

# Adhesives

## 3M™ Panel Bonding Adhesive

Designed to meet specific strength requirements for outer sheet metal panel replacement; panel bonding adhesive is typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.



Part No.	Color	Size	Units per Case
38315		50mL	
08115	Black		6
08116		200mL	

## 3M™ Impact Resistant Structural Adhesive

Designed to meet specific strength requirements for parts such as frame rails, strut towers, rocker panels, pillars and other members where impact resistance is important. This type of adhesive possesses a much greater ability than traditional bonding adhesives to absorb and manage energy under a variety of forces, especially peel and cleavage stresses in extreme temperature conditions. Typically impact resistant structural adhesive is used in conjunction with rivets, spot welds or mechanical fasteners.

Part No.	Color	Size	Units per Case
07333	Dispenses Silver, Cures Purple	200mL	3



**Color Change Feature**  
Curing process has begun, as indicated by silver to purple color change (30 min at 175°F)

## 3M™ Composite and Metal Bonding Adhesive

Approved for bonding door skins. Two-part urethane adhesive that is used to bond SMC and FRP (traditional fiberglass) body panels to each other and to metal. This product is a fast drying product with a 35 minute worktime. It is designed to bond composite and metal to each other, along with metal to metal applications.

**Approved for Direct to Bare Metal**



Part No.	Color	Size	Units per Case
08219	Green	200mL	6

# Adhesives Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Clamp/ Handling Time	Cure Time
3M™ Panel Bonding Adhesive (Direct to Metal Bonder)	38315	50mL	Black	Epoxy	90 min @ 70°F* 45 min @ 90°F*	4 hrs*	24 hrs
	08115	200mL					
	08116	200mL	Black	Epoxy	2 hrs @ 70°F* 1 hr @ 90°F*	6 hrs*	24 hrs
3M™ Impact Resistant Structural Adhesive	07333	200mL	Disp. Silver, Cures Purple	Epoxy	60 min	8 hrs*	24 hrs
3M™ Composite and Metal Bonding Adhesive – 35 (Direct to Metal Bonder)	08219	200mL	Green	Urethane	35 min	90 min	3 hrs
3M™ Quick Fix Adhesive Kit with Accelerator	08224	0.7 oz Adhesive/ 2 oz Accelerator	Clear	Cyano- acrylate	1 min	2 min	1 hr
3M™ Universal Adhesive	08107	50mL	Clear	Epoxy	3 min	30 min	1 hr
	08217	200mL					
	08223	200mL	Black	Urethane	3 min	30 min	4 hrs
	08214	200mL	Black	Urethane	10 min	1 hr	4 hrs
3M™ Channel Bonding and Sidelite Adhesive	08641	50mL	Black	Epoxy	5 min	1 hr	24 hrs

\*May be accelerated with heat.

## OEM Recommendations

Product Name	Part No.	Fiat/ Chrysler	Ford	General Motors	Honda	Hyundai/ Kia	Jaguar/ Land Rover	Tesla	Toyota	Volvo
3M™ Panel Bonding Adhesive	08115		✓		✓	✓			✓	
	08116	✓		✓						✓
3M™ Impact Resistant Structural Adhesive	07333			✓	✓	✓	✓	✓		

**Please reference OEM Repair Procedures:** Collision repair shops should follow OEM recommendations. Always reference the OEM repair procedure to make sure the correct adhesive is being selected for that repair.

## Did You Know?

- Many OEMs recommend 3M™ Panel Bonding Adhesive and 3M™ Impact Resistant Structural Adhesive for weld bonding and rivet bonding repairs.
- 3M™ Composite and Metal Bonding Adhesive 08219 has a 35 minute working time and can be unclamped and handled in as little as 2 hours at 70°F, making it perfect for door skin replacements.
- 3M™ Impact Resistant Structural Adhesive 07333 is optimized to duplicate collision energy management pathways and energy absorption.
- 3M™ Panel Bonding Adhesive 08115 works very well to repair many plastic substrates without the application of adhesion promoter.
- 3M™ Panel Bonding Adhesive 08115 can be “heat set” in as little as 15 minutes to handling strength.



3M™ Shop Rack  
02530



3M™ Static Mixing  
Nozzles 08193



3M™ Performance  
Pneumatic Applicator  
09930



3M™ Cubitron™ II  
Cut-Off Wheel  
33456

**Related Products**  
Learn more at [3MCollision.com](http://3MCollision.com)

# Part Number Reference

## Featured Products

### 3M™ Platinum™ Select Filler



Part No.	Size	Case Qty.
31131	1 Gallon	4
31130	3 Gallon	1
31128	5 Gallon	
35863	276mL DMS	6

### 3M™ Platinum™ Plus Finishing Glaze



Part No.	Size	Description	Case Qty.
31180	30 oz	Finishing Glaze	6
03180	24 oz		
03080	16 oz		
12011	24 oz	Glaze	
05862	276mL DMS		

### 3M™ Dry Guide Coat



Part No.	Size	Case Qty.
05860	Cartridge	10
05861	Kit	6

### 3M™ Panel Bonding Adhesive



Part No.	Size	Color	Case Qty.
38315	50mL	Black	6
08115	200mL		
08116			
58115	450mL DMS		4

### 3M™ Impact Resistant Structural Adhesive



Part No.	Size	Color	Case Qty.
07333	200mL	Dispenses Silver, Cures Purple	3
57333	450mL DMS		2