

DESCRIPTION

The most versatile of all set-fast filler pastes, P-14 ULTRA FILLER 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. P-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. P-14 offers the industry manufacturer a wide variety of applications for bonding, filling, sealing and finishing with optimum physical properties. P-14 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. Its high quality, coupled with the set-fast feature offers industry substantial savings in time and labor plus top quality in the finished product. P 14 can be used in areas of final fabrication, production, tooling, model & pattern making, repair operations and in many other applications. **Typical applications include: filling composites surface porosity, honeycomb panel edge filler, bonding loose pieces and details, vacuum mold repair 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 impressions in pre-preg, non-conductive barrier potting, RIM/SMC/BMC surface filler, bonding inserts/hangers, urethane part repair, potting stripped threads, renewing worn surfaces and many others.**

PROPERTIES

- Very quick setting
- Comes in white and gray colors
- Dimensionally stable
- Excellent finishing and machinability
- Easy to use
- Good adhesion to several

PHYSICAL PROPERTIES				
	Units(s)	P-14	Cream Hardener	Mixed
Composition		Polyester Resin	BPO	Polyester paste
Mix ratio – by weight		100	2	100/2
Aspect		Grain free paste	Paste	Creamy paste
Color		White, Gray	White, Red, Black	White, Gray Pink
Density at 77°F (25°C)	lbs./gal (g/cc)			13.15 (1.58)
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.
- Carefully scrape the surfaces while blending to ensure complete mixing and uniformity.

MIXING INSTRUCTIONS

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. Mix 100 parts paste to 2 parts BPO cream hardener by weight; i.e. approximately the size of golf ball (paste) to a two inch strip of BPO catalyst. 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, the use of too much hardener can cause gumminess in the filler. After 15-20 minutes the filler may be filed or sanded to final finish.

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.
- Sand damaged area. A slightly rough texture will provide a good surface for the filler to bond properly.
- The mixed P-14 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 after 1 hour	ASTM D-2240	Shore D	86
Water absorption (%) 24 hr @ room temperature*	ASTM D-570	%	0.16
Heat Resistance*	N/A	°F (°C)	350/177
Adhesive pull strength	ASTM D-4541		
Polyester filler		Psi (Mpa)	1,717 (11.8)
Mahogany		Psi (Mpa)	1,459 (10.1)
Epoxy glass laminate		Psi (Mpa)	753 (5.2)
Aluminum		Psi (Mpa)	2,940 (20.3)

*Cure schedule: 7 days/77°F (25°C)

CHEMICAL RESISTANCE GUIDE

P-14 Ultra Filler 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.

TESTING 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 Good, Very Slight Attack Not Recommended

Benzene Acetic Acid (5%) Acetone
 Gasoline Citric Acid
 Methanol Hydrochloric Acid (10%)
 Mineral Spirits Nitric Acid (10%)
 Water (Distilled) Sodium Hydroxide (5%)
 Sulfuric Acid (10%)



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 additional information, please consult the safety data sheet (SDS).

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.

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