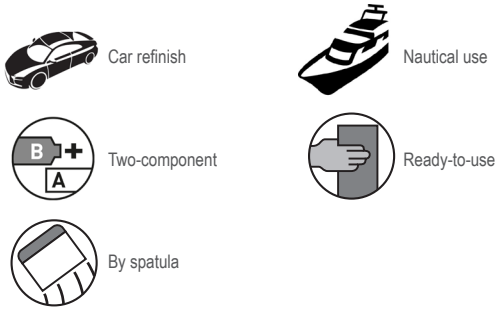
3002 METAL FILL

UNIVERSAL POLYESTER FILLER WITH METAL POWDER



Advantages

→ very tough and resistant after hardening

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.

Substrate preparation

Surfaces to be filled must be dry, degreased, roughed and free of existing paints.

Suitable surfaces:
Steel, cast iron, aluminium, light alloys, zinc plated steel and fiberglass free of detaching agents.
For further information apply to our TECHNICAL SERVICE.

Not suitable substrates:
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.

Application

Application method:
- By spatula

Product preparation:
To use the filler, add the hardener to the filler according to the room temperature and the requested gel time, like the following schedule:

Curing ratio	Tube
Temperature up to 15°C (59°F.)	3 to 100 by weight
Temperature over 15°C (59°F.)	2 to 100 by weight

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Application method:
Stir thoroughly the two components and apply making a light pressure on the spatula, to get a better 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.
If necessary, top up with non-reinforced polyester filler.

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 12 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with the current legislation.

Technical features

Colour	iron grey	
Appearance of the hardened product	metal alike	
Binder	unsaturated polyester resins with high adhesion	
Specific gravity comp. A *	1.48 kg/l (± 0.03)	
Hardener	paste code 4000	
Curing ratio	100 di A + 2-3 di B by weight	
Gel time *	4-5 minutes with 2 parts by weight of hardener to 100 parts of A	
Complete polymerisation *	after 1 hour	
Sandability *	after 30 minutes on medium thickness	
Flexibility	low	
Water resistance *	excellent	
Tensile strength *	approx. 300 Kg on thread 8 x 1,25 MA	
Adhesion * indicative data registered by BS 5350 C5 method	Fe P04	570 kg/inch²
	Rolled aluminium UNI 4507	420 kg/inch²
	Casting aluminium	400 kg/inch²
	Electro-zinc plated sheet	600 kg/inch²
Property of the polymerised filler resistance indicative value:	dip in water at 40°C (104°F)	more than 15 days
	at 150°C (302°F.) of temperature	more than 3 hours
	to the thermal chock	more than 40 cycles from 0 to 100°C (32 to 112°F) in 15 days.
	to the acid of battery	more than 24 hours
	In discontinuous contacts with hydrocarbons and solvents in general.	unaltered
EU limit values for VOC content (Directive 2004/42/EC)	Category B/b: VOC max 25g/l product VOC < 250g/l	
* The data are measured at a temperature of 20°C and 65% R.H.		

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Warnings

- For professional use only.
- Always read the safety datasheet before use.
- Dispose of contents / container in accordance with national regulations.
- Clean equipment immediately after use with cellulose thinner.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

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

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