

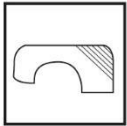


PRODUCT: 8416 Plus Par Patch and Repair Putty

PART NUMBER: 8416 30 Oz. Pump 6 units/case

DESCRIPTION: Two-part polyester finishing and blending putty. It offers superior adhesion to galvanized metal, metal, aluminum, body filler, wood, fiberglass, catalyzed primers, and aged/sanded OEM topcoats. Packaged with blue cream hardener

APPROVED SUBSTRATES:



- Steel
- Fiberglass
- Aluminum
- Sanded Body Filler
- Galvanized Steel
- Most Rigid to Semi-Rigid Plastics
- Cured Sanded OEM Finishes
- Cured Sanded 2K Primer Surfer

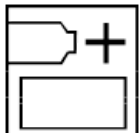
NOTE: Not for use on flexible plastics.

PREPARATION:



- Clean and degrease the entire panel to be repaired with soap and water, followed by a mild cleaning solvent. Thoroughly dry the surface before repairing.
- Use 80-180 grit to remove or scuff the paint and featheredge.

MIXING:



- Place the desired amount of material on a clean, non-fibrous surface. Knead the cream hardener before use.
- Measure hardener 2% by weight (add a ribbon of cream hardener from edge to edge across the center of a 4" (10 cm) diameter puddle. Puddles larger than 4" in diameter will require additional hardener.
- Mix thoroughly until uniform color is achieved.
- Approximate setting time is 4 - 5 minutes @ 72°F (22°C)

APPLICATION:



- Spread a thin layer of mixed material over surface using firm pressure.
- Apply additional layers to build material slightly higher than the surface to allow for sanding to desired contour

NOTE: Do not apply over new or uncured coatings. Avoid thick heavy applications.

FINISH:

- Sand to contour with 180 grit sandpaper.
- Final sand with 180 grit followed by 220-320 grit if desired.
- Apply 2K polyester, 2K urethane, 2K epoxy, or 1K primer to manufacturer's recommendations

**TECHNICAL
SPECIFICATIONS:**

• Appearance	Light Green Thixotropic Liquid
• VOC	Refer to Section 9 of the Safety Data Sheet
• Relative Density	Refer to Section 9 of the Safety Data Sheet
• Sand Time	25-30 min.
• Max Recommended Thickness (sanded)	1/8 inch (3mm)

NOTE:

**Properties are typical values and should not be considered as sales specifications.
Physical testing performed @ ~72°F (22°C) / 75% RH unless otherwise noted.**

**SAFETY &
HANDLING:**

Read all directions and warnings prior to using product.
Safety Data Sheets can be found online at <https://www.3m.com>.

NOTES:

Never return mixed filler to container

Keep can closed and store in a cool dry place

USE WITH SUPPLIED CREAM HARDENER ONLY!