

3M

Dent Finishing Glaze

05857

Technical Data Sheet

February, 2011

3M Part No.(s)	3M Part Descriptor(s)
05857	3M™ Dent Finishing Glaze

Product Description 3M™ Dent Finishing Glaze (PN 05857) is intended to be used as an auto body repair material. This polyester finishing glaze is capable of repairing minor imperfections such as scratches, gouges, pinholes, and low areas. It may be applied on properly prepared polyester body filler, steel, aluminum, SMC, fiberglass and cured automotive paint surfaces. 3M™ Dent Finishing Glaze (PN 05857) may also be used for industrial and architectural surfaces needing minor surface repairs.

- Features**
- 300ml Dual Cartridge System
 - 50:1 mix ratio
 - Dynamic Mixing

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	Two Part Cartridge - (300ml)	Two Part Cartridge - (6ml)
Base	Polyester Resin with Styrene Monomer	Benzoyl Peroxide
Density lbs/Gallon (Appx.)	7.8 lbs/gallon	10 lbs/gallon
Color	Beige	Blue
Viscosity (CPS) Brookfield Viscometer	17,600 - 25,600 cps	70,000 - 150,000 cps
Consistency	Viscous liquid	Viscous paste
Service Temperature	Min. -20°F (-29°C) Max. 180°F (82°C)	N/A
Application Temperature	Min. 55°F (13°C) Max. 110°F (43°C)	N/A

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**Use with the following applicator: PN 05846 (pneumatic).
3M™ Mix Nozzle PN 05847 (50/box).**

Typical Performance Properties The following times have been determined with ambient air temperature and substrate temperature @ 72°F (22°C) and are considered typical values.

WORK TIME:
2 to 3 minutes

SANDING TIME:
10 to 12 minutes

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Lap Shear, Steel to Steel:	2,050 psi	ASTM D1002
Lap Shear, Aluminum to Aluminum:	740 psi	ASTM D1002
Tensile Strength:	2,050 psi	ASTM D638-82
Shore D Hardness @ 24 hrs:	55	ASTM D2240

Directions for Use **SURFACE PREPARATION:**
Use appropriate 3M VOC compliant product(s) for adhesive removal, degreasing, cleaning or removal of surface contaminants. Sand the area with grade 80 - 180 grit abrasive, and blow off with clean dry compressed air.

PRODUCT PREPARATION:
INSTALLING THE CARTRIDGE

- Position large diameter cylinder in the up (12 o'clock) position.
- Place the mounting flange end of the cartridge against the mounting plate of the dispenser, making sure to align and insert the cartridge drive rod with the dispenser drive socket, located in the center of the dispenser mounting plate.
- Press the cartridge back against the mounting plate (this should occur without resistance if drive rod is aligned properly) and twist until the cartridge locks into place.

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Directions for Use (continued)

INSTALLING THE NOZZLE

- Remove sealing cap from cartridge.
- Align the 3M™ Dynamic Mixing Nozzle with the cartridge outlets, making sure to position the large outlet (cartridge) with the large inlet (nozzle) and the small outlet (cartridge) with the small inlet (nozzle).
- Press in until locking retainer engages mixing nozzle.

EQUALIZING THE CARTRIDGE

- Attach an air line to the dispenser inlet.
- Using proper air pressure settings (see directions for use included with the 3M™ Dynamic Mixing Gun) and a disposable collection point, depress the trigger until both sides of the dual-component material are present and the material is a consistent light blue/green color. This serves to “equalize” both sides of the cartridge.

GENERAL REPAIR PROCESS:

DISPENSING TECHNIQUES

- Material may be dispensed directly onto the damaged area, or onto a non-porous surface, such as a spreader or a mixing board.
- Immersing the nozzle in the puddle of material eliminates any air entrapment during dispensing.
- Proceed with application method (ie spreading) as desired.
- You may continue to dispense material until the normal material curing process clogs the mixing nozzle – typically after 2-3 minutes without depressing the trigger. If more repair material is desired after curing has occurred, remove and install a new nozzle.
- Maximum finished thickness should not exceed 1/8 inch.

CAUTION: Be sure to replace nozzles containing fully or semi cured material to prevent damage to cartridge or nozzle or personal injury. Dispose of uncured material in an approved receptacle.

APPLICATION WARNINGS:

- If applying to an unfamiliar substrate, perform a test to determine if suitable results are obtained. Do not apply on uncured paint surfaces.
- Be sure surface contaminants are removed prior to application.

CLEAN-UP:

- Use an approved solvent to remove excess unwanted material from tools or surrounding areas prior to the expiration of work time (2-3 minutes).

Applications

See “ Product Uses “ above.

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Storage and Handling

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months from the date of manufacture. Store unopened cartridges in an approved area, and prevent exposure to flame, sparks, or high temperatures. Store previously opened cartridges with the used nozzle in place in an approved area and prevent exposure to flame, sparks, or high temperatures. Use caution

not to damage outlets or drive shaft during storage or installation. Optimum storage temperatures are 65-80° F (18-27°C), elevated storage temperatures reduce product shelf life.

After use, leave mix nozzle in place to seal the cartridge.

Precautionary Information

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

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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For Additional Health and Safety Information



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