

3M

Fillet Putty

16035 • 16039

Technical Data

April 2018

Product Description 3M™ Fillet Putty is a milled fiberglass reinforced polyester putty/gel designed to fill corners or sharp transitions between gel coat and the laminate application thus eliminating air voids. This putty can also be used for bonding all types of core materials. Fillet 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**
- Great for use as a radius putty
 - Reduces air voids and dry fibers in laminates
 - Low shrink and exotherm to produce better quality finishes
 - Maintains resiliency to resist cracking and local impact damage
 - Can also be used to fill voids in plywood and for bonding wood to FRP or wood-to-wood
 - Reinforced with milled fiberglass
 - Excellent for filling voids in tooling
 - Can be machine pumped, brushed, or troweled
 - Great for bonding or bedding core materials
 - Great for cut-edge filling in composites

Product Specifications	Color and Odor:	Neutral color with typical styrene odor.
	Viscosity @ 77°F (25°C) using Brookfield RVT, 2.5 RPM, Spindle TE:	700,000 – 1,100,000 cps
	Density @ 77°F (25°C):	74.8 ± 1.5 pounds per cubic feet
	Weight Per Full Gallon @ 77°F (25°C):	10.0 ± 0.2 pounds
	Uncured Stability @ 77°F (25°C):	6 months
	VOC of unmixed material:	337 g/l = 2.81 lb./gal
	VOC after mixing with component B (hardener):	0 g/l

Catalyzation and Gel Time	Catalyst % by Weight	Peak Exothermic Temperature	Gel Time
	1.0% BPO	200°F (93°C)	45 min
	1.5% BPO	210°F (99°C)	30 min
	2.0% BPO	220°F (104°C)	20 min
	1.0% MEKP	200°F (93°C)	25 min
	1.5% MEKP	210°F (99°C)	20 min
	2.0% MEKP	220°F (104°C)	15 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 Cadoc M-50.

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