

CRYSTIC FILLER X 401

Putty for gap filling

Introduction

CRYSTIC FILLER X 401 is a pre accelerated highly thixotropic polyester compound, specially designed for surface finish at joint line.

Application

CRYSTIC FILLER X 401 has been developed for filling gaps at the joint line between the halves of wind mill blades.

Features and benefits

Features

Highly thixotropic.....
Fine mineral fillers.....
Rapid hardening.....
No paraffin wax.....

Benefits

Doesn't drop on vertical surface
Easy and precise sanding
Rapid sanding, time saving
Excellent bonding to substrate and topcoat

Formulation

CRYSTIC FILLER X 401 must be allowed to attain workshop temperature before use. Mix well by hand with the catalyst. The recommended catalyst is catalyst M (or Butanox M50) which should be added at 1.5 to 2% in the filler.

Gel time

Catalyst level and temperature will influence the gel time. Typical gel time of **CRYSTIC FILLER X 401** for 100 parts of filler catalysed with 1.5 % catalyst M is shown in the following table:

Temperature	Gel Time
20°C	10 – 12 min
23°C	8 – 9,5 min

Typical properties

Liquid gelcoat Filler

Viscosity (ICI cone & plate)	at 23°C	mPas	650 - 950
(Brookfield RVT SpB/5 Rpm)	at 23°C	mPas	80000 -400 000
(Brookfield RVT Sp6/5 Rpm)	at 20°C	mPas	300 000 – 400 000
Thixotropic index 5 to 20 Rpm			3.5 – 4
Specific gravity	at 25°C	g/cm3	1.2 – 1.3
Styrene content		%	26 – 30
Flash point		°C	31
Stability in the dark	at 25°C	Month	3
Colour deviation		ΔE	< 1.4

Pured casting resin

Hardness, shore D	After 60 mins	≥ 65
Hardness, shore D	After 120 mins	≥ 75
Barcol Hardness (Model GYZJ 934-1)		40 - 45
Temperature degradation (1000 h / 70°C) – Elongation	%	58
(1000 h / 70°C) – Modulus	%	133
Water absorption 24h	mg	19
168h	mg	55
28 days	mg	102
Elongation at break	%	3.3
Tensile Modulus	MPa	3300
HDT (1.8 MPa)	°C	75

Test according to ISO 527 – ISO 75A – ISO62

1MPa= 1 MN/m² = 1 N/mm² = 10.2 kgf/cm²

Packaging

CRYSTIC FILLER X 401 is supplied in 25 kg keg and 200 kg drums.

Storage

CRYSTIC FILLER X 401 should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C.

Batch identification

Our batch number system contains 7 digits – The first digit is 3 and the 6 others correspond to a chronological number.

Approved Plants

SCOTT BADER S.A. – France

Health and safety

Please see separate material safety data sheet.

All information is given in good faith but without warranty. We cannot accept responsibility or liability for any damage, loss, or patent infringement resulting from the use of this information.

RESINAS CASTRO S. L.

Pol. Ind. A Granxa, 3ª Paralela, C/ Cíes 190
36400 O Porriño - Pontevedra - España
Tlf.: 986 342 953 / Fax: 986 342 520
info@castrocomposites.com
www.castrocomposites.com

