

## Fill' Tool 400

### Tooling Gel-Coat Filler

**Fill' Tool 400** is an inorganic filler, formulated to be blended with an epoxy resin. The reached mix thixotropy is ideal for brush application on moulded parts especially on vertical parts and acute angles. Particle size, density and hardness allow a perfect reproduction of the original copy, with no bubbles and a optimum abrasion resistance.

Appearance	High Density Powder
Density	1.1 - 1.2 kg / litre
Colour	Grey
Average particle size	9-14 microns
Grain	400
Temperature resistance	> 500 °C

#### Applications:

- 0.3 à 5 mm anti-abrasion coatings for composite tooling mould
- Compatible with epoxy, polyester, vinylester resins, polyurethane, silicone

#### Processing

- Carefully mix resin and hardener
- Add **Fill' Tool 400** with a blender for quantities above 0.5 Litres.
- Apply with a brush avoiding any abrasion to the mould or the release agent

Thermal stability : will depend on the used epoxy system

Layer number: 1 to 2

Overlay: Laminate or cast as soon as possible.  
Cardid fabric or Amrstrim 50 can be used to create a mechanical key if the lamination must be delayed.

#### Example

	Weight ratio	Volume ratio	Remarks
<b>SR 8200</b>	100	100	Fast hardening formulation for small to average sized parts
<b>SD 8205</b>	31	35	Up to 70 °C continuous tooling
<b>Fill'Tool 400</b>	100	100	

Mix density : 1.45 - 1,55 g/cm<sup>3</sup>

#### Gel time acceleration means:

- Rise temperature : apply on warm mould, work above 25 °C
- Choice of hardener or catalytic system