



## COMPOSITE SURFACE REPAIR PROCEDURE

INSTRUCTIONS FOR USING  
P-17 SMCR, P-17, P-77

APPLICATION GUIDE

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### COMPOSITE SURFACE REPAIR PROCEDURE – USING ADTECH P-17, P-17 SMCR AND P-77

1. Feather sand damaged area with 320-grit sandpaper to improve adhesion of repair material to substrate.  
  
Note: For a chip, gouge or crack, use a die grinder with a cone shaped bit to form a dished out 'U' groove in the substrate along the defect. Taper sand the sides of the groove in the substrate along the defect. This will relieve sharp angled stress concentrations (most important when paint coatings require high-temp oven cures) and improve adhesion of the filler material to the substrate.
2. Blow off sanding dust with a high velocity air stream. **Do not clean off sanding dust with solvent. Cleaning with solvent will contaminate the bonding surface.**
3. Mix two part polyester filler material (Adtech P-17 SMCR White/Black BPO). Mix ratio for polyester resin to BPO hardener is 100R:2H parts-by-weight.
4. Sparingly apply filler material to defect with a putty knife or spatula. The filler has a working time of 4-6 minutes and will cure in 15-20 minutes. It is not recommended to use heat guns or lamps to promote cure.
5. When the filler has cured, sand filled area flush with 320-grit sandpaper working to blend from the outside surface to the center of the defect.
6. Blow off sanding dust with a high velocity air stream.
7. Tack off area.
8. For best results, repeat steps 4-8 applying filler (Adtech P-17 SMCR) for a second time. Filler material will contract upon cure in deeper repairs, leaving a slight depression. Therefore, a second application of filler material is usually required.
9. Mix Adtech P-17 SMCR White/ Black BPO as described in Step #4. Mix ratio to BPO Hardener is 100R:2H parts by weight. Using a flexible spatula, sparingly apply mixture in a very thin layer (almost transparent) over the filled area. The material cure time is 15-20 minutes at room temperature. (This glazing application is recommended to replace SMC spot and glaze putty P-28 or P-29. P-17 SMCR is less affected by humidity and will withstand higher temperatures than glazing putty, while also sealing the repair.
10. Hand sand area with 400-grit sandpaper.
11. Blow off sanding dust with a high velocity air stream. **Do not clean off sanding dust with solvent.**
12. Mask off area.
13. Spot prime area with approved primer/sealer.
14. Sand primer with 1,200-grit sandpaper.
15. Top coat as required.

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