Lightweight Body Filler

05800 • 05801 • 05804 • 05805

Technical Data Sheet **July, 2014**

3M Part No.(s)	3M Part Descriptor(s)
05800	3M™ Lightweight Body Filler - One quart - 25.6 fl oz, 757ml
05801	3M™ Lightweight Body Filler - One gallon - 102 fl oz, 3.0L, 0.80 US gal.
05804	3M™ Lightweight Body Filler - Five gallon air dispensed - 3.75 gallons, 14.2L
05805	3M™ Lightweight Body Filler - Five gallon mechanical dispensed - 3.75 gallons, 14.2L

Product Description

3M™ Light weight body filler is a two component material that is vacuum processed to create a smooth texture. 3M™ Lightweight body filler cures tack free in 20 minutes with good sanding and handling characteristics.

Features

- Easy spreading & mixing
- Tack free resin
- Vacuum processed

Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	Part A - Filler	Part B - Creme Hardener
Container	PN 05800 - One quart metal can PN 05801 - One gallon metal can PN 05804 - Five gallon metal can (Air Pail) PN 05805 - Five gallon metal can (Mechanical Pail)	1.0 oz. plastic tube 2.75 oz. plastic tube
Base	Polyester resin with styrene monomer	Benzoyl Peroxide
Density	9.2 lb/gal	10.0 lb/gal
Color	Gray	Blue
Flash Point	89°F / 32°C	N/A
Viscosity @ 77°F (25°C) - Brookfield Viscometer	192,000 - 244,000 cps	70,000 - 150,000 cps

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Product Uses

Two component polyester compound used to fill dents, dings, gouges and other cosmetic imperfections on bare steel, aluminum, and fiberglass reinforced polyester (FRP). May also be used on many industrial and architectural surfaces needing minor repairs.

Typical Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 77°F (25°C) and are considered typical values.

SHAPE SAND TIME:
8 to 12 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

FINISH SAND TIME:
20 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

RECOMMENDED APPLICATION TEMPERATURE:
Above 45°F (7°C)

SERVICE TEMPERATURE:
Min. -20°F (-29°C) Max. 180°F (82°C)

MINIMUM HARDENER:
1.5%

MAXIMUM HARDENER:
2.75%

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Lap Shear, Steel to Steel:	1,430 psi	ASTM D1002
Lap Shear, Aluminum to Aluminum:	1,320 psi	ASTM D1002
Tensile Strength:	1,600 psi	ASTM D638
Shore D hardness @ 24 hrs:	70	ASTM D2240
Flexural Strength:	2,260 psi	ASTM D790 Procedure A
Shrinkage:	0.72%	LTM 855.0084

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Directions for Use

1. Clean the repair area using soap and water followed by a wax & grease remover/surface cleaner. Sand the surface as needed with grade P40 to P80 3M™ abrasive.

   Note: If grinding is required use a grade 50 3M™ grinding disc, blow off the sanding dust with clean dry air. When repairing galvanized steel, e-coat, primed/painted surfaces or aluminum, sand with grade P80 3M™ abrasive to remove the paint/primer. Blow off with clean dry compressed air and re-clean the surface using a clean paper or cloth towel and a wax & grease remover/surface cleaner.

2. Apply the required amount of body filler to a clean mixing surface. (Do not use discarded cardboard as a mixing surface as contamination may occur.) The correct hardener to filler ratio = 3 inch diameter circle 1/2 inch thick of filler to a 3 inch strip of cream hardener.

3. Mix the body filler and cream hardener thoroughly, to a uniform color. Gel time/setting time is approximately 3-5 minutes @ 75°F (24°C) using 2% hardener as prescribed. Spread the filler on the mixing board, being sure to break any air bubbles that were introduced during mixing.

4. Apply a thin layer using firm pressure to ensure maximum adhesion being sure to "wet out" the surface completely. Apply additional filler in layers, building up the damaged area higher than the surrounding surface. Maximum filler thickness should not exceed 1/4 inch. Allow curing time of 20 minutes.

5. Sand the filler to the proper contour with 3M™ abrasives, using the following recommended grade sequence: P40, P80, P180. **Note:** If more filler is needed blow off with clean dry compressed air and follow steps 2 through 6.

6. Wait approximately 45 minutes before applying primer and paint, always follow your paint company's recommended procedures.

Applications

Repair of cosmetic surface imperfections in properly prepared auto body, industrial, and architectural substrates.

Storage and Handling

HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

STORAGE

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 16 months from the date of manufacture. Store in a dry area at 65-80°F (18-27°C) for optimal shelf life.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. See link below:

http://solutions.3m.com/wps/portal/3M/en_US/MSDS/Search/?gsaAction=msdsSRA&msdsLocate=en_US

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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