Technical Data Sheet

FORTIS 822 KNOT FILLER

Fortis 822 Knot Filler is an epoxy resin system specifically designed for filling of knots, holes, cracks and other imperfections in rough sawn, dressed or recycled timber. **Fortis 822 Knot Filler** offers fast cure at room temperature allowing same day multiple pours and sanding into crystal clear surface.

Features and Benefits	• Fast cure time • Low viscosity • Excellent bubble release • Self-levelling • High clarity • Tintable
Typical Applications	• Timber knot filling
Properties	• Mixing ratio: 4 parts A to 1 part B by volume • Pot life: 15-30 minutes (50g at 25°C) • Set time: 2-3 hours • Sandable: 12 hours • Cure to maximum strength: 7 days • Colour Stability: Darkens on exposure to UV
Colours	• Clear
Pack Size	1.25L, 5L
Shelf Life	12 months @ 25°C unopened
Safety	• Refer to Safety Data Sheet prior to use • Good industrial hygiene practices should be observed at all times • Appropriate PPE should be worn including impervious gloves and eye wear
Storage	Store in cool, dry conditions, out of direct sunlight and in a well-ventilated area. Do not store below 5°C or over 40°C
Timber Preparation	Timber should be dry and free of contaminants. Remove any loose material from within the knot or hole and mask surrounding area to minimise clean-up of cured epoxy. Carefully inspect the timber and use masking tape or similar to seal the underside and edges of the timber where knots, holes or cracks penetrate though the timber.
Mixing	Ensure **Fortis 822 Knot Filler** Part A and B are shaken prior to pouring and mixing. Graduated plastic containers or measuring spoons are recommended for measuring volumetric quantities. Add 1 part B (Hardener) to 4 parts A (Resin) by volume and mix using jiffy style mixer or manually with suitable flat stirrer. Care should be taken to minimize introducing air during mixing. Mix for 2-3 minutes or until a homogeneous mixture is formed. Ensure material from the bottom and edges of the container are scraped down and sufficiently mixed. If required, add stain or pigment and continue mixing until free of striations. Most solvent-based stains and epoxy specific pigments / powders are suitable.
Application	Following mixing, **Fortis 822 Knot Filler** may be used immediately or for fast cure time, left to stand in mixing container prior to use (see Cure Speed below).

	Pour **Fortis 822 Knot Filler** directly into the knot, hole or crack, slightly over-filling. Top-up resin as it slowly seeps into cracks and voids, and check base and sides of timber for leakage. A plastic scraper or similar may be used push resin into thin cracks and small holes. For large knots or deep holes, multiple pours are recommended. Air bubbles may be released by use of a heat gun or gas torch. Care should be taken to avoid over heating in one spot – sweep the heat gun continuously across the surface for a few seconds only. Excess cured resin can be removed using a card scraper, plane or thicknesser, followed by sanding to the required grit and coated with typical timber finishes (eg oil, wax, varnish, polyurethane).
Cure Speed	The cure speed of **Fortis 822 Knot Filler** depends greatly upon the volume of product mixed, the stand time and the exothermic reaction of the mixture. Where mixed resin is left to stand in mixing containers for 15-30 minutes prior to use, the temperature of the resin will increase, resulting in a faster cure time of 2-3 hours. Mixed resin used immediately for small knots, holes and cracks will maintain its ambient temperature and take up to 6-12 hour to cure. Care should be exercised when mixing large quantities (>100ml) of **Fortis 822 Knot Filler** to avoid excessive exothermic reaction, rapid gelling and resultant cloudy or cracked cured resin.
Clean-Up	Equipment can be cleaned with xylene or acetone immediately after use. Hardened materials must be removed mechanically.
Limitations	Continuous exposure to UV may result in yellowing of epoxy resin.

For further information, including Safety Data Sheets and Technical Bulletins on adhesive applications and surface preparation, refer to the Fortis website www.fortisadhesives.com.au.

Disclaimer - Fortis products should be used in accordance with the information contained herein. Each user should read and consider this information carefully in the context of how the products will be handled and used in the workplace including in conjunction with other products. While the information contained herein is to the best of our knowledge at the date of publication, Fortis makes no representation about the accuracy of the information. If you need clarification or more information, you should contact Fortis Adhesives & Coatings. Fortis products are sold without express or implied warranties, other than as provided by statute, and subject to our standard terms and conditions (provided to customers and available on request). Subject to our standard terms and conditions, and any statutory provisions, Fortis accepts no responsibility (including in negligence) for loss or damage of any nature resulting from the use of Fortis Adhesives & Coatings products or reliance upon the information contained herein.

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