



TECHNICAL BULLETIN

BONDO® Body Filler

DESCRIPTION

We blend microspheres with selected resins and talcs to produce an automotive body filler that is faster and easier to work, while yielding a stronger, more flexible and durable painting surface. What separates Bondo® from the other lightweight brands is superior manufacturing and precise quality control, ensuring a consistent product time after time.

FEATURES

- Non-separating formula.
- Smoother texture. Easy to work with.
- Quicker, easier filing.
- Good adhesion to steel, metal, aluminum, fiberglass and wood surfaces.
- Easier faster spreading. Doesn't clog, so it cuts sandpaper usage dramatically.
- Ready to sand in 20 minutes

PRODUCTS

- 261 Pint
- 262 Quart
- 265 Gallon
- 267 1/2 Gallon

SURFACE PREPARATION



- Clean surface with warm, soapy water to remove all wax, grease and oil. Allow to dry.
- Sand the damaged area with coarse 80 grit sandpaper to remove all paint, primer and rust down to bare metal. Sand 1 to 2 inches beyond damaged area. Remove sanding dust.

MIXING



Knead cream hardener tube thoroughly before using. For a golf ball-size amount of filler, squeeze out 1+ 1/4-inch strip of hardener, or mix 3 inch diameter circle, 1/2-inch thick of filler to 3 inch strip of cream hardener. Correct ratio is 2:100 by weight. Mix thoroughly to uniform color on clean, nonporous surface. Mix only small amounts that can be used within 3 to 4 minutes. Do not add cream hardener in filler container.

APPLICATION



Apply layer of mixed filler over repair area using firm pressure to assure maximum adhesion. If necessary apply multiple coats to build contour higher for sanding. Use of a dust mask is recommended. Do not apply layers of filler that exceed 1/4-inch in thickness.

For best results apply at 45°F (7°C) or above. Temperatures below 60°F may lengthen cure times by 5 to 10 minutes. For clean-up, use Acetone.

POT LIFE



3 to 4 minutes.

DRYING/SANDING TIMES



Allow the application of filler to cure 20 to 30 minutes. Sand with 80 grit sand paper and featheredge with 180 grit sandpaper or finer. Wait 1 hour before painting. Drying time depends on temperature and amount of hardener used.

Optional: Apply a very thin layer of Bondo® Glazing & Spot Putty to fill pinholes or small imperfections if necessary.

PRIME/PAINT



Can be primed and painted after 1 hour.

PRODUCT SPECIFICATIONS

3M

3M Automotive Aftermarket Division

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St. Paul, MN 55144-1000
1-877-MMM-CARS (666-2277)
www.3m.com/automotive
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60-4402-4639-9

| | |
|-------------------------|--------------------------|
| Color | Light Gray |
| Specific Gravity | 1.12 ± 0.03 |
| Viscosity | 144,000 - 232,000 cps. |
| Gel Rate | 3.75 - 5 minutes |
| Shore D Hardness | |
| After 2 hours | 60 ± 5 |
| Filing Time | 3 - 10 minutes after gel |
| Sanding Time | 20 minutes |
| Tensile Strength | approx. 1000 psi |
| Lap Shear | approx. 1000 psi |

Adhesion

- > Steel to Steel: approx. 1000 psi

Properties of Cured Product

- > % Shrinkage: <0.5%
- > % Water Absorption: <0.3%
- > Gasoline Resistance:

Excellent

Maximum Application Temperature

Above 180°F the product will soften, and the repair may lose adhesion

Shelf Life One (1) year from date of manufacture