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Technical Data Sheet 08243

Public

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3M™ Automix™ SMC/Fiberglass Adhesive

Data Sheet

3M Part No.(s)	3M Part Descriptor (s)
08243	3M™ Automix™ SMC/Fiberglass Adhesive

3M Fax on Demand Identification Number : 08243

Description

Two-part urethane used to adhere backup strips and patches to SMC and FRP (traditional fiberglass). Faster version of Part No. 08227.

Features, Advantages, Benefits

Features	Urethane Chemistry Convenient self-mixing
Advantages	Fast work time Proper product ratio everytime
Benefits	Excellent for small strip and patch application Increases productivity

Typical Physical Properties

Container	200mL Automix™ cartridge
Base	Urethane
Density lbs/Gallon (Appx.)	10.7/10.2
Color	White/Black
Flash Point - °F	>200 °F
Viscosity (CPS) Brookfield Viscometer	12000 - 20000 centipoise
Solids Content (Appx.)	100%
Consistency	Paste
Solvent	None
Service Temperature - °F	-20 to 180 deg F
Propellant	N/A
Boiling Point - °F	>95 °F

Product Uses

Bonding small backer strips and patches to the back side of SMC and FRP repairs. The front side should be filled with PN 05885 Automix™ EZ Sand Rigid Parts Repair.

Performance Properties

Work time:	50 sec
Clamp time:	30 min
Cure time:	1 hour

Handling and Application Information

Directions for Use

1. Clean the areas to be bonded with soap and water. Next, use 3M™ General Purpose Adhesive Cleaner to remove any grease, wax and/or tax. Read guidelines for safe handling of the above chemical products.
 2. Sand the cleaned areas with a grade 36 abrasive, either by hand or machine.
 3. Wipe the areas with a clean, dry rag and blow off with compressed air.
 4. Clean the abraded surfaces with lacquer thinner and wipe dry.
 5. Insert 3M™ Automix™ Semi-Rigid Plastic Parts Repair 200mL syringe into 3M™ Applicator Gun.
 6. Remove end seal cap.
 7. Extrude a small amount of product until both parts dispense equally.
 8. Attach 3M™ Mixing Nozzle to syringe and lock in place with retaining collar.
 9. Apply adhesive to one of the surfaces to be bonded.
 10. Clamp parts together and immediately remove adhesive "squeeze out" with a putty knife or similar tool. Allow 30 minutes cure time before removing clamps.
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Applications

Bonding small backer strips and patches to the back side of SMC and FRP repairs. The front side should be filled with PN 05885 Automix™ EZ Sand Rigid Parts Repair.

Storage and Handling

HANDLING

Avoid eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Avoid contact with water to prevent potentially violent reaction or fire. Contents may be under pressure, open carefully.

STORAGE

Store away from acids. Store away from heat. Store out of direct sunlight. Keep container in well-ventilated area.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product . Hazardous polymerization may occur. May cause allergic skin reaction. May cause allergic respiratory reaction. Contains a chemical or chemicals which can cause cancer. Always wear gloves, eye protection, appropriate respiratory protection, and work in a well-ventilated area.

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).

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Author: Brett D. Einerson/US-Corporate/3M/US