

3M™ Golden Extra Filler

Data Sheet

3M Part No.(s)	3M Part Descriptor(s)
01127	3M Golden Extra Filler - Quart
01177	3M Golden Extra Filler - Gallon
01277	3M Golden Extra Filler -Three Gallon Cartridge
01317	3M Golden Extra Filler - Five Gallon pail

Detailed Product Description

Golden Extra is a creamy, easy to apply filler that provides a tack-free surface in minutes over steel, Aluminum, fiberglass and wood. The Rich golden color of this product makes it stand out from the rest.

Features, Advantages, Benefits

Features	Vacuum processed to remove entrapped air Tack-free
Advantages	Creamy formula Resists abrasive loading
Benefits	Outstanding results Reduces abrasive usage

Typical Physical Properties

	Part A - Filler	Part B - Creme Hardener
Container	Various containers	2.75 oz. plastic tube
Base	Polyester resin with styrene monomer	Benzoyl Peroxide
Density	9.30 lb/gal	10.0 lb/gal
Color	Gold	Blue
Flash Point Closed Cup	88°F (31°C)	N/A
Viscosity @ 77°F(25°C) - Brookfield Viscometer	156,000 - 208,000	70,000 - 150,000

Product Uses

Two component polyester compounds used to repair dents, dings, gouges and other cosmetic imperfections

Performance Properties

Sand Time: 20 minutes when mixed with 2% hardener by weight @ 77°F (25°C)

Application Temperature: Min 45°F(7°C) Max 180°F(82°C)

Service Temperature: Min -20°F(-29°C) Max 180°F(82°C)

Linear Shrinkage: 0.60% LTM 855.0084 10-inch gauge, after 24 hours

Minimum hardener: 1.5%

Maximum hardener: 2.75%

Lap Shear, Steel to Steel:	1,190 +- 100 psi	ASTM D1002
Lap Shear, Aluminium to Aluminium:	1,030 +- 100 psi	ASTM D1002
Tensile Strength:	1,210+- 100 psi	ASTM 638 Type 1 Specimens
Shore D hardness:	10 Min. +-5 20 Min. +-5 30 Min. +-5 60 Min. +-5 24 hour 70 +-5	ASTM D2240

Directions for Use

Clean the repair area using soap and water followed by a wax & grease remover/surface cleaner. Sand the surface as needed with grade 40 to 80 3M abrasive.

Note: if grinding is required use a grade 50 3M grinding disc, blow off the sanding dust with clean dry air. If repairing galvanized steel, e-coat, primed/painted surfaces or aluminum, sand with grade 80 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.

1. 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.
2. 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.
3. 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.
4. Sand the filler to the proper contour with 3M abrasives, using the following recommended grade sequence: 40, 80, 180. Note: if more filler is needed blow off with clean dry compressed air and follow steps 2 through 5.
5. Wait approximately 45 minutes before applying primer and paint, always follow your paint company's recommended procedures.

Applications

Two component polyester compounds used to repair dents, dings, gouges and other cosmetic imperfections on steel, Aluminium, Fiberglass and Wood.

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

Store in a dry area at 65-80°F(18-27°C) for optimal shelf life.

Shelf life: 16 months from date of manufacture

Precautionary Information

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

Safety Considerations

Material Safety Data Sheets (MSDS) are available from 3M™ at www.3M.com/MSDS or upon request through your nearest Sales office. MSDS sheets are provided to help customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. MSDS sheets are updated regularly. Therefore, please request and review the most current MSDS before handling or using any product.

Customer Notice

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Warranty and Limited Remedy

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For Additional Health and Safety Information

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