APF 7

Technical Data Sheet

Polyester Filler

400° F (204° C) Service Temperature, Styrene-Free Filler

Description

APF 7 is a quick setting industrial use filler paste. It is specifically formulated for use in the aircraft, aerospace, and other industries that perform manufacturing and repair work on items requiring above normal temperature ranges. The service temperature for APF 7 is up to 400°F (204°C). APF 7 is both chemical and water resistant, and may be used in underwater applications. Applications of APF 7 are both fast and permanent. Excellent machining and finishing results are achieved by grinding, sanding, scraping, etc. When exposed to elevated temperatures APF 7 has a tendency to darken, however it does not gas, bubble, or cause any finish distortion. This product does not contain wax and bonds readily to itself or other substrates such as FRP/SMC, high temperature epoxy molds, aluminum, steel, cast iron, urethane foam parts, and others. APF 7 is non-metallic, non-conductive, and non-sparking. It contains no styrene and is low odor.

Properties

- *Exceptional adhesion*
- *Very quick setting*
- *Minimal shrinkage*
- *Excellent finishing and machinability*
- *Easy to use*
- *High gloss finish*

PHYSICAL PROPERTIES				
		APF 7	**Cream Hardener**	**Mixed**
Composition		Polyester Resin	BPO	
Mix ratio – by weight		100	2	
Aspect		Thixotropic paste	Thixotropic paste	Thixotropic paste
Color		Gray, Black, White	White, Black, Red	Varies
Density at 77°F (25°C)	lbs./gal (g/cc)	14.17 (1.70)	10.0 (1.20)	14.11 (1.69)
Pot life (100 g) at 77°F (25°C)	minutes			4 – 7
Volumetric weight	lbs/in^3 (g/cc)			0.061 (1.69)

Processing Conditions

- *Thoroughly blend 100 parts resin with 2 parts hardener by weight for 1 to 1 ½ minutes in a clean dry container or on a clean dry surface.*
- *Carefully scrape the surfaces while blending to ensure complete mixing and uniformity.*

Surface Preparation and Application

- *The area to be filled or repaired should be thoroughly cleaned, roughened, cleaned again and allowed to dry prior to application to ensure the best possible adhesion.*
- *The mixed APF 7 should be buttered into the area, avoiding trapping air during application.*
- *After curing to a tack-free state, the material can be sanded and finished as needed.*

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MECHANICAL AND THERMAL PROPERTIES			
Hardness	ASTM D-2240	Shore D	88 – 90
Tg	ASTM E-1545	°F (°C)	150 (66)
Tensile strength	ASTM D-638	psi (MPa)	3,150 (22)
Flexural strength	ASTM D-790	psi (MPa)	6,280 (43)
Compressive strength	ASTM D-695	psi (MPa)	9,870 (68)
Peak service temperature		°F (°C)	400 (204)

Storage Conditions

- *Product is guaranteed for 12 months when stored in original unopened containers between 59 – 77°F (15 – 25°C). Any opened can must be tightly closed.*

Handling Precautions

Normal health and safety precautions should be observed when handling these products :

- *Ensure good ventilation*
- *Wear gloves, and safety glasses.*

For further information, please consult the material safety data sheet.

Guarantee

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications

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