



**P-77
HIGH HEAT
FILLER/FAIRING
COMPOUND
SANDABLE**

PRODUCT BULLETIN



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DESCRIPTION

P-77 polyester filler and fairing compound offers the user a smooth workable paste with a set-fast cure to expedite those applications for repair or finish. P-77 is easier to sand than conventional fillers and can be finished to a feather edge. This material has excellent adhesive and bond strength to fiberglass, SMC, FRP, epoxy, graphite, and Kevlar® composites as well as aluminum, wood, and other substrates. P-77 can be easily applied with a squeegee, spatula, or flat tool, and once cured will accept virtually all types of coatings and decorative films.

USES

- Gel coat and blister repair
- Repair of damaged fiberglass parts
- Filling cloth imprint on FRP panels
- Edge filling on honeycomb panels

BENEFITS

- Easy to apply – Easy to sand
- High heat-resistance of 446°F (230°C)
- Accepts virtually all types of finishes
- Low Moisture absorption for above or below the waterline applications
- No shrink or sink upon cure
- Bonds to Epoxy
- Quick-set cure and finishing time

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

Mix Ratio with BPO Paste (parts by volume).....	100R/2H
Mixed Viscosity.....	Smooth Creamy paste
Specific Gravity	1.58 g/cc
Work Life (50 gram mass)	9-11 minutes
Finish Schedule	15-20 minutes
Color.....	White
Shelf Life (in original unopened containers)	1 year
Storage Requirement	40°F-80°F (4°C-27°C)

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APPLICATION INSTRUCTIONS:

- For best results, clean damaged areas thoroughly and remove any surface contaminants such as paint, oil, wax, dirt, etc.
- Allow surface to dry completely. Damp or wet surfaces can inhibit the bonding strength and curing of the filler paste.
- Sand damaged area. A slightly rough texture will provide a good surface for the filler to bond properly.
- 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 resin paste to 2 parts cream hardener by volume(i.e. size of golf ball paste to a two-inch strip of cream hardener).
- Setup 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: TOO MUCH HARDENER CAN CAUSE GUMMINESS IN THE FILLER

- **After 15-20 minutes the filler may be filed or sanded to a final finish**

Typical Material Properties	Test Method	Test Value
% Water Absorbed	ASTM D-570	0.08%
Heat Resistance	N/A	446°F (230°C)
Hardness	ASTM D-2240	85-88 Shore D
Adhesive Pull Strength	Test Method	Test Value
Polyester Filler	ASTM D-4541	400psi (3MPa)
Mahogany	ASTM D-4541	540psi (4MPa)
Epoxy Glass Laminate	ASTM D-4541	430psi (3MPa)

Typical properties are only provided as a general guideline and are not to be construed as specification.

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