

TECHNICAL DATA SHEET

P-12

POLYESTER PATTERN AND MODEL FILLER CARVABLE PINE

DESCRIPTION

P-12 PATTERN AND MODEL CARVABLE FILLER is a system which offers the craftsman the capability of forming, shaping and working the cured filler to precise and accurate trade applications without dulling or damage to tools. P-12 PATTERN AND MODEL CARVABLE FILLER is non directional and resists chipping and cracking when cured. P-12 readily bonds to all types of wood and can be finished to a feather edge by sanding, carving, machining or scraping. P-12 has excellent mixing and handling qualities. The set-fast characteristics offer savings on time and labor. Typical applications include: core box repairs, pattern build up, rebuild broken areas, prototypes, cope and drag changes, design engineer changes, fillets & radius areas and other pattern, figure, model and tooling applications.

PROPERTIES

- Exceptional adhesion to wood
- Excellent sanding / machinability
- Very quick setting
- East to use

PHYSICAL PROPERTIES

	Units	P-14	Cream Hardener	Mixed
Composition		Polyester resin	BPO	Polyester paste
Mix ratio – by weight		100	2	100/2
Aspect		Thixotropic paste	Paste	Workable paste
Color	Visual	Pine	White, Black, Red	Varies
Density at 77°F (25°C)	lbs./gal (g/cc)		10.0 (1.2)	8.01 (.96)
Working time (100g) at 77°F (25°C)	Minutes			4.0 – 6.0
Finish schedule	Minutes			20 - 25
Hardness	Shore D			60

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 20-25 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-12 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.
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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.

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.

PACKAGING

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

CONTACT

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