

RESOLTECH 8020

Hardeners 8023 (slow) & 8025 (fast)

Epoxy profiling & fairing filler

- Simple mixing ratio 1 / 1 by weight
- Fastest hardening filler sandable after 1h30 with 8025
- Non sag vertical application up to 10 mm
- Improved Health & Safety formulation



RESOLTECH 8020 / 8023 - 8025 latest formulation is a premium choice for profiling above and below the waterline for professional applicators on steel, aluminum and composite materials. The specially formulated epoxy filler will apply from very thin layers up to 10 mm in one coat without the risk of sagging/slumping.

- * Improved health and safety formulation following the latest EU regulation (CE) n° 453/2010
- * High strength and impact resistance
- * Easy sanding with 80 to 180 grade paper
- * Slow & fast hardeners mixable

When sanded, the surface of this system is smooth enough to be directly overcoated with 2 coats of RESOLCOAT 3010T high build epoxy primer and is compatible with all paints.

RESOLTECH 8020 is particularly suitable for application over large areas with the 8023 and for smaller repairs when mixed with the 8025 hardener.

Its excellent waterproof quality enables to guarantee long lasting barriers when used as Osmosis treatment. Easy to sand or mill with CNC, RESOLTECH 8020 may be used as profiling filler on low density foams blocks for plugs manufacturing and tooling boards adhesive.

RESOLTECH 8020 is the product that offers long-term performance of superior quality.

Resin 8020

Hardeners 8023 & 8025

MIXING RATIO

System	8020 / 8023	8020 / 8025
Mixing ratio by weight	1 / 1	
Mixing ratio by volume	3 / 2	

The mixing ratio must be respected neither excess nor default. The mixture should be homogeneous and intimate with the use. It is recommended to use flat spatulas & trowels to hand mix the resin & hardener on a flat surface to avoid air incorporation during the mix.

PHYSICAL CHARACTERISITCS

Visual aspect

8020 : Salmon color paste
 8023 & 8025 : Yellow paste
 Mix : Light pink paste

Density (ISO 1675, ±0.05)

References	8020	8023	8025
Density at 23°C	1.09	1.70	1.65
Mixed density at 23°C	-	1.39	1.37

Water absorption (ISO 62)

8020 / 8023 : 0.14%

8020 / 8025 : 0.10%

REACTIVITY & HARDENING

References	8020 / 8023	8020 / 8025
Reactivity on 70mL (~4cm thickness) at 23°C	2h14min	17min
Temperature at exothermic peak on 70mL at 23°C	31.3°C	127°C
Time at exothermic peak on 70mL at 23°C	2h30min	12min
Reactivity on 2mm film at 23°C	3h16 min	21min

Reactivity measurements made with Trombotech®

System	Sandable in 2mm at 23°C	Sandable in 10mm at 23°C
8020 / 8023	6h30min	6h
8020 / 8025	1h30min	1h

Resin 8020

Hardeners 8023 & 8025

APPLICATION

It is mandatory to respect the mixing ratio, all excess or default will result in a loss of thermo-mechanical properties.

- **Substrate temperature** should be minimum 10°C and maximum 35°C. Product temperature should also be minimum 10°C and maximum 35°C. Ambient temperature should be minimum 10°C and maximum 35°C.

- **Surface preparation:** on previously painted surfaces, clean thoroughly to degrease the surface and sand with 80-180 grade paper or remove all previous coatings if in poor condition and prime the substrate.

Steel Aluminum: Prime with RESOLCOAT 3010T.

Wood: Prime stable constructions only, with RESOLCOAT 1010 / 1014.

GRP: For osmosis treatment, prime the sanded fibre with 1020T/1029S in order to waterproof the substrate and lightly sand/deglaze before application of filler.

BARE GRP/COMPOSITE: Remove surface wax/mould release agent with degreaser, sand with 80-180 grade paper. If left for longer than 24 hours, two component epoxy primers and fillers will need sanding with 80-180 grade paper to ensure a good mechanical adhesion.

As general rule: all substrates must be sanded, clean and dry.

- **Mix** the two components thoroughly to an even colour. Remove any dust from the surface. Apply firmly in a spreading action. When hardened, sand smooth with 80-180 grade wet or dry paper.
- **Overcoating:** RESOLTECH 8020 may be over coated with itself or with RESOLCOAT 3010T as soon as it is cured enough not to be lifted during the screeding process.

Coverage & Maximum temperature of application vs thickness

Coverage will depend on the thickness needed to profile. The following table indicates the coverage vs thickness and what is the maximum temperature of application for the thickness:

Thickness	Coverage	Max. temperature of application
1mm	1,4 kg/m ²	35°C
5mm	7 kg/m ²	30°C
10mm	14 kg/m ²	25°C

Warning : On thick applications, with high temperatures it is recommended to test the desired thickness at application conditions & substrate temperature to ensure that no exothermic reaction may occur.

Resin 8020

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THERMO-MECHANICAL PROPERTIES

	T _G	Shore D Hardness	T _G	Shore D Hardness	T _G
Curing cycles	14 days at 23°C		16h at 40°C		10h at 80°C
8020 / 8023	48.6°C	86	52.1°C	86	69.2°C
8020 / 8025	54.0°C	86	62.3°C	87	74.2°C

T_G realized with Kinetech® (DMA type)

PACKAGING

Kits of 8020 / 8023 - 8025 available :

- 1kg : (0,5+0,5)kg
- 2kg : (1+1)kg
- 3kg : (1.5+1.5)kg
- 10kg : (5+5)kg
- 30kg : (15+15)kg
- 50kg : (25+25)kg
- 400kg : (200+200)kg

TRANSPORT & STORAGE

Keep containers sealed and away from heat and cold preferably between 10°C and 30°C in a well ventilated area. Shelf life is minimum one year in sealed containers as provided.

HEALTH & SAFETY

Skin contact must be avoided by wearing protective nitrile gloves & overalls or other protective clothing.

Eye protection should be worn to avoid risk of resin or hardener entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.

Ensure adequate ventilation in work areas. Respiratory protection should be worn with ABEKP coded filters.

RESOLTECH issues full Material Safety Data Sheet for all hazardous products. Please ensure that you have the correct MSDS to hand for the materials you are using before commencing work.

Nota : The data provided in this document are provided good-faith and are based on the test in laboratory and our practical experience and is believed to be accurate. Considering the application of our products gets away from our control, we do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.