



**P-17
HIGH HEAT RESISTANT
RIGID FILLER
GRAY, BLACK, WHITE**



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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 446°F (230°C) 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® 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.**

TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C)

Mix Ratio (parts by weight or volume)	100R/2H
Mixed Consistency	Creamy Paste
Specific Gravity	1.59g/cc
Work Life (100 gram mass)	5-7 minutes
Finish Schedule (100 gram mass)	15 minutes
Hardness	80 Shore D
Shelf Life (in original unopened containers)	1 Year
Storage Requirement.....	40°F - 80°F (4°C-27°C)

TYPICAL PHYSICAL PROPERTIES

Tensile Strength (ASTM D-638.91)	4074psi (28MPa)
Tensile Elongation (ASTM D-638.91)	1.2%
Flexural Strength (ASTM D-790.92).....	7080psi (49MPa)
Compressive Strength (ASTM D-695.91)	8992psi (62MPa)
Shrinkage (Cast Bar)(ASTM D-2566.86).....	0.00982 in/in
Coefficient of Linear Thermal Expansion (TMA) (ppm/°F (°C))	25 (46)
Water Absorption after 24 hours immersion in distilled water (ASTM D-570)	0.149%

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.

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.

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