



**P-18
PATTERN & MODEL
FILLER**
SEMI-RIGID, MACHINABLE
MAHOGANY

PRODUCT BULLETIN



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DESCRIPTION

P-18 PATTERN & MODEL FILLER is a two component set-fast system ideal for numerous and varied applications which require a dimensionally stable filler. P-18 PATTERN & MODEL FILLER has easy mixing and handling properties and also exhibits good vertical hang-up. P-18 cures to a hard surface with minimal shrinkage and porosity. It has excellent bonding characteristics to wood, aluminum, fiberglass, plaster and many other substrates. Once finished it offers a hard, durable and permanent surface. P-18 is a safe system for use in the work place and provides the user complete satisfaction in day-to-day tooling and pattern applications. **Typical applications include: fillets and radius areas, pattern and core box repairs, potting inserts and drill bushings, minor alterations and changes, holding fixtures, bonding and sealing, keller aids, squash molds, surface repairs to molds and many other applications where a strong permanent filler is required.**

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio with BPO Cream Hardener (parts by weight and volume).....	100R/2H
Mixed Viscosity	Smooth Non-Sag Paste
Density.....	14.1 lbs/gal
.....	1.69 gms/cc
Work Life (100 gram mass)	4-6 minutes
Finish Schedule.....	15 minutes
Resin Color Choices	Mahogany
BPO Cream Hardener Color Options.....	White/Red/Black
Hardness	80 Shore D
Shelf Life (in original unopened containers).....	1 year
Storage Requirement.....	40°F - 80°F

P-18 Tech/Revised 7/30/10
Supercedes 1/25/10

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