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**Technical Data Sheet 05857**

**Public**

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**3M™ Dent Finishing Glaze PN 05857**

**Data Sheet**

**3M Part No.(s)**                      **3M Part Descriptor (s)**  
05857                                      3M™ Dent Finishing Glaze

**3M Fax on Demand Identification Number :** 05857

**Description**

3M™ Dent Finishing Glaze (PN 05857) is intended to be used as an auto body repair material. This polyester finishing glaze is capable of repairing minor imperfections such as scratches, gouges, pinholes, and low areas.

**Features, Advantages, Benefits**

<b>Features</b>	300 ml cartridge system 50:1 mix ratio Automatic hand held dispensing system
<b>Advantages</b>	Air Free mixing and application Correct mix ratio each application Minimal waste direct application
<b>Benefits</b>	Pin hole free repairs saves time and materials Trouble free repeatable performance Material and time savings

**Typical Physical Properties**

<b>Container</b>	Two Part Cartridge	Two Part Cartridge
<b>Base</b>	Polyester resin with Styrene Monomer	Benzoyl Peroxide
<b>Density lbs/Gallon (Appx.)</b>	7.8 lbs./gallon	10 lbs./gallon
<b>Color</b>	Tan/Beige	Blue
<b>Flash Point - °F</b>	ASTM D93 closed cup method 89F	N/A
<b>Viscosity (CPS) Brookfield Viscometer</b>	17,600 - 25,600 @77F 2.5 RPM T spindle	N/A
<b>Consistency</b>	Viscous liquid	Viscous paste
<b>Service Temperature - °F</b>	- 20F to 180F	N/A

**Product Uses**

3M™ Dent Finishing Glaze (PN 05857) is intended to be used as an auto body repair material. This polyester finishing glaze is capable of repairing minor imperfections such as scratches, gouges, pinholes, and low areas. It may be applied on properly prepared steel, aluminum, SMC, Fiberglass and cured automotive paint surfaces.

3M™ Surface Finishing Glaze (PN 05857) may also be used for industrial and architectural surfaces needing minor surface repairs.

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### Performance Properties

<b>Sanding Time @ 77F:</b>	15 minutes
<b>Shore D Hardness:</b>	10 Min. 35 +-4 20 Min. 45 +-5 30 Min. 48 +-5 60 Min. 50 +-5, 24 hour 55 +-5
<b>Tensile Strength:</b>	ASTM D638-82 2050 +- 100 PSI
<b>Lap Shear Steel to Steel:</b>	ASTM D3163-84 2050 +-100PSI
<b>Lap Shear Aluminium to Aluminium:</b>	ASTM D3163 740 +-100 PSI
<b>Shrinkage:</b>	Less than 1.00%
<b>Minimum hardener:</b>	1.5%
<b>Maximum hardener:</b>	2.75%

## Handling and Application Information

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### Directions for Use

#### **SURFACE PREPARATION:**

Use appropriate 3M VOC compliant product(s) for adhesive removal, degreasing, cleaning or removal of surface contaminants, then sand the area with grade 80 – 180 grit abrasive, blow off with clean dry compressed air. Note: For best results apply using a “paint to paint” technique reducing the need for additional coats of primer. See 3M™ Dent Repair System for details on this technique (3M.com/automotive)

#### **PRODUCT PREPARATION:**

##### **INSTALLING THE CARTRIDGE**

- Position large diameter cylinder in the up (12 o'clock) position.
- Place the mounting flange end of the cartridge against the mounting plate of the dispenser, making sure to align and insert the cartridge drive rod with the dispenser drive socket, located in the center of the dispenser mounting plate.
- Press the cartridge back against the mounting plate (this should occur without resistance if drive rod is aligned properly) and twist until the cartridge locks into place.

##### **INSTALLING THE NOZZLE**

- Remove sealing cap from cartridge
- Align the 3M™ Dynamic Mixing Nozzle with the cartridge outlets, making sure to position the large outlet (cartridge) with the large inlet (nozzle) and the small outlet (cartridge) with the small inlet (nozzle).
- Press in until locking retainer engages mixing nozzle.

##### **EQUALIZING THE CARTRIDGE**

- Attach an air line to the dispenser inlet.
- Using proper air pressure settings (see directions for use included with the 3M™ Dynamic Mixing Gun) and a disposable collection point, depress the trigger until both sides of the dual-component material are present and the material is a consistent light blue/green color. This serves to “equalize” both sides of the cartridge.

#### **GENERAL REPAIR PROCESS:**

##### **DISPENSING TECHNIQUES**

- Material may be dispensed directly onto the damaged area, or onto a non-porous surface, such as a spreader or a mixing board.
- Immersing the nozzle in the puddle of material eliminates any air entrapment during dispensing.

- Proceed with application method (ie spreading) as desired.
- You may continue to dispense material until the normal material curing process clogs the mixing nozzle – typically after 2-3 minutes without depressing the trigger. If more repair material is desired after curing has occurred, remove and install a new nozzle.
- Maximum finished thickness should not exceed 1/8 inch

**CAUTION:** Be sure to replace nozzles containing fully or semi cured material to prevent damage to cartridge or nozzle or personal injury. Dispose of uncured material in an approved receptacle.

**APPLICATION WARNINGS:**

If applying to an unfamiliar substrate, perform a test to determine if suitable results are obtained. Do not apply on uncured paint surfaces. Be sure surface contaminants are removed prior to application.

**CLEAN-UP:**

Use an approved solvent to remove excess unwanted material from tools or surrounding areas prior to the expiration of work time (3-4 minutes).

**Applications**

3M™ Dent Finishing Glaze (PN 05857) is intended to be used as an auto body repair material. This polyester finishing glaze is capable of repairing minor imperfections such as scratches, gouges, pinholes, and low areas. It may be applied on properly prepared steel, aluminum, SMC, Fiberglass and cured automotive paint surfaces.

**Storage and Handling**

**STORAGE:**

Store unopened cartridges in an approved area, prevent exposure to flame, sparks, or high temperatures. Store previously opened cartridges with the used nozzle in place in an approved area prevent exposure to flame, sparks, or high temperatures.. Use caution not to damage outlets or drive shaft during storage or installation. Optimum storage temperatures 65° – 80° F, elevated storage temperatures reduce product shelf life.

**Precautionary Information**

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product . 05857

**Country**

US

**This document is public . It may be distributed .**

**Warranty and Limited Remedy**

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall 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 3M 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 Automotive Aftermarket Division  
 3M Center , Building 223-6N-01  
 Saint Paul, MN 55144-1000  
 1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.  
 Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

**3M Fax on Demand /MSDS Identification Number 05857**

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