

## NAUTIC FILL 2 ADHESIVE

**Description:**

NAUTIC FILL 2 is a polyester adhesive for professional use in the construction of yachts, boats, canoes, caravans and other laminate structures. NAUTIC FILL 2 is primarily used as an assembly adhesive for joining higher loaded constructions. It has very good resistance properties in connection with good elasticity and excellent adhesiveness with different types of substrates. A carefully chosen thixotropy makes it possible to apply it in thick layers (even up to 3 cm), at the same time ensuring good moistening of the glued elements.

**Substrates:**

- polyester laminates,
- epoxy laminates,
- plywood,
- wood,
- rigid polyurethane and PVC foams.

**Caution:** The adhesive should not be applied directly on one-component acrylic and nitrocellulose products.

**Surface preparation:**

- polyester and epoxy laminates: degrease, dry grind P80 – P120, degrease again with a silicone remover,
- plywood, wood: dry grind P80 – P120, then remove dust.

**Mixing ratio:**

NAUTIC FILL – 100 parts by weight,  
Hardener – 1 to 2 parts by weight.

**Supplementary products:**

Hardener – methyl ethyl ketone peroxide (e.g. METOX 50).

**Application life after mixing with the hardener:**

**NAUTIC FILL 2:** 10 to 20 minutes at 20°C (hardener: 2 %).

**Curing time:**

**NAUTIC FILL 2:** 1.5 to 2 hours at 20°C (hardener: 2 %).

**Coatability:**

Polyester finishing filler, polyester spray filler, acrylic primers.

**Procedure:**

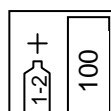
Mix the components thoroughly. Observe the required amount of hardener. Apply a layer not thicker than 30 mm with a trowel. The viscosity of the cured surface improves the adhesion of the following layers. If needed, it may be removed with an NC solvent. Minimal application temperature: +10°C.



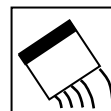
Clean and grind  
the surface



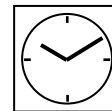
Degrease



Ratio by weight:  
100+1-2  
Pot life:  
10 - 20 min/20°C



Apply



1.5 – 2 h/20°C

**Mass density:**  
**NAUTIC FILL 2** – 1.20÷1.30 g/cm<sup>3</sup>

**Colour:**  
**NAUTIC FILL 2** – olive green

**Volumetric shrinkage:**  
 1.5% max.

**Chosen properties:**

Type of adhesive	Tear strength [MPa]	Ultimate elongation [%]	Peak temp. [°C]
Nautic Fill 2	15÷25	0.5÷1.0	30÷50

Resistance tests have been carried out according to the norm PN EN-ISO 527.

**Equipment cleaning:**  
 NC solvent.

**Storage conditions and shelf life:**  
 Store in a dry and cool place, away from sources of fire and heat.  
 Avoid direct exposure to sunlight.  
 Adhesive: 6 months at 20°C.

**Safety requirements:**  
 See the Safety Data Sheet of the product in question.

**Packaging:**  
 The adhesive is delivered in unit packages individually agreed upon with the customer.

The effectiveness of our systems results from laboratory research and many years of experience. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good construction practices. We may not be held liable for defects if the final results were affected by factors beyond our control.  
 NOVOL Sp. z o.o., Komorniki, PL