



POLYESTER FILLER PASTES

FOR GENERAL USE

ADTECH
Plastic Systems

APPLICATION GUIDE

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POLYESTER FILLER PASTE - INSTRUCTIONS FOR GENERAL USE

MIXING INSTRUCTIONS:

The optimum mix ratio for most Adtech Polyester Filler Pastes is 100 parts Resin to 2 parts (by weight) BPO Cream Hardener (consult your Product Data Bulletin before beginning - some polyester pastes are promoted for use with MEK-P catalysts only – consult your product data bulletin for catalyst information). If the material is notably over or under catalyzed, its physical properties and adhesion characteristics can be reduced.

Once the proper mix ratio has been attained, mix the Resin and Hardener thoroughly, being careful to scrape the sides and bottom of the mixing container. Mix until the material is homogenous. If a colored hardener is used, mix until all streaks are gone.

The work life (gel time) of different products will vary somewhat. Consult the specific Product Bulletin or your CASS Polymers representative prior to mixing.

REPAIR PROCEDURES:

Adtech Polyester Filler Pastes can be used to make surface cosmetic repairs on a wide variety of parts and substrates; FRP, automotive SMC, marine composites, aircraft fire retardant composites, CNC modeling planks, high temperature composite molds, jigs, fixtures, woods and metals, to list a few. Consult your CASS Polymers representative for the product best suited to your application.

To obtain maximum adhesion and physical properties, care should be taken that the surface has been properly prepared, the proper mix ratio and catalyst is used as specified on the Adtech Product Bulletin, and that the material is thoroughly mixed. Begin by sanding or grinding the area to be repaired, making sure to remove any dust or debris using compressed air or vacuum. Do not use solvent to remove sanding dust.

Apply catalyzed Adtech filler paste with a spatula or bondo spreader, slightly overfilling the repair area, and allow for cure to sanding time to occur before proceeding. Polyester repair pastes will shrink to some degree. The procedure of slightly over filling the repair area, sanding/fairing the repair flush to the surrounding surface, will compensate for shrinkage and prevent the repair from reading-out on the surface of your part or mold. Once cured and finished, Adtech Polyester Filler Pastes will accept virtually all types of finishes with no "bleed out".

FAIRING APPLICATIONS:

For fairing applications follow the mix ratio and mixing instructions and use a bondo spreader or template to spread material. Do not mix more material than can be applied in the allotted work life. Material thickness should not exceed 1/8" per application.

BONDING APPLICATIONS:

Adtech Polyester Filler Pastes can be used for bonding as well as filling on various substrates. Bonding applications include: SMC to SMC, FRP Composites to FRP, fiberglass to metal, metal to concrete, metal to metal, wood to wood and concrete to concrete. Consult your CASS Polymers Representative for the material best suited to your application.

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Prepare the surface to be bonded by scuffing, sanding or solvent wipe. Make sure the surface to be bonded is clean and free of any loose debris. Refer to your Adtech Product Data Bulletin for the proper mix ratio.

Mix Resin and Hardener thoroughly, being careful to scrape the sides and bottom of the mixing container.

Apply the material to the substrate to be bonded and apply clamping pressure. **Caution:** Applying excessive clamping pressure may force material away from the bond surface causing inadequate bond strength and resulting in part failure.

Once set (refer to the finish schedule on the Product Data Bulletin), the material can be readily machined or ground off. The system will accept all finishes with no "bleed-out" and is considered non-moisture absorbing.

MASTER MODEL APPLICATIONS:

For master model applications, CASS Polymers offers a variety of ADTECH Polyester Filler Pastes ranging from carvable, to semi-carvable, to machinable. This selection offers the pattern and model maker the versatility of forming, shaping and working the cured filler to accurate trade applications without dulling tools. Common applications for these materials include pattern build-up, rebuilding of broken areas, cope and drag changes and design engineer changes. The material can be applied with fillet balls, spatula or a putty knife. Adtech pattern and model fillers are non-directional when cured to resist chipping and cracking.

FILL & SWEEP APPLICATIONS FOR FIRE RETARDANT AIRCRAFT COMPONENTS

Prepare the composite panel surface by lightly sanding the entire surface with 100-grit sandpaper. Make sure the surface is clean and free of any loose debris.

Thoroughly mix Adtech Flame Retardant Filler P-15-3 per the instructions on the Product Data Bulletin.

Using a bondo squeegee or spatula, apply P-15-3 to the composite panel, thick enough to cover the pattern or weave in the panel.

Once the material has gelled, allow approximately 10-15 minutes for cure before proceeding.

Sand the surface to a smooth finish.

Complete the finish. Adtech Flame Retardant Filler P-15-3 will accept virtually all types of finish with no "bleed out".

HONEYCOMB EDGE FILLING

Applications include aircraft/aerospace and tooling. All composite honeycomb materials require edge filling.

Adtech Flame Retardant Filler P-15-3, (or Edge Fill ED-2016, ED-2017 or ED-2018 which are not polyester products) is suitable for aircraft/aerospace applications. Consult your CASS Polymers Representative for the material that best suits your application.

Once the proper material has been selected, thoroughly mix the resin and hardener, being sure to scrape the sides and bottom of the mixing container. Mix the material until it is homogeneous.

Apply the edge filler with a spatula, taking care to leave no voids. Scrape away any excess material flush with the surface of the composite and allow the filler to fully cure (See Specific Product Bulletin).

After full cure is reached, the material is ready for sanding and finishing. The material will not bleed out nor present any residuals.