



Science.  
Applied to Life.™

Faster than ever for the Bodyshop.  
3M™ Fast Cure Epoxy Metal Filler.

**Important note  
on process safety**

Always wear Personal  
Protective Equipment

- Comfort particle mask P3



- Hearing protection



- Comfort goggles



- Reusable overalls



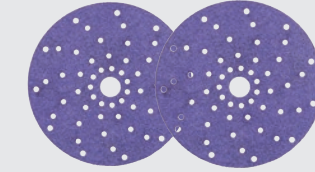
- Nitrile gloves



# 1 Preparation

- Reshape and sand metal surfaces with 3M™ Cubitron™ II 80+ to 120+ and remove paint

Note: The Festool ROTEX RO 150 is recommended for coarse grade sanding. For aluminium, please use the Festool LEX 3 150.



51369 3M™ Cubitron™ II Hookit™ Purple+ Premium Abrasive Discs Multihole 737U, 150mm, 80+

51370 3M™ Cubitron™ II Hookit™ Purple+ Premium Abrasive Discs Multihole 737U, 150mm, 120+



202770 (DE & AT), 202771 (CH) Festool geared eccentric sander ROTEX RO 150



202797 Festool pneumatic eccentric sander LEX 3 150/7

# 2 Cleaning and degreasing

- Thoroughly clean and degrease the repair area

Note: After cleaning and degreasing, allow 5 minutes for all degreaser to evaporate.



8984 3M™ adhesive cleaner



34567 3M™ disposable wipes

# 3a Calibration of the cartridge

- Always ensure to use completely mixed product, the colour should be uniformly grey

I. Dispense material until both components emerge evenly (do this once with every new cartridge).  
II. Attach the 3M™ mixing nozzle (51875) and dispense material until thoroughly mixed and a uniform grey colour has been achieved. Discard the first centimetre of the mixed material on 3M™ Large Paper Mixing Board (20382).



37455 3M™ Fast Cure Epoxy Metal Filler 180 ml cartridge incl. 1 mixing nozzle



51875 3M™ mixing nozzle for cartridge

# 3b Application

- Always apply on bare metal
- Make sure that the tip of the nozzle is always immersed in the product
- Place individual material beads directly into each other to avoid air inclusion

Note: material can be applied to, and will adhere to, itself.

# 4 Smooth and spread

- Smooth and spread from the middle until spread and shaped



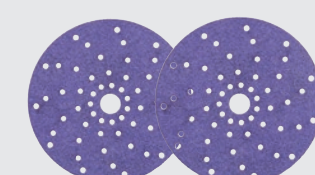
00358 3M™ plastic spreader

# 5 Curing

- To speed up the curing process, heat panel for 15 to 20 minutes at 70°C or at room temperature 4 hours at 22°C (depending on the layer thickness)

Note: Optimal curing is achieved by heating the substrate to approx. 30°C before material application. It is recommended to wait 15 minutes before accelerated curing after material application to avoid blistering.

# 6a Surface sanding machine



51369 3M™ Cubitron™ II Hookit™ Purple+ Premium Abrasive Discs Multihole 737U, 150mm, 80+

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202770 (DE & AT), 202771 (CH) Festool geared eccentric sander ROTEX RO 150

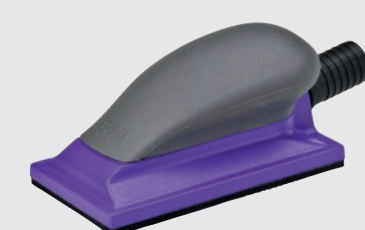


202797 Festool pneumatic eccentric grinder LEX 3 150/7

# 6b Surface sanding hand block



51386 3M™ Cubitron™ II Hookit™ Purple Premium Sheet 737U, 70 x 127 mm, 80+



05170 3M™ Hookit™ Purple Premium hand block, 70 x 127 mm



9560 3M™ Dry Guide Coat, black



Automotive Aftermarket Division  
3M United Kingdom PLC  
3M Centre, Cain Road  
Bracknell, Berkshire RG12 8HT  
Tel: 0845 603 9714

3M Ireland Limited  
The Iveagh Building, The Park  
Carrickmines, Dublin 18  
Tel: 1 800 320 500

aadukenquiries@mmm.com  
www.3M.co.uk/bodyshop

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