



Document Library
TS Data Sheet 46004
46005
46006

Rev:2

Status: Active

Effective: 01/11/2002

3M™ Marine Premium Filler

3M Part No.(s)	3M Part Descriptor(s)
46004	Pint
46005	Quart
46006	Gallon

Description

3M™ Marine Premium Filler is a unique vinyl ester formulation designed for marine filling and fairing applications above or below the waterline. 3M™ Marine Premium Filler is a unique and easy to sand formula designed with 3M™ Scotchlite™ Glass Bubbles.

Features

- Excellent moisture resistance
- Fast curing
- Easy to sand
- Easy spreading
- Premixed
- Blue creme hardener

Typical Physical Properties

Base	Vinyl Ester
Color	Light Yellow
Flash Point - °F	88 F
Solids Content (Appx.)	100% By Weight (App.)
Consistency	Thick Liquid
Reactive Diluent	Styrene
Net Weight	0.6 lb. Per Gallon

Performance Properties

A. Cure Rate

With 2 % 3M™ Creme Hardener and at 70°F/50% RH.

working time 10 minutes
sandable in 30 minutes

B. Shear Strength:

Recorded in pounds per square inch.

wood	fiberglass	
509	669*	PSI

Shear strength retained after 2 week salt water soak = 99 %
* substrate failure

- C. Tensile
Tensile 1396 PSI

Application Information

Directions for Use

Important usage recommendations:

- Surface and product temperatures must remain above 60°F from application to full cure.
- All epoxy resins must be removed prior to application of 3M Marine Fiberglass Fillers. Epoxy will inhibit cure and adhesion.
- Laminates must be dry.

Failure to follow these recommendations will yield unsatisfactory results.

Surface Preparation:

Clean surface free of dust, grease, wax, oil and moisture using a cloth and good cleaning solvent such as 3M™ General Purpose Adhesive Cleaner, P.N. 08984, or acetone.

When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe proper precautionary measures for handling such materials. Refer to product label and MSDS for further precautions.

Local and Federal air quality regulations may regulate or prohibit the use of surface preparation and cleanup materials based on VOC content . Consult your Local and Federal air quality regulation.

Remove damaged fiberglass or wood from the repair area. Scuff repair area with a 80 grit abrasive. Wipe clean.

Mixing:

Apply the desired amount of filler on a clean non-porous mixing surface. Do not use cardboard, as styrene or hardener may soak in and effect performance.

Add 2% 3M™ Marine Creme Hardener (1 ½ inch strip* of cream hardener to a golf ball sized amount of filler). Mix filler and hardener to a uniform color making sure to break any air bubbles that may have been introduced. Mix only what you will use in 10 minutes.

Premium Filler	Creme Hardener
¼ pint	5 inch strip*

½ pint	10 inch strip*
pint	20 inch strip*
quart	40 inch strip*

2 % creme hardener*

Apply
one strip of
hardener
across
the diameter of
the filler.
Amounts
of filler larger
than a baseball
will
require
additional
hardener.

* Diameter of bead strip should be equal to the opening in the tube.

Application:

Do not proceed with the repair if the air, 3M™ Marine Premium Filler, or the area to be repaired is below 60°F.

For scratches, cracks, and gouges deeper than ¼", begin with 3M™ Marine High Strength Repair Filler and follow label directions.

Wet surface by applying a thin coat of mixed 3M™ Marine Premium Filler to the clean repair surface. Spreading in one direction and then smoothing in the opposite direction will reduce the possibility of leaving voids. Apply additional filler in layers (3/8" maximum thickness per layer), building slightly higher than the surrounding area. 3M™ Marine Premium Filler can be sanded after 30 minutes.

APPLICATION TIP: In many cases separate fill coats will reduce the amount of sanding and labor time.

- fill level with surrounding surface and allow to cure.
- fill any low areas or pin holes with a "skin coat".

Finishing:

Sand 3M™ Marine Premium Filler close to contour using a coarse grade

40 grit abrasive, follow with a medium grade 80 grit. Most primers, coating, and sprayable fillers will fill 80 grit scratches. When not using a primer, final sanding with a fine grade 180 grit may be necessary.

For topside repairs, apply primer, paint, or gelcoat following manufactures recommended procedures.

Cleanup:

For cleaning 3M™ Marine Premium Filler before it is cured, use a dry cloth to remove the majority, followed by a cloth damp with 3M™ General Purpose Adhesive Cleaner, P.N. 08984 or acetone.

*Cured Filler can be removed by sanding.

Applications

For filling and fairing of fiberglass, metal, and wood. Can be applied up to 3/8" thick per application. Can be used for boat repairs above or below the waterline.

- Filling scratches, cracks, and gouges above and below the waterline
- Building and shaping
- Fairing hulls, decks, keels, rudders, etc.
- Cosmetic filling of repair area

Storage and Handling

Recommended Storage Temperature Range : 60F or 15C to 80F or 26C

Expected Shelf Life at Recommended Storage Temperature : 12 months

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

Country

US

This document is public. It may be distributed.

Important Notice to Purchaser

Technical Data: All physical properties, statements and recommendations are either based on tests we believe to be reliable or our experience, but they are not guaranteed. 3M recommends each user determine the suitability of the products for the intended use.

* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

Warranty and Limited Remedy: 3M warrants this product will be free from defects in materials and manufacture. **3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE** . If the product is proved to be defective your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

Limitation of Liability: 3M and seller will not be liable for any loss or damage arising from this product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract,

negligence or strict liability.

For Additional Health and Safety Information

3M Marine
3M Center, Building 223-6S-06
Saint Paul, MN 55144-1000
1-877-366-2746 (1-877-3M MARINE)