

## Section 1: Description

Additive F was originally developed early in our history as a sanding coat additive which makes sanding the hardener epoxy far easier than without. Epoxy resin have always had a bad reputation in this regard and additive F changed that making epoxy flow coats as easy to sand as their polyester resin cousins. It does this by sealing the surface away from humidity and oxygen in the air preventing bi-carbonate formation on the surface. It was found later that the elimination of bicarbonates also made re-coating without sanding possible since bi-carbonates are the main cause of delamination between layers in coating or composites. The only drawback to this product is a slight milky appearance in coatings that require crystal clear finishes. In these cases Additive F can't be used.

## Section 2: Applications

- Sanding additive for Flow Coats
- Sanding additive for use in laminates
- Blocks bi-carbonate (blush) formation
- Used to enhance flow in flow coats
- Reduces the formation of fisheyes

## Section 3: Handling Precautions

Refer to the Safety Data Sheet

## Section 4: Storage Life

At least 12 months from the date of manufacture in the original sealed container at ambient temperature. Store away from heat and excessive humidity in tightly closed containers.

## Section 5: Typical Properties

In Combination with RR 2040 epoxy resin

Appearance: Clear Liquid

Color (Gardner) 1 - 2

Viscosity @ 77 °F 1000(cP) when mixed in epoxy/hardener mixture

EEW - 180

Specific Gravity @ 77 °F 1.14

Density @ 77 °F (lb/gal) 9.5

Flash Point (closed cup) (°F) NA

Recommended Mix Ratio: 1 to 1 mix by volume with epoxy/hardener mixture

### Section 7: Typical Handling Properties

In combination with 2040 resin:

Gel Time (130g mix @ 77 °F) (min)

18 Minutes - Fast Hardener

40 Minutes - Slow Hardener

160 Minutes - Extra Slow Hardener

Thin Film Set Times

@ 77 °F (hr) 1.5 Fast - 4 Slow - 12 X Slow

@ 57 °F (hr) 4.5 Fast - 12 Slow - 36 X Slow

Peak Exotherm (100g mix @ 77 °F)

Fast 198F; Slow 180F; X Slow 150F

Peak Exotherm Time (min)

22 Fast; 48 Slow; 170 X Slow

**Use Level:** 1% to 2% with epoxy/hardener mixture

### Section 8: Typical Performance

(7 day cure @ 77 °F)

Heat Deflection Temperature (°F) 125

Tensile Strength (psi) 9500

Tensile Modulus 398,000

Tensile Elongation (%) 4.3

Flexural Strength (psi) 14,400

Flexural Modulus 470,000

Hardness (Shore D) 86

Compression Yield 15,200