

METAL FILL

3002.

Universal polyester filler with metal powder

06/09/10 LRD/nz

Description and use

Highly resistant and hard filler paste which can be applied on most metals. It is made up of unsaturated polyester resins, inert mineral and metallic extenders. Its lamellar structure ensures excellent adhesion even to difficult surfaces and in special condition, when ordinary fillers mechanical properties may be subjected to alterations. Especially recommended to reconstruct corroded metal parts and rusty fenders, to fix pieces by threading of the hardened filler, and to restore damaged parts on various substrates. Product also suitable for nautical use.

Technical data

Colour	:	iron grey												
Hardened product appearance	:	metal alike												
Binder	:	unsaturated polyester resins with high adhesion and resistance												
Specific gravity**	:	part A: 1.48 kg/l (± 0.03)												
Hardener	:	paste code 4000												
Curing ratio	:	100 parts of A + 2 ÷ 3 parts of B by weight.												
Gel time**	:	4 ÷ 5 <i>minutes</i> with 2 parts by weight of hardener to 100 parts of A												
Complete polymerization**	:	after 1 <i>hour</i>												
Workable**	:	after 30 <i>minutes</i> on medium thickness												
Flexibility	:	low												
Water resistance**	:	excellent												
Extension (traction) resistance**	:	approx. 300 Kg on thread 8 x 1,25 MA												
Adhesion**	:	indicative data registered by BS 5350 C5 method: <table border="0" style="margin-left: 20px;"> <tr> <td>Fe PO4</td> <td>:</td> <td>570 Kg/inch²</td> </tr> <tr> <td>rolled aluminium UNI 4507</td> <td>:</td> <td>420 Kg/inch²</td> </tr> <tr> <td>casting aluminium</td> <td>:</td> <td>400 Kg/inch²</td> </tr> <tr> <td>electro-zinc plated sheet</td> <td>:</td> <td>600 Kg/inch²</td> </tr> </table>	Fe PO4	:	570 Kg/inch ²	rolled aluminium UNI 4507	:	420 Kg/inch ²	casting aluminium	:	400 Kg/inch ²	electro-zinc plated sheet	:	600 Kg/inch ²
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Property of the polymerised filler	:	resistance indicative value: dip in water @ 40°C.(104°F.) : more than 15 <i>days</i> @ 150°C. (302°F.) of temperature: more than 3 <i>hours</i> to the thermal chock: more than 40 cycles from 0 to 100°C.(32 to 112°F.) in 15 <i>days</i> . to the acid of battery : more than 24 <i>hours</i> unaltered in discontinuous contacts with hydrocarbons and solvents in general.												
Storage life**	:	12 months in original sealed container, away from light.												

NB: Data recorded @ 20°C.(68°F.)

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

Application note

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- Suitable surfaces : Steel, cast iron, aluminium, light alloys, zinc plated steel and fiberglass free of detaching agents.
For any 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, degreased, roughed and free of existing paints.
- 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:

Suggested ratio for a temperature	Tube (by weight)
up to 15°C. (59°F.)	3 to 100
over 15°C. (59°F.)	2 to 100

Stir thoroughly and apply the filler pressing down the spatula in order to have the best adhesion. The hardened filler can be worked with an abrasive disc for metal after about 30 minutes with a temperature ambient/metal of 17 ÷ 30°C.(62 ÷ 86°F.) or after 50 minutes when it is 10 ÷ 17°C.

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.