

### DESCRIPTION

P-17 high heat resistant filler set-fast system has uses in aerospace, aircraft, automotive, tooling, manufacturing and final fabrication where potential exposure to elevated temperatures up to 230°C/446°F have to be tolerated either for short term or continuous periods. P-17 offers the user a smooth workable paste with set-fast cure to expedite those applications for repair or finish. P-17 can be applied with a squeegee, spatula or flat tool. The cured material can be finished by mechanical sanding, grinding, scraping, etc., to a feather edge. This filler has excellent adhesive and bond strength to fiberglass, SMC, BMC, RIM, FRP, epoxy, graphite and Kevlar<sup>®</sup> composites as well as aluminum, plaster and other substrates. P-17 high heat resistant filler when cured and finished accepts virtually all types of coatings and decorative film without any blush or discoloration. **Typical applications include: Aircraft interior panels, FRP panels-filling cloth imprint, nose cone porosity, edge filling on honeycomb, changes & repairs to vacuum form molds, drill fixtures, potting bushings, gel-coat repairs on production molds, SMC mold porosity in molded parts, and many other applications.**

### PROPERTIES

- Exceptional adhesion
- Very quick setting
- Minimal shrinkage
- High service temperature
- Comes in white,gray,black colors
- Excellent finishing and machinability
- Easy to use
- High gloss finish
- Low moisture absorption
- Excellent shelf life

### PHYSICAL PROPERTIES

		P-17	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,Black	White, Black, Red	White, Gray, Black, Pink
Density at 77°F (25°C)	lbs./gal (g/cc)			12.75 (1.53)
Pot life (102 g) at 77°F (25°C)	minutes			5.0 – 7.0

### 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. 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.*
- *The mixed P-17 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	80
Flexural strength	ASTM D-790	psi (MPa)	7,080 (49)
Tensile strength	ASTM D-638	psi (MPa)	4,074 (28)
Tensile elongation	ASTM D-638	%	1.16
Compressive strength	ASTM D-695	psi (MPa)	8,992 (62)
Linear shrinkage (cast bar)	ASTM C-531	inch/inch	0.00982
Coefficient of thermal expansion (CTE)	ASTM D-696	10 <sup>-6</sup> .°F <sup>-1</sup> (°C)	24.5 (44)
Water absorption (%) 24 hr @ room temperature	ASTM D-570	%	.149

\*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 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.*