



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

PRODUCT BULLETIN



**www.axson-technologies.com
31200 Stephenson Hwy**

**800.344.7776
Madison Heights, MI 48071**

**axsonmh@axson.com
Ph 248.588.2270 Fax 248.588.5909**

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)

Continued on next page

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.

P-77 Tech/Revised 1/26/15
Supersedes 6/17/14

The information contained in this technical data sheet results from research and tests conducted in our laboratories under precise conditions. Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. It is the responsibility of the user to determine the suitability of the Axson Technologies' products, under their own conditions, before commencing with the proposed application. In no event shall Axson Technologies, Inc. be liable for any direct, indirect, punitive, incidental, special, and/or consequential damages, to property or life, whatsoever arising out of or connected with the use or misuse of our products.

AXSON TECHNOLOGIES US +1 249 588 2270 axsonmh@axson.com axson-na.com	CHINA +86 21 58 68 30 37 marketing.china@axson.com	GERMANY +49 6 07 44 07 11-0 verkauf@axson.com	INDIA +91 20 25 56 07 10-11 info.india@axson.com	ITALY +39 02 96 70 23 36 axson@axson.it	JAPAN +81 5 64 26 25 91 sales.japan@axson.com	FRANCE Global Headquarters +33 1 34 40 34 60 axson@axson.com axson-technologies.com
	MEXICO +52 55 52 64 49 22 marketing@axson.com.mx	MIDDLE EAST +971 7 2432227 axsonmideast@axson.com	SLOVAKIA +42 1 76 42 25 26 axson.sk@axson.com	SPAIN +34 9 32 25 16 20 spain@axson.com	U.K. +44 16 38 66 00 62 sales.uk@axson.com	