



P-49 HIGH HEAT RESISTANT FILLER

PRODUCT BULLETIN



RIGID

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DESCRIPTION

P-49 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 200°C/390°F have to be tolerated either for short term or continuous periods. P-49 offers the user a smooth workable paste with set-fast cure to expedite those applications for repair or finish. P-49 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-49 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, FRP panels filling cloth imprinting, nose cone porosity, edge filling on honeycomb, vacuum form molds, changes and repairs, drill fixtures, potting bushings, gel-coat repairs on production molds, SMC mold porosity in molded parts and many other applications.**

HANDLING CHARACTERISTICS @ 25°C/77°F

| | |
|---|----------------------|
| Mix Ratio w/BPO Cream Hardener (parts by weight)..... | 100R/2H |
| Mixed Viscosity | Thick Paste |
| Mixed Consistency | Smooth, creamy paste |
| Work Life (100 gram mass) | 10-15 minutes |
| Finish Schedule | 20 minutes |
| Shelf Life (in original unopened container) | 1 year |
| Storage Requirement..... | 40°F - 80°F |

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

1. 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.
2. Mix ratio: 100 parts paste to 2 parts cream hardener by weight, i.e. size of golf ball (paste) to a two inch strip of catalyst.
3. 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.

CAUTION: THE USE OF TOO MUCH HARDENER CAN CAUSE GUMMINESS IN THE FILLER.

4. After 15-20 minutes the filler may be filed or sanded to final finish.

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