

POLY-FAIR® F26

Fast Setting Polyester-based Fairing Compound for the Marine and Tooling Industry

Introduction

Poly-Fair F26 is a water resistant, low-density polyester-based fairing compound. Poly-Fair F26 has good adhesion to cured fiberreinforced polyester and vinylester laminates. Poly-Fair sands easily, gives a hard finish after a full cure, yet is not brittle and has good impact strength. Poly-Fair F26 is supplied as “R” regular version, “S” summer version.

General Features

- Fast setting, with follow-on “cheese state”
- Sufficient time for rasping/filing before a full cure
- Tack-free and good feather-edging
- Easy to apply and spread
- Easy to sand
- Excellent adhesion
- Low shrinkage

Poly-Fair F26 is a suitable base for all marine finishes such as polyester, urethane and epoxy paints. Poly-Fair F26 is often covered, prior to painting, with our sprayable polyester-based primer Poly-Fill to hide surface imperfections and to obtain a high-quality finish. (Please refer to the ATC Poly-Fill Technical Data Sheet). Below the waterline, Poly-Fair and Poly-Fill must be covered with epoxy bottom paints.

Poly-Fair F26 fairing compound is used primarily in the boat building and fiberglass fabrication industries for fairing and sanding plugs, molds, one-off custom boats, fairing of lead keels (not if coated with epoxy), fairing of keel to hull joints, repair of damaged fiberglass parts, and mold rework/modification.

General Properties

Color	Light Pink
Density	67-.71g/cc(5.6-5.9 lbs/gallon)
Working temperature range, “R”, “S”	16°-30°C(60°-95°F), max. at 70% humidity
Gel time	3-5 minutes
Deformation, compression	6.6% before rupture
Deformation strength	2500 psi
Shrinkage	less than 1%
Thixotropy	non-sagging
Tack-free surface	prevents sandpaper clogging
Good feather-edging	after min. thickness of 3mm (1/8”) and full (24 hour) cure

Mixing

Before using, thoroughly mix 5 gallon pail using a mechanical mixer. Mixing the liter/quart can by hand is sufficient. DO NOT REMOVE ANY POLY-FAIR F26 FROM CONTAINER BEFORE MIXING.

Surface Preparation

Substrate contamination will inhibit proper bonding and cure of Poly-Fair F26. Prior to application of Poly-Fair, thoroughly vacuum all surfaces. Do not use an air hose as this only redistributes the dust. This operation must be carried out between applications of Poly- Fair F26. Using an acetone wipe or solvents on the surface of the Poly-Fair prior to applying a paint or gelcoat should only be done after a full cure, normally at least after 24 hours at room temperature. Caution is advised when parts to be faired are subject to sudden temperature change, thus creating condensation on the surface. Condensation on the bonding surface will inhibit adhesion and the cure, so parts must be stabilized within the recommended working temperature limits for Poly-Fair F26 well in advance of application. Small, thin fiberglass parts (low mass parts) will stabilize more rapidly, whereas a massive object like a lead keel may take 24 hours or more to warm up. Although parts may be warmed outside with space heaters or torches, placing parts to be faired into an area with a constant temperature well in advance of Poly-Fair application is strongly recommended.

Catalyzation for 3-5 minute gel time*, in cc/gallon (3.78 liters)

Poly-Fair F26 R (Regular)				Poly-Fair F26 S (Summer)			
Temperature °F	°C	% MEKP (by weight)	cc/Gallon (3.78 l)	grams/Gallon (3.78 l)	% MEKP (by weight)	cc/Gallon (3.78 l)	grams/Gallon (3.78 l)
60	15.5	1.30	34.3	34.4			
65	18.3	1.16	30.6	30.7			
70	21.1	1.00	26.4	26.5	3.00	42.2	42.3
75	23.9	0.88	23.2	23.3	1.60	39.8	39.9
80	26.7	0.78	20.6	20.6	1.51	34.8	34.9
85	29.4	0.70	18.4	18.5	1.32	26.4	26.5
90	32				1.00	21.1	21.2
95	35				0.80	42.2	42.3

* Arkema Luperox DDM 9 is the MEKP catalyst is in this table. Other MEKP catalysts may vary in their gel time, and appropriate test under shop conditions are suggested.

Fairing/ Application

Mix small quantities (1 liter/quart) at a time. At a level of 1% by weight (Poly-Fair "R" version) of catalyst at 21°C (70°F), 5 minutes of trowelling time can be expected. Turn the catalyzed mixture frequently on the mixing board. This will help to extend the gel time. Apply Poly-Fair F26 in thin layers of at least 1/8" because Poly-Fair F26 needs a certain amount of mass to cure properly. Knock off high spots with a rasp or file between layers. Sand lightly before applying next layer. Recommended maximum total thickness 1/4".

If additional thickness is required, cover with a layer of Mat/Biax/Woven Roving. Any additional high spots can be taken off with a rasp after about 15 to 20 minutes, when the compound still has a cheesy consistency. If waiting too long, Poly-Fair F26 becomes very hard and will be more difficult to remove. To test if Poly-Fair F26 is ready for the rasp, scratch with your fingernail, it should turn white (or whiter).

A 50 mm (2") overlap beyond the surface being worked is recommended to achieve further feather-edging of the compound, as approximately 3 mm (1/8") of thickness is necessary for full cure. Sanding can start after approximately 30-40 minutes at room temperature, but a 24 hour cure will assure perfect feather-edging. Gradually reduce the grit size of the sand paper during sanding from 40 to 80 grit. It is not recommended to wet-sand Poly-Fair F26 because moisture can inhibit the cure cycle. Poly-Fair F26 can be thinned down with a GP polyester resin by approx 5% for easier spreading or for drawing it out with a board.

Storage

For maximum shelf life, store Poly-Fair F26 in a cool, dry area, maintaining a temperature between 10°- 20°C (50° - 70°F). Avoid storing in heat or direct sunlight. Always allow Poly-Fair F26 to reach shop temperatures before using. Periodically invert pails (store upside down) to prolong shelf life.

NOTICE: All precautionary labels and notices should be read and understood by all supervisory personnel and employees. Consult OSHA and government regulations for additional safety and health information. Purchaser is responsible for complying with all federal, state, or local laws and regulations covering the use of this product. The information contained herein is correct to the best of our knowledge. Please check our website for latest updates. The recommendations or suggestions contained in this bulletin are made without guarantee or representation as to results. We suggest that these recommendations and suggestions are evaluated by the purchaser's technical staff prior to use. Our responsibility for claims arising from breach of warranty, negligence, or otherwise is limited to the purchase price of the material. All values can be revised due to ongoing testing and are subject to change without notice.

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