

DESCRIPTION

P-76 FiberBond Repair Filler is the ultimate choice for tackling large cracks and abrasions on your boat's deck, hull, keel transom, etc. This fiberglass reinforced filler is specially formulated for heavy duty jobs requiring increased impact strength and durability and is compatible with fiberglass, wood, metals, and most plastics. P-76 FiberBond Repair Filler is water resistant allowing for above or below the waterline applications. The finish can be sanded, machined, tapped, or painted.

APPLICATIONS

- Large cracks and abrasions on boat parts
- Heavy duty jobs and repair of damaged fiberglass parts

PROPERTIES

- Easy to apply
- Water resistant for above or below the waterline applications
- Minimal shrink or sink upon cure
- Compatible with fiberglass, wood, metals, and most plastics
- Good impact strength

PHYSICAL PROPERTIES				
	Units(s)	P- 76 FiberBond	Cream Hardener	Mixed
Composition		Polyester resin	BPO	Polyester paste
Mix ratio – by weight		100	2	100/2
Aspect		Paste	Paste	Creamy non-sag paste
Color		Dark green	White / Red / Black	~ Dark green
Viscosity – Brookfield (Sp. 7@ 5)	Cps.	300,000 – 500,000		300,000 – 500,000
Density at 77°F (25°C)	lbs./gal (g/cc)	11.3 (1.36)	10.0 (1.20)	11.4 (1.37)
Pot life (102 g) at 77°F (25°C)	minutes			4.0 – 6.0

PROCESSING CONDITIONS

- Thoroughly blend 100 parts resin with 2 parts hardener by weight for 1 to 1 ½ minutes in a clean dry container or on a clean dry surface. (i.e. approximatly the size of golf ball paste to a two-inch strip of cream hardener).
- Carefully scrape the surfaces while blending to ensure complete mixing and uniformity.

SURFACE PREPARATION and APPLICATION

- The area to be filled or repaired should be thoroughly cleaned, roughened, cleaned again and allowed to dry prior to application to ensure the best possible adhesion.
- The mixed P-76 FiberBond should be buttered into the area, avoiding trapping air during application.
- After curing to a tack-free state, the material can be sanded and finished as needed.

MECHANICAL AND THERMAL PROPERTIES*

Property	Test Method	Units(s)	Test Results
Hardness	ASTM D-2240	Shore D	83
Flexural strength	ASTM D-790	Psi (Mpa)	4,360 (30)
Flexural modulus	ASTM D-790	Psi (Mpa)	216,100 (1,491)
Tensile strength	ASTM D-638	Psi (Mpa)	2,419 (17)
Tensile modulus	ASTM D-638	Psi (Mpa)	398,300 (2,748)
Tensile elongation	ASTM D-638	%	1.3
Compressive strength	ASTM D-695	Psi (Mpa)	3,505 (24)
Compressive modulus	ASTM D-695	Psi (Mpa)	63,000 (435)
Adhesive pull strength to: Mahogany - Epoxy glass laminate -	ASTM D-2240	psi (MPa)	850 (5.8) 420 (2.9)
Water absorption (%) 24 hr @ room temperature	ASTM D-570	%	1.15
HDT – Heat deflection temperature @ 66 psi @ 264 psi	ASTM D-648	°F (°C)	130 (55) 120 (49)
Cure time to handling strength		Minutes	15-20

*Cure schedule: 7 days/77°F (25°C)

STORAGE CONDITIONS

- Product shelf life of polyester resin is 12 months when stored in original unopened containers between 65 – 77°F (15 – 25°C). Any opened can must be tightly closed. Product shelf life of BPO hardener is 18 months when stored in original unopened containers between 65 – 77°F (15 – 25°C). Any opened can must be tightly closed.
- Polyester resin contains filler which has the potential to separate in time, please re-homogenize prior to use.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves, and safety glasses.

For further information, please consult the material safety data sheet.

DISCLAIMER

The information contained in this technical data sheet results from research and tests conducted in our laboratories under precise conditions. Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. It is the responsibility of the user to determine the suitability of the SikaAxson's products, under their own conditions, before commencing with the proposed application. In no event shall SikaAxson US be liable for any direct, indirect, punitive, incidental, special, and/or consequential damages, to property or life, whatsoever arising out of or connected with the use or misuse of our products.