent on several factors such as product formulation and storage conditions. The shelf life for uncatalyzed polyester resin products should be up to 6 months when stored in dry, cool conditions below 70°F. Warm to above 60°F before use.

APPLICATION DATA:	
Consistency/Color:	Smooth Putty, Off-White
Application Method:	Putty Knife, Spreader, Trowel
Working Time:	10-15 minutes* (100g mass catalyzed with 1% MEKP at 77°F)
Cure Time to Sand:	20-30 minutes* (100g mass catalyzed with 1.5% MEKP at 77°F) * Actual values are dependent on ambient/ substrate/material temperatures, catalyst amount, and mass of Polyester Fairing Compound
Application Temp.:	50-95°F (0-90% relative humidity)
Cleanup:	Acetone. Once cured, it must be removed mechanically.
Peak Exotherm:	265-295°F

PHYSICAL DATA:	
Components:	Two - Fairing Compound Putty and Catalyst
Flash Point:	<100°F
Density:	.67-.69 g/cm^3
VOC Content:	30-34%
Smell/Scent:	Styrene (until cured)
Viscosity (at 77°F):	390,000-520,000 cps at 2 rpm, 48,000-76,000 cps at 50 rpm
Storage:	Cool, dry, well-ventilated area away from oxidizing materials. Keep container closed tightly.
Units:	Quart, Gallon
Shelf Life/Stability:	6 months minimum if stored properly (Typically longer, depending on storage conditions)