P-77

Technical Data Sheet
POLYESTER FILLER / FAIRING
Sandable, Styrene-Free, High Temperature

DESCRIPTION

P-77 polyester filler and fairing compound offers the user a smooth workable paste with a set-fast cure to expedite those applications for repair or finish. P-77 is easier to sand than conventional fillers and can be finished to a feather edge. This material has excellent adhesive and bond strength to fiberglass, SMC, FRP, epoxy, graphite, and Kevlar® composites as well as aluminum, wood, and other substrates. P-77 can be easily applied with a squeegee, spatula, or flat tool, and once cured will accept virtually all types of coatings and decorative films.

APPLICATIONS

- *Gel coat and blister repair*
- *Repair of damaged fiberglass parts*
- *Filling cloth imprint on FRP panels*
- *Edge filling on honeycomb panels*

PROPERTIES

- *Easy to apply – Easy to sand*
- *High heat-resistance of 400°F (209°C)*
- *Accepts virtually all types of finishes*
- *Low moisture absorption for above or below the waterline applications*
- *Minimal shrink or sink upon cure*
- *Bonds to epoxy, vinyl ester, polyester, and many subtrates*
- *Quick-set cure and finishing time*

PHYSICAL PROPERTIES				
	Units(s)	**P- 77 Resin**	**Cream Hardener**	**Mixed**
Composition		Polyester resin	BPO	Polyester paste
Mix ratio – by weight		100	2	100/2
Aspect		Grain free paste	Paste	Smooth creamy paste
Color		White	White	White
Viscosity – Brookfield (Sp. 7@ 5)	Cps.	550,000 – 800,000		550,000 – 800,000
Density at 77°F (25°C)	lbs./gal (g/cc)	13.3 (1.6)	10.0 (1.20)	13.2 (1.59)
Pot life (102 g) at 77°F (25°C)	minutes			9.0 – 11.0
Vertical sag	inches			<.05

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.*

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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-77 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	85 - 88
Adhesive pull strength to: Polyester Filler - Mahogany - Epoxy glass laminate -	ASTM D-4541	psi (MPa)	 400 (2.8) 540 (3.7) 430 (3.0)
Water absorption (%) 24 hr @ room temperature	ASTM D-570	%	0.08
Peak service temperature		°F (°C)	400 (204)
Sanding time		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.

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