



**Marine 861  
ULTRAFAIR  
EPOXY  
FAIRING COMPOUND**

**PRODUCT BULLETIN**



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**DESCRIPTION**

Marine 861 UltraFair is a convenient trowelable filler developed for fairing large surface imperfections on aluminum, steel, fiberglass or wooden marine vessels. With the cold weather hardener it is easier to mix-apply-cure during colder weather conditions. The white resin and brown hardener, when mixed together at the convenient 1:1 volumetric mix ratio, yield a smooth, creamy paste which can be easily applied up to 1" thick without sagging or shrinking during the curing process. 861 UltraFair Resin and Hardener are 100% solids systems and may be used above or below the waterline. When cured, this system features excellent sanding and finishing characteristics and accepts virtually all types of primers and paints. *Note: This product is intended to be used as supplied. Do not thicken or thin this product as altering the formulation may lower physical properties.*

Available with two hardener options and simple 1R: 1H parts by volume mix ratio: **861 UltraFair Hardener, and 861 Cold Weather Hardener**

**BENEFITS**

- Convenient 1:1 Volumetric Mix Ratio
- Easy to Sand – Blush Free Surface
- Can be Applied up to 1" Thick Without Sagging or Shrinking During Cure
- Color Coded Positive Mix Indication
- For Applications Above or Below the Waterline
- Smooth, Creamy Paste Mixes Easily and Trowels Smoothly

**TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C)**

	<b><u>861 Hardener</u></b>	<b><u>861 Cold Weather Hardener</u></b>
Mix Ratio (parts by volume) .....	1R/1H .....	1R/1H
Mixed Viscosity.....	Trowelable Non-Sag Paste.....	same
	1" Vertical Sag Resistance .....	same
Specific Gravity .....	0.90 g/cc .....	0.90 g/cc
Pot Life .....	48 mins (1 gal mass).....	27 minutes (150 gram mass)
Pot Life .....	42 mins (2 gal mass).....	50 minutes (200g @ 55°F (13°C))
Application Temperature Range .....	55°F (13°C) – 95°F (35°C).....	same
Cure to Sanding Time @ 77°F (25°C) .....	6-8 hours .....	4-6 hours
Cure to Sanding Time @ 55°F (13°C) .....	N/A .....	16-½ hours
Total Cure Time @ 95°F (35°C).....	3-5 days .....	same
@ 77°F (25°C) .....	5-7 days .....	same
@ 55°F (13°C) .....	10-12 days .....	same
Maximum Applied Thickness .....	1 inch (25mm) per coat.....	same
Theoretical Coverage Per 1-Mixed Gallon.....	6.40 sq/ft @ ¼"(6mm)thickness.....	same
	1.60 sq/ft @ 1"(25mm)thickness.....	same
Volatile Organic Carbon (voc's) .....	Zero Percent (0 g/L).....	same
Color.....	White Resin/Brown Hardener .....	same
Shelf Life of Resin and Hardener (in original unopened containers).....	2 years .....	2 years

*Continued on next page*

**APPLICATION GUIDELINES**

Underlying primer coverage (gauged millage) must be to manufacturer's specification and it is critical that the underlying primer system must be allowed to reach complete cure before sanding. All finished primers and/or 861 must be blown down with clean, dry compressed air or wiped to a dust free state (clean rag). Sanding or further preparation of the 861 Fairing Compound is only possible after it has been allowed to fully cure to material specifications. Skinning of the 861 Fairing Compound to itself without proper scarfing is not recommended and will result in poor adhesion.

To achieve desired results, it is critical that all tools, mixing boards, containers, and all other material application accessories must be free from contamination. Proper mixing of 861 Fairing Compound must be followed. A thorough mix is evident only when a positive color change appears between the resin and hardener and is homogenous throughout. It is imperative that the 861 is applied to the prepared surface immediately upon achieving a proper mix. 861 Fairing Compound must not be applied beyond the recommended pot life.

**CRYSTALLIZATION**

Epoxies may form small crystals when exposed to moisture, dirt, low temperatures or temperature cycling. To return the material back to its original state, heat to 130°F (54°C) and stir until the crystals disappear. Do not use an epoxy if the crystals will not return to liquid form.

861 UltraFair Tech/Revised 12/22/14  
Supersedes 5/6/14

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