

SPECIFICATIONS

Prepared on:
January 18, 2005



Updated on:
April 18, 2004

Page 1 of 3

Product name: PE Poly-Plast Polyester Resin for Lamination

Medium-elastic, high-durability unsaturated polyester resin. Designed for manual and spray lamination during bodywork/sheet-metal and lacquer repairs.

Container:	Resin - 0.975 kg; hardener 25 g.
Product and additives:	The PE Poly-Plast resin for lamination; Peroxide hardener, paste; The APP PE POLY-PLAST glass mat. The APP PE POLY-PLAST glass fabric.
Basic components:	The PE Poly-Plast resin for lamination - unsaturated polyester resin. Hardener - DIBENZOYLPEROXIDE, paste.
Colour:	Transparent yellow.
Output:	0.5 kg of glass-fibre mat or fabric is used per 1 kg of the product. Caution! In practice the output depends on certain factors including: object shape, roughness of the base, method of application and working conditions.

Usage

The product with glass fabric or mat has the following applications:

- for the filling of large material chips/cavities and holes;
- for the strengthening of spots weakened by corrosion;
- for the filling of perforations in metal surfaces;
- for the production and repairs of boats and camping equipment made of metal and laminates.

After hardening, the coat obtained through lamination provides high resistance to mechanical stresses and vibrations.
It is resistant to a temperature up to +120°C, and the action of oils, lubricants/ greases and petrols/naphtha.

Base

Proper base types: The product adheres very well to: metal, old lacquer coats and 2K primers, polyester laminates and wood.

Caution!
Do not apply onto: acid-hardenable reacting primers, acrylic and nitro-cellulose unary primers, and thermoplastic lacquers (T.P.A.).

The above information complies with current knowledge on our products and their possible applications. This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

**Auto Plast Produkt Sp. z o.o. [Ltd.] 62-300 Września, ul. Przemysłowa 10, Poland
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Page 2 of 3

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Base preparation:



Steel:

- degrease and polish dry using P60-P80 abrasive paper.

Zinc-coated steel sheet, aluminium:

- degrease and polish dry using abrasive fabric or P80-P120 abrasive paper.

Existing finish:

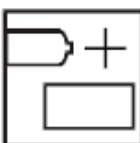
- polish with P60-P80 abrasive paper to bare metal or until the proper surface quality is obtained, then smooth down all lines of transition to the old coating using P80-P120 abrasive paper.



Before lamination, remove any dust from the treated surface and degrease it using the W900 or WB900 remover.

Application

Mixing ratio(s):



100 parts by weight of the APP PE Poly-Plast resin for lamination
2-3 parts by weight of the hardener

Caution!

Avoid hardener overdosing, as this may cause local lacquer coating discolouration and poor hardening quality.

Mix until a uniform colour is obtained.

Do not pour the remaining hardener and resin mixture into the container.

Lamination:



- Cut out a properly-sized piece of glass-fibre fabric. Mix polyester resin with 2-3% of hardener added.
CAUTION! At a temperature of +20°C, the mixture is suitable for use for 8-10 minutes.
- Use a paintbrush or paint roller to spread the mixture onto a derusted and degreased surface.
- Apply the previously prepared piece of glass-fibre fabric onto the surface to be repaired.
- Use a paintbrush or paint roller to spread the rest of the resin and hardener mixture onto the surface to be repaired. During lamination, make sure to air bubbles, which formed whilst applying the resin, are removed. If necessary, apply several layers of the glass-fibre fabric.

Recommended working temperature: from +15°C to +25°C.

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Page 3 of 3

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Drying



At a temperature of +20°C, the material is ready for further treatment after 40-50 minutes.

Long-term thermal resistance after hardening: up to +120°C, but no more than the thermal resistance of the base.

After hardening, the material is resistant to solvents and low-concentration acids, bases and brine. It offers high elasticity and improved mechanical resistance.

Polishing:



After complete hardening:
dry pre-polishing: P60;
dry rough polishing: P120/P150.

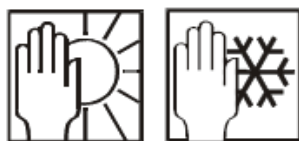
Coverage:

APP PE Poly-Plast Füllspachtel
APP SOFT Poly-Plast
APP ALU Poly-Plast
APP PE Poly-Plast Feinspachtel
APP PE Poly-Plast Spritzfuller
APP 1K Haftgrund
APP 2K Haftgrund
APP 1K Filler
APP 2K HS Acrylfüller 5:1
APP 2K Grund EP

Equipment cleaning:

Wash with nitrocellulose solvent immediately after use.

Storage:



Store in original, closed containers in a dry and well-ventilated room.
Protect against freezing.

Industrial safety regulations:



For professional use only.
See: information on product labels and/or in Hazardous Material Safety Data Sheet.
Users should observe all industrial safety regulations applicable in their countries.

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