

# HITCHINS

## TECHNICAL DATASPEC

# EPOFLUSH 604

## Two Component Epoxy Flushing Compound

December 2014

NO.1451 v6

### Description

**Epoflush 604** is a two component epoxy compound for filling, fairing and flushing.  
**Epoflush 604** is non-shrinking, non porous and cold curing with excellent sanding properties.  
**Epoflush 604** two components (off white and charcoal) when mixed produce grey colour, comprising of epoxy resin and light fillers,  
**Epoflush 604** has a pot life of approximately ½ hour and dries to a hard sandable finish.

### Recommended Uses

**Epoflush 604** has a wide range of uses in the construction industry as a filling, fairing and flushing compound.

- \* General repair compound.
- \* Chases, cracks, channel filling compound.
- \* Filling screw holes in fibre-cement sheets.
- \* Filling rebate chases in plywood.
- \* Producing coves at upstands.
- \* Producing falls on sill rebates.
- \* Can be applied over most prepared surfaces.
- \* Can be applied 10mm thickness.

### Properties/Features

- **Epoflush 604** due to its composition has excellent non-slump and non-shrink properties therefore it is ideal for filling compound of holes, cracks and carrying out repairs
- **Epoflush 604** can also be applied in a thin film for flushing out and has excellent sanding properties and great adhesion of subsequent coatings.
- **Epoflush 604** is cold-curing epoxy, allowing cure to take place down to 0°C.

### Technical Data

#### Mixed Batch

Classification	2 component epoxy compound		
Colour	Grey	Specific Gravity	0.64 when mixed
Solids Content	100%	Application Method	Trowel
Cure Time	0.5hour @ 25°C, 2.5 hours @ 10°C	Packaging	2L & 4L Batch
Clean-up	Hitchins Thinners No 13	Viscosity	Non slump
Cured Properties	(standard hardener at 20°C)	Mix Ratio	1 : 1 by volume
Shelf Life	1 year in original unopened container	Flash Point	>150°C
V.O.C.	0 grams/litre		
Minimum Application Temperature : 0°C			
Pot Life (temperature dependent) : 1/2hour at 25°C, 2.5 hours at 10°C			

### Surface Preparation

- Thoroughly clean the surface of all extraneous matter, especially oil, grease, mould release agents, free of dust and dry.
- Nibs, laitance should be removed from concrete surfaces mechanically grinding or by acid etching and then thorough washing clean.
- For best results steel surfaces should be prepared by sand-blasting, grinding or sanding and primed Hitchins' Speedspray 10 or Jotamastic
- Chase pre-routed in plywood before installation of the sheets
- **Epoflush 604** is self-sealing (no need for sealer) by applying thin layer to surface first, when set apply fill layer.

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<b>EPOFLUSH 604</b> <i>Two Component Epoxy Flushing Compound</i>	
<b>December 2014</b>	<b>NO. 1451 v6</b>
<b>Packaging</b>	2 litre pack (1 litre hardener & 1 litre resin). 4 litre pack (2 litres hardener & 2 litres resin). Other sizes (Smaller and larger) are available on pre-ordering.
<b>Mixing</b>	<ul style="list-style-type: none"> <li>Mixing Proportions – 1: 1 by volume. Mix the two parts thoroughly by machine, spatula, or by hand until a uniform grey colour is obtained.</li> <li>Do not add any other substance to <b>Epoflush 604</b> including water as this may interfere with the final set and hardness.</li> <li>Pot life of mixed <b>Epoflush 604</b> (depending on temperature) is ½ hour at 25°C to 2½ hours at 10 °C. Mix only what you can apply in that timeframe.</li> <li>In cold weather placing the containers in hot water helps to soften the resin and hardener. When mixed pot life is considerably shorter.</li> <li>If hand mixing wear thin rubber gloves dampen with water for non-stick.</li> </ul>
<b>Application</b>	<ul style="list-style-type: none"> <li>To a prepared clean surface <b>Epoflush 604</b> should be worked well into surface to be filled or flushed out.</li> <li>Initial thin smear (film) of <b>Epoflush 604</b> is recommended to ensure the surface is properly “wet” with epoxy to obtain maximum “key”.</li> <li>After applying the initial layer, more <b>Epoflush 604</b> can be applied to completely fill the hole, chase, crack or surface undulation.</li> <li>Application by broad knife, flushing blade or trowel. Screeding bar can be used to remove ponding or to improve falls or when slightly overfilling, tools kept moist for smooth finish.</li> <li>Coves produced by placing <b>Epoflush 604</b> in up-stand junction and shaping with stainless steel coving tools or plastic bottle.</li> <li>Recessed joints in plywood substrate involves layer of <b>Epoflush 604</b>, lay-In mesh or Flexi-tape and flush out with <b>Epoflush 604</b>.</li> <li>Once cured <b>Epoflush 604</b> can be machine or hand sanded to produce a smooth surface.</li> <li><b>Epoflush 604</b> is an extremely versatile product with wide range of uses on wood, steel, aluminum, concrete, cementitious fibreboard etc.</li> <li><b>Epoflush 604</b> is particularly suitable for filling countersunk screw holes in fibre cement sheets, then sand smooth, seal and install Hitchins Formcote, Formwal 612 smooth coating systems and/or Hitchins textured finishes.</li> </ul>
<b>Precaution</b>	<ul style="list-style-type: none"> <li>* Recommend the use of barrier cream and wear thin rubber gloves to minimize skin contact to avoid skin irritation</li> <li>* Avoid eye contact. If eye contact occurs, thoroughly flush under running water for 15 minutes and seek medical advice if irritation persists.</li> <li>* Acquire copy of safety data sheet on <b>Epoflush 604</b>.</li> </ul>
<b>Clean Up</b>	<ul style="list-style-type: none"> <li>Equipment regularly cleaned with solvent before <b>Epoflush 604</b> sets</li> <li>Hands cleaned with hand cleaner and washed in soapy water curing.</li> <li>Protect hands with barrier cream</li> </ul>
<b>Health and Safety</b>	Refer to the Safety Data Sheet N° 1451 for more information for Part A and Part B.
<b>Non-Compliance</b>	Do not apply or install any Hitchins product or process to building structures that do not comply with the Building Code.
<b>Warranty</b>	<b>Epoflush 604</b> , as part of a process, is covered under the Hitchins Product Performance Warranty Document for “that” products process, as per our Warranty Schedule.
<b>Marketing</b>	<ul style="list-style-type: none"> <li><b>Epoflush 604</b>, manufactured under license for Hitchins New Zealand Ltd.</li> <li><b>Epoflush 604</b>, marketed under Hitchins New Zealand Limited trade name throughout New Zealand and Pacific Islands.</li> <li><b>Epoflush 604</b> product available from Hitchins offices and warehouse</li> </ul>