

TDS FFE-200 FITTING AND FAIRING EPOXY

UNIVERSAL FAIRING & BONDING

“The Professional’s Choice”



TDS FFE-200 Fitting & Fairing Epoxy is a custom blended epoxy mastic of high quality resins, activators and engineered fillers to yield a **light weight, flexible** and **easily-sanded** system used for both fairing of deck substrates and the final glue-down of deck panels. FFE-200 weighs only 6 pounds per gallon when cured, and its cell-like structure makes it an **excellent sound and thermal insulator**. The viscosity of the FFE-200 is formulated to be high enough to stay in place when used for fairing, but low enough to provide excellent wet-out for bonding. The FFE-200 Fitting & Fairing Epoxy will cure in temperatures as low as 45° F. Developed to be user-friendly, the simplified 1:1 mix ratio allows a batch of any size to be easily measured and mixed. Once thoroughly mixed, the material can be spread immediately, requiring no induction time. At 77° F, a layer of FFE-200 applied with a 3/16" toothed trowel will have an open time of approximately 60-70 minutes, the material will set in approximately 4-6 hours, and complete cure will be achieved in approximately 24 hours. TDS Fitting & Fairing Epoxy is DOT non-corrosive, so it does not require hazardous labeling for shipment.

Mixing Instructions: Stir both A & B components before combining, especially if less than a full container is being used. Mix by volume: 1 part base resin to 1 part activator. Mixing **MUST** be thorough to ensure a good cure. The viscosity of FFE-200 may be increased with TDS Fairing Filler and reduced with TDS FR101 Epoxy after its A & B components have been mixed together at 1:1 by volume. Application is not recommended below 45° F. Keep from freezing!

All surfaces must be clean, dry, and free of any dirt, grease, wax, etc. before beginning any surface preparation.

Steel should be sandblasted or ground to clean white metal per SSPC-SP63 to a 3-4 mil profile. Wash with Metal Prep. Do not wipe surface with rags due to the possibility of leaving a fiber pathway through the seal coat. Apply 2-3 coats of a commercially approved epoxy primer such as Awl-Grip High-Build, Devoe Epoxy Primer or equivalent, adequately filling the blast profile.

Aluminum should be sandblasted or ground with 24 grit disc pads to a 3-4 mil profile. Do not wipe surface with rags due to the possibility of leaving a fiber pathway through the seal coat. Then follow with a vinyl wash primer or Alumaprep followed by a mil/spec zinc or strontium chromate corrosion-inhibiting primer, then AwlGrip High-Build epoxy, Devoe Epoxy Primer, or equivalent.

Fiberglass/Gelcoat should be ground with 36-40 grit paper until no shiny surface is present, then wiped down with acetone.

Wood should be scuffed with 36-40 grit paper. Do not use polyester resin or wood sealers that contain oils.

For all faired surfaces, seal the fairing compound with a high-quality 100% solids epoxy. After complete cure, the sealer/primer must be aggressively sanded before bonding with FFE-200. Regardless of the substrate, it is mandatory that a sample adhesion test be performed to the primed/sealed surface at least 24 hours prior to the final glue-down.

TDS FFE-200 will be usable for up to 12 months under proper storage conditions (50-95° F) in a sealed container. Prolonged storage may cause the hardener to darken. After prolonged storage, it is advisable to test a small mix to make sure it is viable. Be sure to pre-mix the individual containers before testing. Freezing may cause crystallization in the resin side. If this occurs, warm to 130-150° F and stir to melt crystals. The resin’s properties will be unaffected.

As with all epoxies, Teakdecking System’s Fitting & Fairing Epoxy can cause skin and eye irritation upon frequent or prolonged exposure. Avoid contact with skin and eyes by the use of gloves, goggles, impervious clothing and barrier creams. In case of accidental contact, wash skin thoroughly with soap and water. In the event of eye contact, flush eyes with water for 15 minutes and seek medical attention. See MSDS for further information and first aid measures.

PRODUCT #'S:

FFE200-2G (2 GALLON KIT - 7.56 LITER)

COVERAGE:

Approximately 30 ft² (2.8m²) / Gal.

PROPERTY	VALUE
Specific Gravity-Base A	0.74
Specific Gravity-Activator B	0.70
Flash Point	>200°F
Gel Time (8-oz Mix)	75-80 Minutes
Open Time – 3/16”	60-70 Minutes
Film Set Time – 3/16” @77°F	4 Hours
Film Set Time – 3/16” @ 40°F	10 Hours
Heat Distortion Temperature	136° F
Peak Exotherm – 100g Mass	205° F
Adhesion To Teak	Substrate Failure
Adhesion To Fiberglass	Gelcoat Failure

PROPERTY	VALUE
Compressive Strength	12,900 psi
Compressive Modulus	310,000 psi
Tensile Strength	2,090 psi
Tensile Modulus	126,000 psi
Tensile Elongation	4.5%
Flexural Strength	5,400 psi
Flexural Modulus	420,000 psi
Hardness – Shore D	55-60
Adhesion To Aluminum	>300 psi
Adhesion To Steel	>350 psi