

[METRIC]
A-A-3133
October 24, 1997
Superseding
Fed. Spec.
TT-F-322E
Sept. 28, 1992

COMMERCIAL ITEM DESCRIPTION

FILLER, TWO-COMPONENT TYPE (FOR DENTS, CRACKS, SMALL HOLES, AND BLOW HOLES)

The General Services Administration has authorized the use of this commercial item description by all federal agencies.

1. **Scope.** This technical purchase description covers a commercial two-component filler, resin and hardener/curing agent, to be mixed in proportion recommended by the manufacturer for use in filling dents, cracks, small holes, etc., in metal and wood.

2. **Salient Characteristics.**

2.1 Physical requirements:

2.2 Composition. The filler shall consist of two components and shall be furnished unmixed in two separate containers.

2.2.1 Component A. Component A shall be furnished in paste form, consisting of commercially available synthetic resin with suitable extender or pigment.

2.2.2 Component B. Component B shall consist of benzoyl peroxide with suitable extender and necessary amount of plasticizers and shall be furnished in cream or paste form.

2.2.3 Working properties. When components A and B are mixed in accordance with manufacturer's direction, the product shall spread smoothly and shall show no tendency to gouge. The color of the mixed filler shall be significantly different than the color of either component A or component B.

2.2.4 Quantitative requirements. When mixed, the products shall comply to all requirements specified in Table I.

Beneficial comments, recommendations, additions, deletions, clarification, etc., and any data which may improve this document, should be sent to: GSA, Paints and Chemicals Commodity Center, 400 15th Street, S.W., Auburn, WA 98001.

CID A-A-3133

Characteristics	Min.	Max.	ASTM Method *
Gel time, minutes @ 25°C (77° F)	4.5	6.5	D 2471
Hardness, shore D	55	75	D 2240
Time to attain shore D-20, minutes	7	11	
Time to attain shore D-40, minutes	13	20	
Time to attain shore D-50, minutes	18	25	
Adhesive shear, kPa (psi)	6895(1000)	—	para. 3.2
Viscosity, cps RVT Brookfield-TD spindle, @ 2.5 RPM (within 4 minutes after mixing.)	400,000	600,000	

NOTE: The contractor may use his normal quality assurance procedures for manufacture of this product; however, should a disagreement arise between the Government and its customer or between the Government and the manufacturer concerning compliance to the salient characteristics of this commercial item description, the test methods and tests stated in this commercial item description will be used to determine compliance of the product.

2.2.5 Prohibited materials. The product shall not contain lead, benzene, chlorinated solvents or ethylene-based glycol ethers and their acetates. Mercury and hexavalent chromium compounds shall not be used.

3. Quality Assurance Provisions.

3.1 Product Conformance. The products provided shall meet the salient characteristics of this commercial item description, conform to the producer's own drawings, specifications, standards, and quality assurance practices and be the same product offered for sale in the commercial market. The Government reserves the right to require proof of such conformance.

3.2 Adhesive shear. Prepare 6, low alloy, steel panels measuring approximately 2.5 cm x 10 cm (1 in. x 4 in.) by lightly sanding the surfaces with No. 80 grit paper, wiping off any loose particles and then clean with aliphatic naphtha and isopropanol. On the surface of one end of one of the cleaned panels, apply approximately 6.3 square centimeters (1 sq. in.) of mixed filler. Sandwich the filler between the two panels and press together to achieve approximately 0.4 mm (0.015 in.) of filler thickness between the panels and allow to dry at room temperature for 24 hours. Pull the strips apart, using Instron (or equal) equipment, at a separation rate of 1.27 mm/minute (0.005 in./minute.) The reading taken at failure and converted to kPa (psi) shall comply with the requirement of Table I.

3.3 Shrinkage. Solvent clean two small shallow tin or tennplate lids approximately 5 cm (2 in.) in diameter and 1 cm (3/8 in.) high. Fill with thoroughly mixed filler and level with top of the lids. Care should be taken to work out all bubbles. Allow to dry for 7 days at room temperature. The filler shall show no cracking and no more than 0.5 mm shrinkage away from the rim of either lid.

* ASTM standards and specifications may be ordered from American Society for Testing and Materials, 100 Barr Harbor Drive, Conshohocken, PA 19428-2959.

4. Packaging, packing, and marking. Packaging and packing shall be normal commercial practice. Marking shall be as specified in the contract or order.

Preparing Activity:

GSA - FSS

FSC 8030