

TECHNICAL DATA SHEET

APF 6

POLYESTER FILLER
STYRENE FREE

DESCRIPTION

APF 6 Orange is a quick setting industrial use filler paste. It has been specifically formulated for the repair of nicks, cracks, holes, or gouges in the surface of production FRP molds. This product has a very smooth, creamy consistency that allows the user to make fast, long lasting repairs with minimal air entrapment. APF 6 Orange is also highly chemical resistant and can be used in temperatures up to 400°F / 204°C. Best of all, APF 6 Orange is a low odor product and contains no styrene. Common uses include repairing FRP molds, pattern repairs, high temperature repair of vacuum molds, plastic mold repairs, model filler, and cultured marble repairs.

PROPERTIES

- Exceptional adhesion
- Quick setting
- Excellent finishing / machinability
- Easy to use
- Minimal shrinkage
- Chemical resistant

PHYSICAL PROPERTIES

	Units	APF 6	Cream Hardener	Mixed
Composition		Polyester resin	BPO	Polyester paste
Mix ratio – by weight		100	2	100/2
Aspect		Thixotropic paste	Paste	Thixotropic paste
Color	Visual	Orange	White, Black, Red	Varies
Density at 77°F (25°C)	lbs./gal (g/cc)	12.5 (1.50)	10.0 (1.2)	12.4 (1.49)
Pot life (100g) at 77°F (25°C)	Minutes			13.0 – 18.0
Volumetric weight	lbs/in ³ (g/cc)			0.054 (1.49)

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.

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 APF 6 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

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 10-20 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 20-25 minutes the filler may be filed or sanded to final finish.

MECHANICAL AND THERMAL PROPERTIES - Cure schedule: 7 days/77°F (25°C)			
Property	Test Method	Units(s)	Test Results
Hardness	ASTM D2240	Shore D	88 - 90
Flexural strength	ASTM D790	psi (MPa)	6,300 (23)
Tensile strength	ASTM D638	psi (MPa)	3,300 (23)
Compressive strength	ASTM D-695	psi (MPa)	10,600 (73)
Tg per TMA	ASTM E-1545	°F (°C)	150 (66)
Peak service temperature		°F (°C)	400 (204)

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, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

Packaging

Packaging information on request, please contact your local sales representative or find your local contact on www.sikaadvancedresins.us

CONTACT

UNITED STATES

Sika Corporation

30800 Stephenson Highway
Madison Heights, Michigan 48071 – USA
Tel.: (+1) 248 588-2270
Fax: (+1) 248 577-0810
E-mail: axsonmh@axson.com
Website: www.sikaadvancedresins.us

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