

# 3M™ Wind Epoxy Filler W3120, 10 minutes

## Product Description

3M™ Wind Epoxy Filler W3120 is a flexible and tough two part epoxy filler used to:

- Finish and smooth the wind blade surface and leading edge during the manufacturing process
- Repair minor damage on the wind blade surface quickly and reliably during maintenance operations either on the ground or up tower

The duo-pack cartridge delivery system ensures proper mixing and eliminates the mess and waste associated with hand mixing. It's easy to apply the 3M Wind Epoxy Filler W3120 exactly where it's needed.

All times are at 70°F/21°C and 50% RH.

Work time	10 minutes
Sand time	30 minutes
Paint time	30 minutes

## Typical Physical Properties

Property	Bulk
Container	200mL Dual Cartridge
Base	Epoxy
Density lbs/Gallon (Approx.)	8.3/8.3
Color	Blue/White
Solids Content (Approx.)	100%
Consistency	Paste
Solvent	None
Service Temperature °F (°C)	-20 to 180°F (-28.9 to 82.2°C)

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

## Directions for Use

Evaluate the wind blade surface to determine the level of damage. Follow internal procedures to determine the appropriate repair method. If damage is minor and fiberglass reinforcement is not required, the repair method outlined below may be appropriate.

### Wind Blade Manufacturing

1. Make sure wind blade surface has been scuffed and is clean and dust free per internal procedures.
2. Load the 3M Wind Epoxy Filler W3120 cartridge in the applicator and remove the cap. To ensure adequate mixing, "equalize" the cartridge by dispensing filler until both Part A & B are visible. Attach the nozzle.
3. Apply 3M Wind Epoxy Filler W3120 directly to the repair area or via a 3M squeegee.

4. Build 3M Wind Epoxy Filler W3120 to a height equal to or greater than the surrounding area.
5. Use a 3M™ Clean Sanding Disc P80 to sand the filler close to level with the surrounding area.
6. Follow internal procedures for final surface finishing, including additional sanding and application of the topcoat.

### Wind Blade Maintenance and Repair

Before starting the repair, evaluate the wind blade surface to determine the level of damage. Follow internal procedures to determine the appropriate repair method. If damage is minor and fiberglass reinforcement is not required, the repair method outlined below may be appropriate.

1. Wash the repair surface with soap and water to remove water soluble debris. Clean with a substrate compatible solvent to remove other surface contaminants.
2. Dish out the repair area with a 3M Clean Sanding Disc P80.
3. Finish the dish out process with a 3M™ Clean Sanding Disc P180 and feather into the surrounding area, removing coating where filler will be applied.
4. Remove dust from surface using clean, unoled compressed air and a clean, dry rag.
5. Load the 3M Wind Epoxy Filler W3120 cartridge in the applicator and remove the cap. To ensure adequate mixing, "equalize" the cartridge by dispensing filler until both Part A & B are visible. Attach the nozzle.
6. Apply a tight coat of 3M Wind Epoxy Filler W3120 to the repair area, using firm pressure to ensure good contact and bonding. 3M Wind Epoxy Filler W3120 can be applied directly to the repair area or via a squeegee.
7. Continue to build thick, wet coats of the 3M Wind Epoxy Filler W3120 until the repaired area is slightly higher than the surrounding area. Allow filler to cure for listed sand time.
8. Use a 3M Clean Sanding Disc P80 to sand the filler close to level with the surrounding area.
9. Use a 3M Clean Sanding Disc P180 to finish leveling the area and feather into the surrounding area.
10. Prime and paint per the paint manufacturer's recommendations.

**Please note:** Polyester or epoxy putties or glazes can be applied over the 3M Wind Epoxy Filler W3120 if desired.

Read and follow the precautions on label and MSDS before using product.

## Temperature Considerations

- 3M Wind Epoxy Filler W3120, works best when the substrate and filler temperatures are 60°F (16°C) or higher.
- Repairs are not recommended below 50°F (10°C).

## Storage

Store in a dry place at room temperature conditions for optimal shelf life.

## Shelf Life

Shelf life is one year from the date of manufacture.

## Handling

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

## Caution

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. Always wear gloves, eye protection, appropriate respiratory protection, and work in a well-ventilated area.

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For more information on our wind energy product line, contact 3M Renewable Energy at 800-755-2654 or visit us at [www.3M.com/wind](http://www.3M.com/wind).

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