



# Lightweight Bonding Putty

## 16015

Technical Data

April 2018

**Product Description** 3M™ Lightweight Bonding Putty has outstanding bonding strength and is designed for bonding and filling substrates – adding minimum weight to any structure. This highly thixotropic polyester putty is ideal for vertical applications. Lightweight Bonding Putty can be catalyzed with either a liquid Methyl Ethyl Ketone Peroxide (MEKP) 9% active oxygen or with a Benzoyl Peroxide Paste (BPO-50).

- Features**
- Lightweight bonding
    - Non-sagging
  - Excellent vertical hang in very thick sections
  - Trowels and spreads easily
  - Excellent for bonding and bedding core materials and FRP parts
  - Low shrinkage, low exothermic compound
  - Use to bond liners to hulls and decks
  - Great for 1-2 inch bond line thickness
  - Great for filling large strakes
  - Great for bonding FRP to FRP or wood to FRP
  - Only 5.8 lbs per gallon

**Product Specifications**

<b>Color and Odor:</b>	White compound with typical styrene odor.
<b>Viscosity @ 77°F (25°C) using Brookfield RVT, 2.5 RPM, Spindle TE:</b>	700,000 – 1,000,000 cps
<b>Density @ 77°F (25°C):</b>	43.4 ± 1.5 pounds per cubic feet
<b>Weight Per Full Gallon @ 77°F (25°C):</b>	5.8 ± 0.2 pounds
<b>Uncured Stability @ 77°F (25°C):</b>	6 months
<b>VOC of unmixed material:</b>	168 g/l = 1.40 lb./gal
<b>VOC after mixing with component B (hardener):</b>	0 g/l

**Catalyst and Gel Time**

Catalyst % by Weight	Peak Exothermic Temperature	Gel Time
1.0% BPO	180°F (82°C) – 190°F (88°C)	30 - 45 min
1.5% BPO	190°F (88°C) – 200°F (93°C)	15 - 27 min
2.0% BPO	200°F (93°C) – 210°F (99°C)	30 - 45 min
1.0% MEKP	180°F (82°C) – 190°F (88°C)	20 - 35 min
1.5% MEKP	190°F (88°C) – 200°F (93°C)	15 - 27 min
2.0% MEKP	200°F (93°C) – 210°F (99°C)	12 - 22 min

Above results were obtained using 100-grams mass of compound. Tests were conducted with compound at 77°F (25°C) and surrounding conditions at 77°F (25°C). A change in mass and temperature may vary results. Catalysts used were Norac BPO and Akzo Cadox M-50.

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## Technical Information

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Industrial Adhesives and Tapes  
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