

PRODUCT DATA SHEET

SikaBiresin® AP861

(formerly Marine 861 UltraFair)

Epoxy fairing compound

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaBiresin® AP861 (A)	SikaBiresin® AP861-1 (B)
Color	White	Brown
	Light brown	
Density	1.16 kg/l	0.64 kg/l
Mixing Ratio	by weight	100 : 52
	by volume	100 : 100
Pot-Life	mass: 1 gallon at 25 °C	45 minutes
Application Temperature	product, ambient	15 – 30 °C
Sanding Time		8 hours ^A
Curing Time	at 25 °C	7 days
	at 13 °C	12 days
	at 35 °C	5 days
Shore D Hardness (ASTM D-2240)		78
Tensile strength (ASTM D638)		3700 PSI
Flexural strength (ASTM D790)		4300 PSI
Flexural modulus (CQP027-2 / ISO 178)		260 000 PSI
Coefficient of thermal expansion (CQP053-1 / ISO 11359)		52×10^{-6} 1/K
Glass transition temperature (CQP053-1 / ISO 11359)		59 °C
Service Temperature		-40 – 90 °C ^B
Shelf Life		24 months

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r.h.^{B)} used just as fairing without external loads

DESCRIPTION

SikaBiresin® AP861 is a trowelable, 2-component epoxy filler developed for fairing large surface imperfections on aluminum, steel, fiberglass or wooden marine vessels.

PRODUCT BENEFITS

- Convenient 1:1 volumetric mix ratio
- Above or below waterline usage
- Good non-sag property
- Low shrinkage
- Easy to apply
- Suitable for use with most common marine substrates

AREAS OF APPLICATION

The white resin and brown hardener yield a smooth, creamy paste which can be easily applied up to 1" thick without sagging during the curing process.

When cured the Product provides very good sanding and finishing characteristics and accepts virtually all types of primers and paints.

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METHOD OF APPLICATION

Ensure that all tools, mixing boards, containers, and all other application utensils are free of contamination prior to working with SikaBiresin® AP861.

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. Usually this is achieved by blowing off the surface with clean, dry compressed air, or wiping free of dust with a clean cloth, prior to the application of SikaBiresin® AP861. After the cleaning process, a physical abrasive or chemical pre-treatment might be required, depending on surface and type of material. The type of pre-treatment must be determined by appropriate testing.
Note: Bonding the SikaBiresin® AP861 to itself is only possible after sanding the bonding surface. Without proper sanding, adhesion will not be achieved.

Mixing Process

Prior to use, check the material for homogeneity and crystallization. After prolonged storage at low temperatures, crystallization of components may occur. This process can be easily reversed by heating the affected component to a maximum of 70 °C until the crystals have disappeared. Allow the Product to cool down to required processing temperature before use.
Both component must be stirred thoroughly before use.
Both components must be mixed homogeneously respecting the defined mixing ratio. A homogeneous mixture is achieved when there is a clear and homogeneous color change between the resin and the hardener. Containers must be closed tightly immediately after use to prevent moisture ingress. Once opened, the Product must be used as soon as possible.

Application

Apply the Product with a trowel, squeegee, or spatula to the prepared surface immediately after mixing. Once the pot life has been reached, SikaBiresin® AP861 must no longer be applied.

If application requires more than one layer of material, let the previous layer cure to semi-cured, tacky state before applying the next layer.
Ensure the Product has reached specified sanding time before proceeding with sanding. Further finishing of the SikaBiresin® AP861 is only possible after it has completely cured. If the product is to be primed or painted, the surface must be cleaned before the painting process. The paintability must be tested in advance prior to painting the whole area.

Removal

Uncured SikaBiresin® AP861 may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.
Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Application Limits

Use SikaBiresin® AP861 as is and do not mix with anything else, since it could result in a total failure.

STORAGE CONDITIONS

Both components must be stored at temperature between 15 °C and 25 °C in original unopened containers.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.
Copies of the following publications are available on request:

- Safety Data Sheet

PACKAGING INFORMATION

SikaBiresin® AP861 (A)

Can	2.1 lb
Pail	9 lb
	18 lb
	38.8 lb

SikaBiresin® AP861-1 (B)

Can	1.04 lb
Pail	4.7 lb
	9.4 lb
	20 lb

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

