

TECHNIFILL R1170 is a solvent free, epoxy resin paste specifically designed for use with H1170 hardener for edge-filling composite panels or components.

R1170 can be used as an alternative to the standard procedure for edge-filling that involves the mixing of powder fillers into a liquid system. The resin and hardener can be easily mixed by hand* to form a soft paste that is then rolled and pressed into the rebated edge of cored components.

- No exotherm in bulk mixes.
- >20% weight savings compared to standard epoxy edge-filling mixtures.

TECHNIFILL R1170 can also be used as an insert to attach furniture hardware fittings, such as hinges and door locks, in place of plywood, timber or high density foams. Screws will easily drive into the cured compound, and screw retention is similar to other materials used for this application.

** Disposable gloves must be worn at all times when mixing R1170 by hand.*

MIX RATIO

60 parts hardener to 100 parts resin by weight
1 part hardener to 1 part resin by volume

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.

UNCURED PROPERTIES

	R1170	H1170
Physical State	White Paste	Brown Paste
Specific Gravity g/ml @ 25°C	0.5-0.6	0.4-0.5

CURE CHARACTERISTICS

Pot Life -100g @ 25°C (in air)	30-40 minutes
Minimum Cure Time	12 hours
Machining time @ 25°C	12-16 hours

APPLICATION

De-core the edge of the panel or part with a standard router bit – 10mm rebating bit with a ball-race.

Measure resin and hardener in equal quantities by volume – two tennis-ball size handfuls is a practical amount. Mix by hand to consolidate the compound until a uniform colour is achieved.

Roll into a sausage of 600mm *max* in length, which is practical for handling, that has a diameter slightly larger than the size of the void to be filled.

Place the sausage in the core rebate, pressing down firmly.

For best surface finish, spray the compound's surface lightly with water after installation.

Roll along the edge with a smooth roller to compact the epoxy compound and to remove excess material from the edges. Scrape any excess from the sides of the part, if required.

Note: Avoid using a trowel for this procedure.

Mounting Furniture Hardware Fittings

Remove core with a router set to the depth of the inside bottom laminate/ skin, fitted with an Inverted Flush Trimming bit (with a ball-race on the TOP)

Cut through the top laminate / skin and core to the required shape, leaving an adequate perimeter around where the fitting, e.g., hinge or door lock, will be placed.

Mix enough TECHNIFILL R1170 resin and hardener to slightly over-fill the cut-out.

Press some mixed R1170 compound into the perimeter of the cut-out to achieve good adhesion to the core, and to eliminate any voids.

Then slightly over-fill the entire cut-out, pressing the compound firmly into position. Spray lightly with water and roll out to a smooth finish with the TECHNIFILL R1170 roller.

Allow to cure fully. If required, sand flush and then attach fitting.

Note:

For larger fastenings, a pilot hole may be required.

PACK SIZES				
Order Code		Order Code		PACK
Resin		Hardener		
RD 1170	10 L	HD 1170	10 L	20 L

STORAGE

TECHNIFILL R1170 resin and H1170 hardener will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

HEALTH AND SAFETY

TECHNIFILL R1170 resin and H1170 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 8/11/10



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