

Product Bulletin

CASS POLYMERS

ADTECH
Plastic Systems
SC-9001 Registered



Phone: 800 344 7776
Fax: 248 588 5909
815 West Shepherd Street
Charlotte, MI 48813-0523
plastic@casspolymers.com
www.casspolymers.com

NO. 14
ULTRA FILLER
RIGID - MACHINABLE
WHITE - GRAY - BROWN

0302

DESCRIPTION

The most versatile of all set-fast filler pastes, ULTRA FILLER No. 14 is a two component filler system which yields a smooth, creamy, thixotropic and workable paste with superior handling, set-fast characteristics and dimensional stability. Once applied it forms a rigid, strong surface which can be machined, sanded, filed or scraped to a feather edge. No. 14 adheres and bonds to fiberglass, SMC, RIM, BMC, Graphite, Kevlar® and other types of composites as well as aluminum, steel, grey iron, copper, plaster, models, patterns and other substrates. No. 14 offers the industry manufacturer a wide variety of applications for bonding, filling, sealing and finishing with optimum physical properties. ULTRA FILLER can be applied without pin-holing and exhibits no shrink or sink after curing. It accepts virtually all types of finishes e.g., lacquer, enamel, polyurethane, epoxy, etc., without any special surface preparation. It is a "no bleed out" system after finishing or if covered with a decorative film. No. 14 is a safe system for the applicator. However, it should be used in a well-ventilated area. Its high quality coupled with the set-fast feature offers industry substantial savings in time and labor plus top quality in the finished product.

USES

- Filling composite surface porosity
- Honeycomb panel edge filler
- Bonding loose pieces and details
- Vacuum mold repairs and modifications
- Urethane mold repairs and modifications
- FRP composite repairs
- Pattern repairs and fillets
- Core box repairs and modifications
- Void and porosity filling
- Router fixture repairs
- Crack, dent and crevice repair
- Temporary holding fixtures
- Filling cloth impression in prepreg
- Non-conductive barrier potting
- RIM/SMC/BMC surface filler
- Bonding inserts/hangers
- Urethane part repair
- Potting stripped threads
- Renewing worn surfaces
- Many others...

No. 14 can be used in areas of final fabrication, production, tooling, model & pattern making, repair operations and in many other applications.

HANDLING CHARACTERISTICS @ 25°C/77°F, 100 gram mass

Mix Ratio (parts by weight or volume).....	100R/2H
Mixed Viscosity	Thixotropic Paste
Mixed Consistency	Smooth/Creamy
Work Life	5 ± 1 minutes
Finish Schedule	15 minutes
Hardness after 1 hour	86 Shore D
Water Absorption (24 hour immersion)	0.16%

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MIXING INSTRUCTIONS

1. Stir contents of can thoroughly using a spatula or putty knife. Place the required amount of filler and cream hardener on a disposable clean surface.
2. Mix ratio: 100 parts paste to 2 parts cream hardener by weight, i.e. size of golf ball (paste) to a two inch strip of catalyst.
3. Set up time of mix at room temperature will be 5-10 minutes and may be adjusted faster or slower by increasing or decreasing the amount of hardener.

CAUTION: THE USE OF TOO MUCH HARDENER CAN CAUSE GUMMINESS IN THE FILLER.

4. After 15-20 minutes the filler may be filed or sanded to final finish.

CHEMICAL RESISTANCE GUIDE

ADTECH Ultra Filler No. 14 combines saturated and unsaturated Polyester resins of medium to high reactivity. As an aid to the user, chemical resistance evaluations were conducted, using a modification of ASTM 0543-60T.

PROCEDURE:

Samples nominally sized at 1/2" x 1" x 4" were immersed halfway in 4 ounces of reagent and stored for 12 months at ambient temperature. Reagents were swirled monthly, and specimens were rated every 4 weeks.

Rating Results:

Excellent, No Visible Attack

Benzene
Gasoline
Methanol
Mineral Spirits
Water (Distilled)

Good, Very Slight Attack

Acetic Acid (5%)
Citric Acid
Hydrochloric Acid (10%)
Nitric Acid (10%)
Sodium Hydroxide (5%)
Sulfuric Acid (10%)

Not Recommended

Acetone