Technical Data Sheet

ALUMINIUM

Body Filler with Aluminium Powder

PROPERTIES

- Designed and dedicated for the refinishing of classic cars
- Very easy to apply over large work areas
- Increased resistance to high temperature
- Superb adhesion
- Lower shrinkage than in regular fillers helps with filling large defects

DESCRIPTION

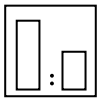
The filler is intended for sculpting the profiles of workpieces highly exposed to heat, like engine bonnets, body roofs or top surfaces of fenders. The ALUMINIUM filler features a special selection of filling materials to provide superior heat transfer for extremely fast heating and cooling rates.

SUBSTRATES	
EPOXY PRIMER	Apply once the epoxy primer has cured for 24h at 20°C. Dry sand with a claret abrasive cloth or P220 - P240 grit paper. Blow off all dust and degrease with the SILICONE REMOVER.
HYBRID EPOXY PRIMER – ANTI-CORROSION	It is recommended to be applied after 24h at 20°C The chemical activity life is up to 7 days at 20°C without matting. If necessary, dry sand with a red abrasive cloth or P220 - P240 grit paper. Blow off all dust and degrease with the SILICONE REMOVER.
HYBRID EPOXY PRIMER – ISOLATOR	Apply at least 1h at 20°C after application of the HYBRID EPOXY PRIMER – ISOLATOR. Requires no sanding for up to 12h to 20°C. After more than 12h at 20°C, sand with a red abrasive cloth. Thoroughly blow off all dust and degrease with the SILICONE REMOVER.
HYBRID EPOXY PRIMER – FILLER	Can be applied after 24h at 20°C. Dry sand with P220 - P240 grit paper.
ELASTIC FIBER filler	Application of subsequent ELASTIC FIBER layers requires no sanding for up to 24h at 20°C after application of the last ALUMINIUM layer. If necessary, rough sand with P80 - P120 grit paper, blow off the dust, apply the Control Powder or the CONTROL SPRAY, and sand with P220 - P240 grit paper to finish. Follow by thoroughly blowing off all dust, degrease with the SILICONE REMOVER and blow off all dust again.
BODYWORK PRIMER	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Steel	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – new parts and body panelling	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – body parts for refinishing	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.

Existing coatings	Do a solvent effect test. If the old coating resists the solvent, strip it away and apply anti-corrosion protection according to the NfCC processing procedures. Degrease with the SILICONE REMOVER, dry sand with P220 - P240 grit paper, blow off all dust again and degrease again.
Old polyester laminates	Degrease with the SILICONE REMOVER, dry sand with P180 - P240 grit paper, blow off all dust again and degrease again.
Two-component acrylic primers	Degrease with the SILICONE REMOVER, dry sand with P220 - P240 grit paper, blow off all dust again and degrease again.

The NfCC refinishing process does not permit direct application of polyester products on metallic substrates. Anti-corrosion preservation with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION is required.

MIXING RATIO



	Weight ratio
ALUMINIUM	100 g
HARDENER	2 - 3 g

It is natural for polyester fillers to exhibit sedimentation coupled with surfacing of a part of the resin and the dye. It is perfectly normal and common to this type of product.

It is always necessary to homogenize the product by stirring it in the container before mixing with the hardener.

Add the hardener in strict compliance with the specified mixing ratio. Overdosing the hardener will not reduce the curing time required to achieve processability.

Always reseal the container tightly after use. An unsealed container will cause the reactive monomer (styrene), required for proper cross-linking of the polyester filler, to evaporate.

VOC CONTENT

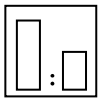
VOC II/B/b limit*	250 g/l
Actual VOC	90 g/l

* For a ready for use (RFU) mixture acc. to EU Directive 2004/42/CE.

APPLICATION CONDITIONS

It is recommended to apply the filler at more than +10°C.

The substrate temperature during application of the filler must be at least 3°C higher than the dew point to avoid condensation and its absorption by the polyester material.

APPLICATION	
	Clean and sand the surface as specified. Thoroughly blow off all dust from the sanding marks.
	Degrease with the SILICONE REMOVER.
	Mixing ratio by weight: Add 2 - 3 g of the hardener to 100 g of the ALUMINIUM. Follow the required hardener ratio. Thoroughly mix the components.
	The curing time is 4 - 6 min at 20°C.
	It is best to apply the filler to the pretreated surface with the putty knife held at 60° to the surface. The maximum single layer thickness should be 2 - 3 mm*. The maximum total thickness of polyester filler/putty layers should be 5 mm. Avoid application in thick layers at the edges of the work area.
* Apply the filler as thin as possible to avoid internal stresses which could cause workpiece deformation.	
	Use of the correct PPE is recommended!

CURING TIMES		
	20°C	60°C
	25 - 35 minutes	10 minutes
The curing time is specified for the body workpiece temperature and not the air temperature! The polyester filler/putty is fully crosslinked after 72h at 20°C.		

IR DRYING	
	Dry for 10 min maximum. A short-wave IR lamp is recommended. Follow the recommendations of the equipment manufacturer!

SANDING	
	**Step 1:** Apply the Control Powder or CONTROL SPRAY **Step 2:** Rough sand with a hand sanding block or an orbital/eccentric sander and P80 - P120 grit paper **Step 3:** Blow off all dust and apply the Control Powder or CONTROL SPRAY **Step 4:** Finish sand (process the edges by hand) using an orbital/eccentric sander and P220 - P240 grit paper
Always dry sand the ALUMINIUM. Wet sanding may result in coating defects due to the hygroscopic response of the polyester resin and certain polyester filler/putty filling materials.	
	Use of the correct PPE is recommended!

COLOUR
Dark grey.

EQUIPMENT CLEANING
NC thinner or THIN 880.

STORAGE CONDITIONS
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.

SHELF LIFE	
ALUMINIUM	24 months/20°C
HARDENER	18 months/20°C

SAFETY
See the Safety Data Sheet. For professional use only.

OTHER INFORMATION
The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained here meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials. We cannot be held liable for defects where the final results were affected by factors beyond our control. This TDS supersedes all its previous issues. Index number: 000024104