



Technical Data Sheet

ECO288 Filler Paste

1. Product and Storage Information

Product Description: A UV Curable Filler Paste that is used for deep surfacing defects and repair of composite tool face surfaces and composite parts.

- VOC and HAP free.
- 100% solids content and Non-shrinking.
- Easy sand with excellent feathering.
- Tintable up to 3% with solvent based pigments and dyes.
- Polishable for final finish repair applications.
- Forms well for complex or curved profiles.
- Won't run or sag on vertical or inverted surfaces.

Suitable Surfaces:

Synthetic	Wood
Metal	Plastics

Storage: The product should be stored within the temperature range of 50°F to 90°F and in the original container. Do not return unused material into the original bottle.

2. Application



Use suitable respiratory and PPE equipment

See Section 6 (Liability/Hazard Info) for more details



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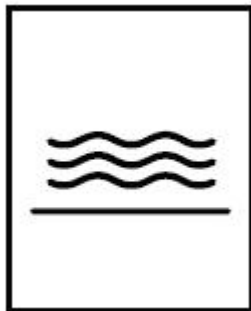
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Preparation Process: Prepare the surface to be coated by removing any dirt, debris, or contamination materials.

Application Process: Apply in a well-ventilated area, use appropriate PPE and a respirator (full / half mask) for spray coating (refer to SDS). Blade or otherwise apply onto substrate. Product can be applied at temperature ranges of between 60°F and 112°F as well as humidity between 20% and 97%. Product temperature should be at minimum 72°F. Substrate temperature should be at minimum 60°F. Equipment can be cleaned with isopropyl alcohol or acetone.

WARNING: material will start curing immediately when applied in direct or indirect sunlight.



Build Coats:

1. Apply up to 1/16th of an inch of material..
2. Cure for 2-4 min with UVA curing light or direct sunlight. Do not interrupt the cure cycle until tack-free.
3. For additional coats sand with 320 grit, or finer, paper between coats. Use shop air and prep with IPA.

Repeat steps 1-2 for additional coats.

Can be sanded / polished using traditional and modern methods.

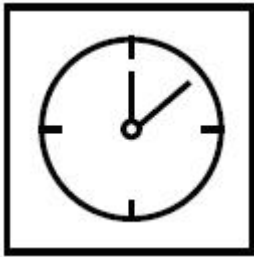


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3. UV Through Cure Verification

Use this procedure to verify your UVA light is adequate to thoroughly cure the product.



1. Use a test article and apply a 1/16th inch coat.
2. Cure with UV light 2 minutes.
3. Let rest for 10 minutes.
4. Check for a tack free surface. If it's not tack free then it has insufficiently cured*.
5. Take 220 grit sandpaper and sand completely through looking for dry powder all the way through. If you encounter gummy material or clogged sandpaper then it has insufficiently cured*.

***An insufficient cure indicates that the UVA light is unable to cure the product.
(This could be due to the distance or total output power of the light)**

4. Cleaning Process

Use isopropyl alcohol and/or acetone to clean tools and equipment. Cure excess or unwanted material on surfaces or filters with UV light.

5. Material Details

Solid Content	100%
Volatile Organic Content	0%



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6. Liability/Hazard Info

See SDS for complete information.

Although the product is VOC free it should be used in a well-ventilated area.

If skin contact occurs immediately wash with soap and water.

Harmful if swallowed.

Causes skin and eye irritation and may cause an allergic skin reaction.

WARNING: Exposing open containers or barrels of product to direct or indirect sunlight will result in a runaway exothermic reaction. Product is unstable until properly cured.

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Personal Protective Equipment: Eye/face protection: Face shield and safety glasses Use equipment for eye protection tested and approved under appropriate government standards such as NIOSH (US) or EN 166(EU).

Skin protection: Handle with gloves. Gloves must be inspected prior to use. Use proper glove removal technique (without touching gloves outer surface) to avoid skin contact with this product. Dispose of contaminated gloves after use in accordance with applicable laws and good laboratory practices. Wash and dry hands.

Body Protection: Use full paint suit with hood, The type of protective equipment must be selected according to the concentration and amount of the dangerous substance at the specific workplace.

Respiratory protection: Where risk assessment shows air-purifying respirators are appropriate use a full-face respirator with multi-purpose combination (US) or type ABEK (EN 14387) respirator cartridges as a backup



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to engineering controls. If the respirator is the sole means of protection, use a full-face supplied air respirator. Use respirators and components tested and approved under appropriate government standards such as NIOSH (US) or CEN (EU).

Control of environmental exposure: Do not let product enter drains.