



39542 CARBO-FILL

TECHNICAL DATA SHEET

Description

39542 CARBO-FILL is a carbon fiber enriched formula that offers exceptional cosmetic and structural repair for SMC, FRP, HPA and PPO/PA. **39542** eliminates the risk of swelling the substrate, which is typically viewed as a “bull’s eye” or “halo” by providing the same expansion and contraction characteristics as the original substrate.

Features

- Carbon fiber enriched
- Superior strength and durability
- Prevents swelling
- Resists staining and shrinkage
- Easy to sand
- Quick cure time – sand in only 10-15 minutes

Typical Properties

Container	2.75 lbs.
Color without hardener	Greenish gray
Viscosity	350,000-390,000 cps.
Density	10.40-10.46 #/g1 (1248-1255 g/l)
Exotherm temperature	190°F (88°C) @ 20 grams
Peak exotherm time	4-5 minutes @ 20 grams
Gel time	3-5 minutes @ 100 grams
Set time	5-10 minutes
Cure time	10-15 minutes
Shore D hardness	10 minutes: 70 20 minutes: 75 30 minutes: 80 60 minutes: 82 24 hours: 84

Handling and Application

PREPARATION:



Clean first with **39362 SEM SOAP** and rinse with water. Next clean with **3835() PLASTIC/LEATHER PREP**. **NOTE:** Use caution during cleaning process not to saturate exposed fibers with water or solvent. Sand with 80 grit 2-3 inches around damaged area. “V” groove area and create bevel with 36 or 40 grit disc. Make a gradual taper, 1 ½” wide leaving no sharp edges. Blow off to remove dust and clean again with **3835() PLASTIC/LEATHER PREP**. Large holes should be reinforced with **70006 SEM REINFORCING TAPE** or a backer panel made from scrap SMC, fiberglass or similar plastic. Cut and fit scrap material to be used as a backer panel. Make certain the original contour of the panel being repaired is followed as closely as possible. Bond with **39542, 39337 DOOR SKIN & SMC ADHESIVE** or **4050() QUICK SET 50**. **39337 or 4050() MUST BE USED FOR STRUCTURAL REPAIRS.**

MIXING:



Stir contents of can thoroughly before each use. Mix a 1' ribbon of cream hardener with a golf ball size quantity of **39542**. **DO NOT OVERCATALYZE OR MIX MORE THAN CAN BE USED IN 3-5 MINUTES**. Mix to a uniform color.

APPLICATION:



Apply a sufficient amount of **39542** to fill the repair area. Spread mixture with a putty knife or spreader. Press firmly into area to eliminate air pockets. Apply higher than surrounding surface to allow for sanding. After the **39542** has set 10-15 minutes, sand with 80 grit paper then finish with 180 grit prime. For slight imperfections, reapply a skin coat of **39542**. To fill sand scratches and prepare surface for painting, apply **3913() FLEXIBLE PRIMER SURFACER**, **39624 WORLD CLASS FLEXIBLE PRIMER SURFACER** or **420()3 HIGH BUILD PRIMER SURFACER**, as per directions. After the priming and sanding have been completed, apply the paint system of choice.

STORAGE:



39542 should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **39542** is 2 years when stored under normal conditions.

TECHNICAL CONSULTATION SERVICE

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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Users should review the Material Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and product label are available upon request.

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