BUILDING TRUST

TECHNICAL DATA SHEET

P-17 SMCR

POLYESTER FILLER
STYRENE FREE, HIGH TEMPERATURE, SANDABLE

DESCRIPTION

P-17 SMCR 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 400°F (204°C) have to be tolerated either for short term or continuous periods. P-17 SMCR was developed to more closely match the sandability and hardness of SMC. P-17 SMCR offers the user a smooth workable paste with set-fast cure to expedite those applications for repair or finish. P-17 SMCR can be applied with a squeegee, spatula or flat tool. The cured material can be easily sanded to a feather edge by hand or with mechanical sander. This filler has excellent adhesive and bond strength to fiberglass, SMC, BMC, RIM, FRP, epoxy, graphite and Kevlar composites as well as aluminum, plaster and other substrates. P-17 SMCR HIGH HEAT RESISTANT FILLER when cured and finished accepts virtually all types of coatings and decorative films without any blush or discoloration. Typical applications include: aircraft interior panels, vacuum form molds, changes & repairs, FRP panels-filling cloth imprint, Drill fixtures, potting bushings, nose cone porosity, gel-coat repairs on production molds, edge filling on honeycomb, SMC mold porosity in molded parts, repair of damaged SMC parts and many other applications*

PROPERTIES

- *Exceptional adhesion*
- *High service temperature*
- *Comes in white and black colors*
- *Sandability matches SMC*
- *Sands to a feather edge*
- *Minimal shrinkage*
- *Low moisture absorption*
- *Excellent shelf life*

PHYSICAL PROPERTIES

	Units	P-17 SMCR	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	Visual	White, Black	White, Black, Red	Varies
Density at 77°F (25°C)	lbs./gal (g/cc)		10.0 (1.20)	13.10 (1.57)
Work life (100g) at 77°F (25°C)	Minutes			7.0 – 10.0
Finish schedule	Minutes			15
Hardness after 1 hour	Shore D			88

NOTE: All high heat resistant systems typically exhibit a slight color change at the extreme end of the elevated temperature range when used in tooling repairs

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 7-12 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 SMCR 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.

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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