

3220 F20

UNIVERSAL POLYESTER FILLER



Two-component



Trowel

Advantages

- Very fine texture
- Extremely easy to apply

Description and Use

High specific gravity universal plaster in paste

Highly versatile, it is suitable for application on galvanized sheet steel, steel, aluminum, light alloys and fiberglass, where it ensures good adhesion and sanding.

The ease of spreading with a spatula and the smooth look ensures a surface without porosity or flaws.

Substrate preparation

Surfaces to be filled must be dry, clean, free of dust or grease and made rough by sanding.

Suitable substrates:

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 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:

- trowel

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	DIDOC
Temperature up to 10°C (50°F)	3 to 100 by weight	3
Temperature between 10 and 20°C (50 ÷ 68°F)	2 to 100 by weight	2
Temperature up to 20°C (50°F)	1 to 100 by weight	1

Application method:

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 thin layers or in case of low temperature the waiting time for sanding and recoating is longer than those reported in technical data.

For an excellent final result, before painting it is recommended to apply an insulating primer EQUALIX HS item code 1513 or STAR PRIME HT item 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 drier 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).

Sanding:

after 30 minutes on medium thickness.

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 current legislation.

Technical features

Colour	yellow
Specific gravity comp. A	1.80 kg/l (±0.03)
Hardener	paste code 4000
Curing ratio	100 of A + 1-3 of B by weight with tube
	positions 1-2-3 with DIDOC
Gel time	3 ÷ 5 minutes with 2 parts by weight of hardener to 100 parts of A
Complete polymerisation	after 2 hours
AFNOR NF T 36-005 classification	Family 4 - Class 3
EU limit values for VOC content (Directive 2004/42/EC)	Category B/b, SB: VOC max 250 g/l product VOC < 250g/l
The data are measured at a temperature of 20°C and 65% R.H.	

Warnings

- For professional use only.
- Always read the safety datasheet before use.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of 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.)

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.tecnica@impa.it.