

PRODUCT DATA SHEET

# SikaBiresin® AP539 (Formerly P-39)

Fiberglass-Filled Polyester Filler and Marine Radius Putty

**TYPICAL PHYSICAL PROPERTIES (FOR FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaBiresin® AP539 (A) Resin	MEKP Liquid Hardener (B)
Composition	Polyester	Methyl Ethyl Ketone Peroxide (MEKP)
Mix ratio by weight	100	2
Aspect	Thixotropic paste	Liquid paste
Color	Neutral	Clear
Color (mixed)	Neutral	
Density at 77°F (25°C) (mixed)	10.6 lbs./gal (1.27 g/cc)	
Pot life (102g) at 77°F (25°C)	20.0 – 30.0 Minutes	

**DESCRIPTION**

SikaBiresin® AP539 is a fiberglass-filled, polyester-based, industrial filler paste. It is specifically formulated for use as a marine radius putty/filler applied behind the gelcoat after it has been applied to the mold. As a marine radius putty, SikaBiresin® AP539 fills in details and bridges the areas where imperfections have occurred in the gelcoat.

**PRODUCT BENEFITS**

- Bonds well to a wide range of substrates
- Low exotherm
- Long working time
- Fiberglass-filled for increased strength
- Minimal shrinkage

**AREAS OF APPLICATION**

SikaBiresin® AP539 is suitable for use as a marine radius putty material. It can also be used as a high strength bond and fill system in a wide range of industries for FRP composites to FRP, wood to wood, and wood to FRP applications.

Tests with actual materials and conditions have to be performed to ensure satisfactory performance.

## TYPICAL MECHANICAL AND THERMAL PROPERTIES

Properties, Test Method	SikaBiresin® AP539 (A) Resin	MEKP Liquid Hardener (B)
Hardness, Shore D ASTM D2240	79	
Flexural strength, ASTM D790	5,519 psi (39 Mpa)	
Tensile strength, ASTM D638	4,129 psi (29 Mpa)	
Tensile Elongation, ASTM D638	4.0 %	
Compressive Strength, ASTM D695	9,288 psi (64 Mpa)	
Water absorption - 24 hr @ RT, ASTM D570	1.02 %	
Heat Deflection Temperature @ 66 psi, ASTM D648	131 (55) °F (°C)	
Heat Deflection Temperature @ 264 psi, ASTM D648	101 (38) °F (°C)	

Cure schedule: 7 Days at 77°F (25°C)

### PROCESSING

#### Surface Preparation and Application

To ensure optimal adhesion, the area to be filled or repaired should be thoroughly cleaned, sanded/roughened, re-cleaned, and allowed to dry prior to application.

#### Mixing Instructions

Stir contents of resin can thoroughly using a spatula or putty knife. Place the required amount of filler and hardener on a disposable clean surface. Mix 100 parts paste to 2 parts cream hardener by weight. Set up time of mix at room temperature will be 10-20 minutes

#### Application

The mixed SikaBiresin® AP539 should be applied and worked into the area, taking caution to avoid air entrapment. After curing to a tack-free state, the material can be sanded and finished as needed.

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

- Ensure adequate ventilation
- Wear gloves, glasses, and protective clothes

For further information, please consult the Safety Data Sheets

#### STORAGE CONDITIONS

Product shelf life of SikaBiresin® AP539 (A) is 12 months when stored in original unopened containers between 65 – 77°F (15 – 25°C).

Shelf life of MEKP Liquid Hardener (B) is

12 months when stored in original unopened containers between 65 – 77°F (15 – 25°C).

Keep containers tightly closed. Polyester resin contains filler which has the potential to separate in time, please re-homogenize prior to use.

#### PACKAGING INFORMATION

Packaging information is available upon request. Please contact your local Sika sales representative.

#### FURTHER INFORMATION

Advice on specific applications will be given on request. To contact Sika Corporation's Industry Technical Services Department, send an email to [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Copies of Safety Data Sheets and Product Data Sheets are available upon request.

#### BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

#### ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International

3-527-3887.

#### LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product. SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.