

SEEVENAX[®] Sprayfiller 314-11

Technical Datasheet 314-11

Characteristics



- Water-dilutable chromate free two-component epoxy-based filler
- Offers good filling and sanding properties
- Suitable for composite substrates
- Quickly cures to a hard film without shrinking
- Extremely high mechanical resistance
- Water-based: VOC only 140 g/l (1.17 lb/gal) exempt water acc. to ASTM D-3960

Range of Application

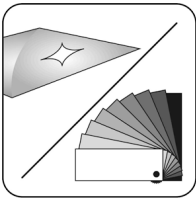


Used for the filling and levelling of composite surfaces (carbon and glass fibre reinforced plastics) for structural parts of the aviation industry.

Qualified according to:

- AIMS 04.04.011
-ABP 4-3350

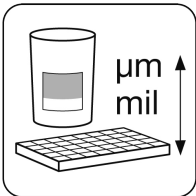
Color and Gloss



Color: grey

Gloss: mat

Theoretical Coverage



Area	Quantity	Film thickness
25 m ²	1 L	20 µm
1003 ft ²	1 gal	0.8 mil

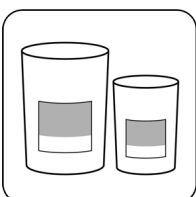
Recommended dry film thickness before sanding: 20 - 100 µm (0.8 - 4.0 mil)

Surface Pre-treatment



according to OEM spec.

Trade Names and Packaging



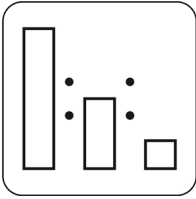
Material	Trade name	Container size [net]
Base material	SEEVENAX Sprayfiller 314-11	5 L
Hardener	SEEVENAX Hardener 315-11	2,5 L



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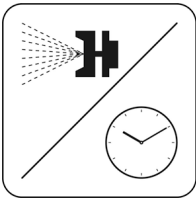
Mixing



	Base	Hardener	Thinner
Trade name	SEEVENAX Sprayfiller 314-11	SEEVENAX Hardener 315-11	water
By weight	5	2	0.4 - 1.5
By volume	2	1	0.2 - 0.8

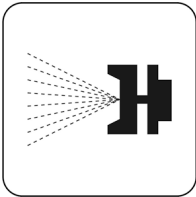
Flow time under normal conditions (23 °C / 73 °F at 50 % RH)
ISO 2431 4 mm approx. 45 ± 20 s (acc. to IPS 04-04-011-05)

Pot Life



3 h under normal conditions (23 °C / 73 °F at 50 % RH)

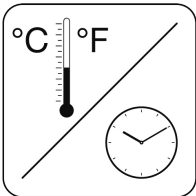
Application



	Compressed Air Spraying
Nozzle size	1.4 - 1.6 mm
Pressure	3.0 bar (44 psi)

Please observe the technical recommendations of the equipment manufacturers.

Drying



	23 °C (73 °F)	60 °C (140 °F)	80 °C (176 °F)
Flash-off time at 23 °C (73 °F)	-	10 min	10 min
Dust free (TG 1)	30 min	10 min	5 min
Dry to handle (TG 3)	4 h	25 min	15 min
Dry to tape	5 - 6 h	30 min	15 min
Dry to sand	12 h	60 min	45 min
Dry to overcoat	2 - 72 h	5 min	5 min
Dry to overcoat with SEEVENAX 313/311	wet-in-wet (after 5 min)	-	-
Full cure	7 d	-	-

The temperature specified is the object temperature.
Drying times according to DIN 53150 and AITM 2-0011.

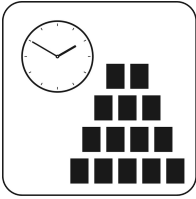
IR drying possible.



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Shelf Life



Material	Shelf life
Base material	12 months
Hardener	12 months

The storage data specified relates to unopened original containers.
at 5 to 25 °C (41 to 77 °F)

Use hardener within two months after opening.

Additional Details



The information contained in this document is based on our current state of research and development. Revisal by the user with regard to the intended purpose is necessary due to the variety of processing options and fields of application – please refer to the General Terms and Conditions of Sale.

