SOFTON PLUS 3022.

Medium weight universal polyester filler

12/02/15 LRD/nz

Description and use

Two-pack filler paste with added special hollow microspheres for excellent dry sanding results; its medium specific gravity allows not to make the parts heavier when applying in thick layers.
Easy to spread, it offers high adhesion to galvanized surfaces, steel, aluminium, light alloys and fiberglass.

Technical data

Colour	:	white
Specific gravity**	:	part A: 1.30 *kg/l* (± 0.03)
Hardener	:	paste code 4000
Curing ratio	:	100 of A + 1 ÷ 3 of B by weight with tube; DIDOC device: positions 1-2-3
Gel time**	:	4 ÷ 6 *minutes* with 2.5 parts by weight of hardener to 100 parts of A
Complete polymerisation**	:	after 2 *hours*
Sandability**	:	after 30 *minutes* on medium thickness
Flexibility	:	medium
Water resistance	:	excellent
Solvent resistance	:	excellent
Storage life**	:	12 months in original sealed container, away from light.

**Data recorded @ 20°C (68°F) and 65% RH.

The product is compliant with Directive **2004/42/CE-IIB(b)** maximum VOC limit value: 250 *g/l*

Application note

Suitable surfaces	:	Steel, cast iron, aluminium, light alloys, zinc plated steel, aged car paints and fiberglass free of detaching agents. For further information apply to our TECHNICAL SERVICE.
Not suitable surfaces	:	Wash primer, epoxy primers with phenolic hardeners, thermoplastic varnishes, solvent sensitive primers. Copper and its alloys must be previously treated with a non-phenolic or acid cured adhesion primer.
Surface preparation	:	Surfaces to be filled must be dry, clean, free of dust or grease, and made rough by sanding.
Application method	:	spatula (blade)
Product preparation	:	To use the filler, add the hardener according to the room temperature and the requested gel time, like the following schedule:

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Suggested ratio for a temperature	Tube (by weight)	DIDOC position
up to 10°C (50°F)	3 to 100	3
10 ÷ 20°C (50 ÷ 68°F)	2 to 100	2
over 20°C (68°F)	1 to 100	1

Stir thoroughly the two components and apply making a light pressure on the spatula, to get a better adhesion.
For the sanding work it's suggested the use of sandpaper P80, P120, P180, P240 grit.
For best result, spray over the filler a coat of insulating primer EQUALIX HS code 1513 or STAR PRIME HT code 1543 before applying the finishing paint.

Infrared rays lamps.
Using medium or short waves IR lamps, waiting time before sanding can be reduced, getting at the same time a more dry surface.
After application allow some minutes before radiating the filler.
It is important that filler temperature never exceeds 90°C (194°F). Refer to the lighting system manufacturer to get correct user information (e.g. times and distances).

NOTE: Avoid to apply when temperature is below + 10°C (50°F)

Information provided in this technical data sheet is based upon our best experience and technical knowledge; it does not absolve the users from carrying out tests and preventive checks in order to verify the suitability for use. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE.
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