



## Automotive Aftermarket Division

### 3M™ 51004 DMS Fine General-Purpose Body Filler

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#### 1) Part Numbers

51004

#### 2) Description and end uses'

Soft Body Filler 51004: 276 ml two-part cartridge system - 50:1 mixing ratio filler to hardener.

3M™ 51004 is intended to be used as an automotive body repair material. This lightweight polyester filler is capable of repairing imperfections such as dents in steel and aluminium, as well as a finishing material over properly reinforced cracks in SMC and Fibreglass.

51004 Fine General-Purpose Body Filler is designed to be used with the 3M™ Dynamic Mixing System Applicator (PN 50600) and the 3M™ Dynamic Mixing System Nozzle Red (PN 50601).

#### 3) Physical Properties

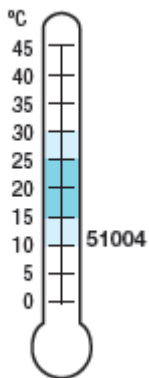
Container	Two Part Cartridge	
	Part A (Filler)	Part B (Hardener)
Base	Polyester resin with styrene monomer	Benzoyl Peroxide
Consistency	Viscous paste	Viscous paste
Density (g/cm <sup>3</sup> )	1.1	1.2
Colour	Creme-White	Blue

The following times have been determined with ambient air temperature and a substrate temperature at 10° to 35° C and are considered typical values.



# Technical Data Sheet

Effective: 28/02/2020 Supersedes: 01/01/2000



WORK TIME: 5-6 mins @ 10° C 2-3 mins @ 35° C  
MIX NOZZLE DWELL TIME: 2-3 mins @ 10 ° C 2 mins @ 35° C  
SAND TIME: ~ 15 mins @ 10° C ~ 13 mins @ 35° C

Usage temperature: 10° C – 30° C

Optimum temperature: 15 ° C – 25° C

## 4) Directions for Use

### 1 - Preparation

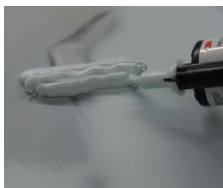
Surfaces should be thoroughly de-greased and free from dirt and dust. Sand the damaged area with a P80 abrasive disc. To remove any corrosion or broken paint, a suitable Bristle Disc or Fibre Disc should be used. Wipe dust away and clean the surface with Adhesive Cleaner.

Wear appropriate personal protective equipment when working with body filler. Refer to the relevant MSDS and 50600 DMS applicator user manual

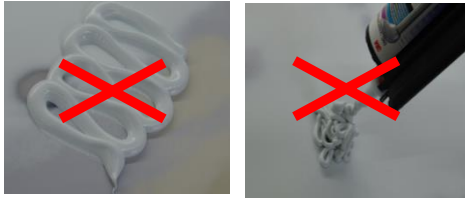
### 2 - Application method

- 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 retainers engage mixing nozzle
  - Note: If the cartridge is placed onto a hard surface with force, the driving rod can be dislodged and become loose. It can be pressed and clicked back into position by the simple use of a screw driver. Push the screwdriver through underneath the sealing cap and press the driving rod back in place
  
- Installing the cartridge
  - Position the cartridge with the larger diameter cylinder in the 11 o'clock position relative to the 3M™ Dynamic Mixing System Applicator.
  - Place the mounting flange end of the cartridge against the mounting plate of the applicator, making sure to align and insert the cartridge drive rod with the applicator drive socket, located in the centre of the applicator 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.
- Equalising the cartridge
  - Refer to the 3M™ Dynamic Mixing System Applicator manual for detailed instructions on applicator set up and safety information
  - Close down the regulator on the applicator into the fully off position
  - Attach an airline to the air inlet on the applicator
  - Open the regulator to obtain correct dispensing pressure (approximately 2 to 3 turns)
  - Using a disposable collection point, dispense a small amount of material by fully depressing the applicator trigger
  - Discard the very first 2-4 cm of filler bead from a new cartridge to allow initial equalisation, any further material is good to use.
  - Note: The initial extrusion contains both hardener and filler and due to the specific set-up of the cartridge, it will be a deep blue for the very first centimetre or two and become lighter thereafter.
- 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.
  - Proceed with application method (i.e. spreading) as desired.
  - You may continue to dispense material until the normal material curing process clogs the mixing nozzle – typically after approximately 2 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 4-6 mm, maximum layer thickness should not exceed 2-3 mm. Due to the creaminess of this Fine General-Purpose Body Filler, this product is also ideal as final filler layer (like a glaze) on top of coarse sanded previous filler layers.
- Best practice application techniques to ensure minimal risk of pinholes

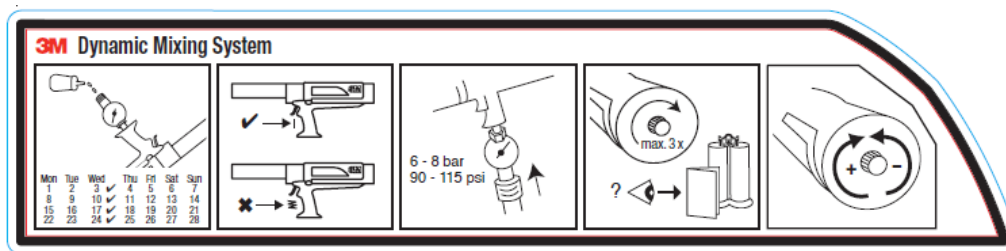


Keep nozzle tip always in the material, place beads directly next to each other.



To prevent air entrapment, avoid applying material as shown (no spaghetti balls / spaced bead)

- Best applicator handling (see sticker on applicator)
  - Oil weekly
  - Do not feather trigger
  - Inlet flow pressure should be between 6 – 8 bars
  - Max. 3 turns working speed



A small amount of equalisation waste with a new nozzle is possible if previous material was expressed with high pressure or if a large amount was expressed before.

Always check that the colour of the material coming out has a shade blue in it, if in doubt, discard the first couple of cm.

**CAUTION:** Be sure to replace nozzles containing fully or semi cured material to prevent damage to cartridge or nozzle or personal injury. If material is dispensed against a cured nozzle, re-equalisation of material might be needed. Dispose of uncured material in an approved receptacle.

### 3 - Infra Red Curing

- Do not start using an infrared dryer prior to the filler starting to set!
- Refer to and follow the manufacturer's instructions when using IR equipment to cure 3M™ 51004
- The following are typical figures provided for guidance
  - Short wave 4 min at full power
  - 4:20:70 (4 minutes total time: Temperature increase 20°C per minute: Maximum Temperature is 70°C)
  - Medium wave 5-10 min at full power
- Distance from panel: Consult IR equipment manufacturers instructions



# Technical Data Sheet

Effective: 28/02/2020 Supersedes: 01/01/2000

Best practice although is it to let the material cure at ambient temperature.

## 4 - Next steps – following layers

We recommend using 2K primers as following layers as per paint system recommendations.

## 5) Storage

12 months from original date of manufacture in the original sealed packaging between 5° and 25 °C. Refer to label for expiry date.

Any opened cartridge can be stored with the used nozzle on for a few days; be sure to put a fresh nozzle on before using the cartridge again.

## 6) Safety

Read full instructions and material safety data sheet before use.

**IMPORTANT:** This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the material safety data sheet for full handling instructions and personal protection information. These are available via your stockist. The supplier disclaims any liability where the user does not wear recommended personal protective equipment.

**3M™ DMS Fine General-Purpose Body Filler is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.**

## 7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.



# Technical Data Sheet

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## For Additional Health and Safety Information

3M South Africa & Sub-Saharan Africa, 146A Kelvin Drive, Woodmead, Sandton, South Africa, Tel: (0861) 225536
3M (East) AG Representation Office Tirane, Rruga Sami Frasheri, Pallati i Ri Perxhola Kati 2 Ap2, 1000 Albania
3M Arabia, LLC, Building 24-25 3M Saudi Arabia Zone C, Business Gate, Airport Road, Riyadh, Saudi Arabia
3M Bulgaria, Mladost 4, Business Park, bl.4, 2nd floor, Sofia 1766, Bulgaria
3M Česko, spol. s r.o., V Parku 2343/24, 148 00 - Praha 4, Czech Republic
3M (East) AG, Branch office Croatia, Avenija Većeslava Holjevca 40, 10 000 Zagreb, Croatia, Tel: +385 1 2499750, www.3m.com.hr
3M Egypt, Finance Center , New Cairo , Plot 140 , Banking Sector , 5th settlement , Cairo , Egypt
3M Hellas MEPE, Automotive Aftermarket Division, 20 Kifisias Avenue, 151 25 Marousi, Greece, Phone: +30 210 68 85 300, innovation.gr@mmm.com, www.3M.gr
3M Hungária Kft, Neumann János u. 1/E, 1117 Budapest, Hungary
3M Israel, 91 Medinat Hayehudim St., Herzliya, Israel
3M Kenya Ltd, Victoria Towers, 3rd Floor, Kilimanjaro Av, Upperhill, Kenya
3M Gulf Limited, Ein El Mreisseh, Saint Charles City Center, 4th. Floor, P.O.Box: 11-5025, Riad el Solh, Beirut 1107 2180 Lebanon
3M Minnesota Mining & Manufacturing Nigeria Limited, No 2 Sheraton Opebi Link Road, Ikeja, Lagos Nigeria
3M Pakistan, Islamic Chamber of Commerce Building, ST-2/A, Block 9, KDA Scheme 5, Clifton, Karachi, Pakistan
3M Poland, Al. Katowicka 117, Kajetany, 05-830 Nadarzyn, Poland, Telefon: +48 22 739 60 00, www.3m.pl/kontakt
3M Gulf (Representation Office), Suhaim Bin Hamad St., Al Mana Towers Tower B, 2nd Floor, Office No.4, Doha Qatar, P.O.Box 14685
3M Romania, 12 Meneuului St., Bucharest Business Park, Building D, District 1 013713 Bucharest, Romania
3M (East) AG, Representation Office Serbia, Airport City, Omladinskih brigada 90B, 11070 Belgrade, Serbia, Tel: +381 11 2209 400, www.3m.co.rs/3M/sr_RS/3m-south-east-europe/
3M Slovensko s.r.o., Polus Tower 2, Vajnorská 100/B, 83104 Bratislava
3M (East) AG, Branch office Slovenia, Cesta v Gorice 8, 1000, Ljubljana, Slovenia, Tel: +386 1 2003 630, www.3m.com/3M/sl_SI/3m-south-east-europe/
3M Sanayi ve Ticaret As, Barbaros Mah., Mor Sümbül Sok., No:7/3F, 27-51, Nidakule Ataşehir Güney, 34746 Ataşehir, İstanbul, Turkey
3M Gulf Limited, Dubai Internet City, Building No. 11, 3rd Floor, U.A.E

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