

3025 SOFTON HT

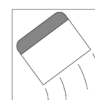
MEDIUM WEIGHT UNIVERSAL POLYESTER FILLER



Two-component



See warnings



By spatula

Advantages

- Medium specific gravity
- Excellent sanding
- Easy to spread

Description and Use

Two-pack filler paste of medium specific gravity that allows not to make the parts heavier when applying in thick layers. Easy to spread, it guarantees a surface without flaws and excellent sanding without kneading the sandpaper. This special formulation ensures high adhesion to galvanized surfaces, steel, aluminium, light alloys and fiberglass.

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:

- 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	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 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 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 the current legislation.

Technical features

Colour	white
Specific gravity comp. A	1.26 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	4-6 minutes with 2.5 parts by weight of hardener to 100 parts of A
Complete polymerisation	after 2 hours
Flexibility	medium
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 250g/l; product VOC < 250g/l
The data are measured at a temperature of 20°C and 65% R.H.	

Warnings

- The product contains synthetic polymer microparticles (SPM).
- **INSTRUCTIONS TO PREVENT THE RELEASE OF SYNTHETIC POLYMER MICROPARTICLES INTO THE ENVIRONMENT**
- In accordance with Regulation (EU) 2023/2055, please follow the procedures below to prevent environmental release.
- During use and application, avoid accidental release of the product onto soil, into drains, or household wastewater. Apply the product only to the surfaces to be treated.
- Any remaining product should be stored by tightly sealing the original container. Dispose of the product/container in accordance with national regulations.
- If you wish to reuse the tools used for application, follow these steps to clean them in an environmentally responsible manner.
- The water, 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.
- Remove as much product as possible from the tools used.
- Soak the tools in hot water or in solvent for at least a couple of hours, then remove them from the container.
- Allow the water in the bucket to evaporate and let the tools dry. For solvent-based products, close the container. Do not release the product into the environment and do not pour it into drains.
- Deliver the container with any remaining product / wash water / solvent / cleaning thinner to an authorised waste collection centre, in accordance with national regulations.
- For professional use only.
- Always read the safety datasheet before use.
- 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.

It is recommended not to use when temperature is below + 10°C.(50°F.) or above 35°C.(95°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.technica@impa.it.