

F 1000

Universal polyester filler

3130.

11/05/17 LRD/ib

Description and use

Bi-component plaster in paste with good flexibility and high adhesion onto galvanized sheet steel, steel, aluminum, light alloys and fiberglass.

The excellent sanding and easiness to apply make it an excellent base product for repair-work, filling and shearing on every type of support-structure, both in bodywork and in industrial activities.

Technical data

Colour	: yellow
Specific gravity**	: part A: 1.82 kg/l (± 0.03)
Hardener	: paste code 4000
Curing ratio	: 100 of A + 1 ÷ 3 of B by weight
Gel time**	: 4 ÷ 6 <i>minutes</i> with 2 parts by weight of hardener to 100 parts of A
Complete polymerisation**	: after 2 <i>hours</i>
Sandability**	: after 30 <i>minutes</i> on medium thickness
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.
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:

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

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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 final result, before applying the top-coat spray over the filler a coat of the High Solids Primer EQUALIX HS code 1513 or STAR PRIME HT code 1543.

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 or for suggestions about specific systems and/or applications, please contact our TECHNICAL SERVICE.

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