

# 3M Body Repair Materials Guide

## ADHESIVES

Product Name	Part No.	Size	Color	Chemistry	Work Time	Clamp/Handling Time	Cure Time
3M™ Panel Bonding Adhesive DTM bonder	38315	50 mL	Black	Epoxy	90 min. @ 70°F 45 min. @ 90°F (May be accelerated with heat)	4 hrs. (May be accelerated with heat)	24 hrs.
	08115	200 mL					
	58115	450 mL DMS					
3M™ Panel Bonding Adhesive (GM and Chrysler Approved)	08116	200 mL	Black	Epoxy	2 hrs. @ 70°F 1 hr. @ 90°F (May be accelerated with heat)	6 hrs. (May be accelerated with heat)	24 hrs.
3M™ Composite and Metal Bonding Adhesive - 35, DTM bonder	08219	200 mL	Green	Urethane	35 min.	90 min.	3 hrs.
3M™ Quick Fix Adhesive Kit with Accelerator	08224	0.7 oz. Bottle/ 2 oz. Accelerator	Clear	Cyanoacrylate	1 min.	2 min.	1 hr.
3M™ Universal Adhesive	08107	50 mL	Clear	Epoxy	3 min.	30 min.	1 hrs.
	08217	200 mL					
3M™ Universal Adhesive	08223	200 mL	Black	Urethane	3 min.	30 min.	4 hrs.
3M™ Universal Adhesive	08214	200 mL	Black	Urethane	10 min.	1 hr.	4 hrs.
3M™ Channel Bonding & Sidelite Adhesive	08641	50 mL	Black	Epoxy	5 min.	1 hr.	24 hr.

Cure Time	Cure Temperature				
	50°F	73°F	100°F	150°F	200°F
10 min.				262	3061
20 min.			22	1562	3707
40 min.			32	3316	3786
1 hr.			172	3569	
2 hr.			1382	3833	
4 hr.		78	2836		
5 hr.		569			
6 hr.		865			
8 hr.	24	1756			
16 hr.	592	2920			
1 day	1413	3273			
7 days	2774	3935			

Video	Product Name	Product Name
	08115 3M™ Panel Bonding Adhesive	08116 3M™ Panel Bonding Adhesive

  

Product Sample	
08217 3M™ Universal Adhesive (Clear)	08223 3M™ Universal Adhesive

## PLASTIC REPAIR

Product Name	Part No.	Size	Color	Chemistry	Work Time	Sand Time / Handling Time	Cure Time	Features
3M™ Multi Purpose Adhesive - 15	35887	50 mL	Grey	Epoxy	5 min.	15 min.	24 hrs.	<ul style="list-style-type: none"> <li>Flexible for use on bumper covers</li> <li>Excellent sandability</li> <li>For use on exterior bumper covers</li> </ul>
	05887	200 mL						
	55887	600 mL DMS						
3M™ EZ Fix Flexible Bumper Patch	05888	4 in x 8 in	Black	TPO	N/A	N/A	N/A	<ul style="list-style-type: none"> <li>Excellent adhesion properties</li> <li>No cure time delay</li> <li>Effective on many plastics where additional reinforcement is needed</li> </ul>
3M™ Super Fast Repair Adhesive	04747	50 mL	Clear	Urethane	20 sec.	5 min.	1 hr.	<ul style="list-style-type: none"> <li>A super-fast setting adhesive and repair material for rebuilding tabs and fixing broken eyelets</li> <li>Excellent gap-filling capabilities and withstands a wide range of temperatures, unlike cyanoacrylate</li> </ul>
	04248	200 mL						
	04247	200 mL						
3M™ Semi-Rigid Plastic Repair	34240	50 mL	Black	Urethane	50 sec.	15 min.	1 hr.	<ul style="list-style-type: none"> <li>Very rigid material to reinforce back side</li> </ul>
	04240	200 mL						
3M™ Semi-Rigid Parts Repair - 1	08235	200 mL	Black	Urethane	50 sec.	30 min.	1 hr.	<ul style="list-style-type: none"> <li>Xenoy, RRIM, GTX, PPO, ABS and a variety of other semi-rigid plastics and bumper covers</li> </ul>
3M™ Semi-Rigid Parts Repair - 3	08237	200 mL	Black	Urethane	3 min.	30 min.	4 hrs.	<ul style="list-style-type: none"> <li>Reinforcement strips, patch bonding, small bonding applications fix Xenoy, RRIM, GTX, PPO, ABS and a variety of other semi-rigid plastics and bumper covers.</li> </ul>

Video	Product Sample	Video	Product Sample
	05887 3M™ EZ Sand Flexible Parts Repair		04247 3M™ Super Fast Repair Adhesive
	05888 3M™ EZ Fix Flexible Bumper Patch		04240 3M™ Semi-Rigid Plastic Repair

## SMC/FIBERGLASS REPAIR

Product Name	Part No.	Size	Color	Chemistry	Work Time	Sand Time / Handling Time	Cure Time	Features
3M™ EZ Sand Rigid Parts Repair	05885	200 mL	Blue	Epoxy	8 min.	30 min.	4 hrs. (For best results heat set)	<ul style="list-style-type: none"> <li>Repair SMC, FRP, and other rigid plastic parts</li> <li>Can be heat set (150 F for 15 minutes)</li> <li>Can be primed and painted in 30 minutes</li> </ul>
	08275	400 mL						
	55885	600 mL DMS						
3M™ EZ Sand Rigid Parts Repair Kit	05883	5 fl. oz. Tube	Blue	Epoxy	10 min.	30 min.	4 hrs.	<ul style="list-style-type: none"> <li>Excellent sandability and adhesion</li> </ul>
3M™ SMC/Fiberglass Repair Adhesive - 1	08243	200 mL	Black	Urethane	50 sec.	5 min.	10 min.	<ul style="list-style-type: none"> <li>Adhere backup strip and patches to SMC/FRP (traditional fiberglass)</li> <li>Quick cure makes it ideal for small repair applications</li> </ul>
	08270	400 mL						
3M™ SMC/Fiberglass Repair Adhesive - 3	08271	400 mL	Green	Urethane	3 min.	10 min.	30 min.	<ul style="list-style-type: none"> <li>Reinforcement strips, patch bonding, small bonding applications fix Xenoy, RRIM, GTX, PPO, ABS and a variety of other semi-rigid plastics and bumper covers.</li> </ul>
3M™ SMC/Fiberglass Repair Adhesive - 4	08227	200 mL	Black	Epoxy	4 min.	30 min.	2 hrs.	<ul style="list-style-type: none"> <li>Adhere backup strips and patches to SMC/FRP (traditional fiberglass)</li> </ul>
3M™ SMC/Fiberglass Repair Adhesive - 10	08272	400 mL	Green	Urethane	10 min.	30 min.	1 hr.	<ul style="list-style-type: none"> <li>Bond SMC and FRP to each other and to primed metal frames</li> </ul>
3M™ SMC/Fiberglass Repair Adhesive - 35	08273	400 mL	Green	Urethane	35 min.	90 min.	3 hrs.	<ul style="list-style-type: none"> <li>Used to bond SMC and FRP body panels to each other or to primed metal frames (Preferred adhesive for GM 200 series vans)</li> </ul>
3M™ SMC/Fiberglass Repair Adhesive	08274	400 mL	Black	Epoxy	90 min. @ 70°F 45 min. @ 90°F (May be accelerated with heat)	4 hrs. (May be accelerated with heat)	24 hrs.	<ul style="list-style-type: none"> <li>A high performance two component epoxy adhesive with excellent sag resistance. Used to bond SMC and FRP (traditional fiberglass) body panels to each other and to metal frames</li> </ul>
3M™ Fiberglass Matting Adhesive	08277	400 mL	Green	Urethane	10 min.	45 min.	24 hrs.	<ul style="list-style-type: none"> <li>Used to saturate fiberglass cloth when preparing backing patches</li> <li>Self-leveling to fill cracks, channels and areas that restrict the application of an adhesive bead</li> </ul>

Video	Product Sample	Video	Product Sample
	05885 3M™ EZ Sand Rigid Parts Repair		08219 3M™ SMC/Fiberglass Panel Adhesive-35
	08271 3M™ SMC/Fiberglass Repair Adhesive-3		08277 3M™ Fiberglass Matting Adhesive

## SOUND DEADENING / FOAMS

Product Name	Part No.	Size	Color	Chemistry	Work Time	Cure Time	Features
3M™ NVH Dampening Material (Noise, Vibration, Harshness)	04274	200 mL	Black	Urethane	60 min.	24 hrs.	<ul style="list-style-type: none"> <li>Ideal 2-part urethane product for replacing factory NVH sealants and foams</li> <li>Remains pliable, yet sturdy and will not degrade</li> <li>Does not expand</li> </ul>
3M™ Flexible Foam	08463	200 mL	Grey	Urethane	40 sec.	1 hr.	<ul style="list-style-type: none"> <li>Stays flexible, fills and bonds</li> <li>Designed to replace flexible foams in OEM applications such as trunks, door cavities, door skins and roof beams</li> <li>Works well for quarter panel applications or wherever "flexible" factory foam is found</li> </ul>
3M™ Rigid Pillar Foam	08458	200 mL	Tan	Urethane	1 min.	1 hr.	<ul style="list-style-type: none"> <li>Rigid foam, fills and bonds</li> <li>Foams in place to fill posts, pillars and automotive body cavities</li> <li>Can be used for OEM replacement of rigid foams</li> </ul>
3M™ Sound Deadening Pads	08840	19 in x 19 in (500 mm x 500 mm)	Black	Pad	N/A	N/A	<ul style="list-style-type: none"> <li>Conformable, self adhesive backing to be applied in floor pans, hood deck lids, etc.</li> <li>OEM matching diamond pattern</li> <li>Paintable</li> </ul>

Video	Product Sample	Video	Product Sample
	08463 3M™ Flexible Foam		08458 3M™ Rigid Pillar Foam
	04274 3M™ NVH Dampening Material		08840 3M™ Sound Deadening Pads

## SEALERS (Note: 3M Seam Sealers are not to be used in direct contact with acid or one-part aerosol can primers.)

Product Name	Part No.	Size	Color	Chemistry	Work Time	Paintable	Features
3M™ Multi Purpose Adhesive 15	35887	50 mL	Grey	Epoxy	5 min.	15 min.	<ul style="list-style-type: none"> <li>Must be applied over primer</li> <li>Provides great rounded edges</li> <li>Matches OEM seams, semi flowable, sandible, flexible</li> </ul>
	05887	200 mL					
	55887	600 mL DMS					
3M™ Heavy-Bodied Seam Sealer	08308	200 mL	Black	Epoxy	6 min.	15 min.	<ul style="list-style-type: none"> <li>Heavy-bodied seam sealer for matching OEM seams on floor pans, door skins, truck beds, or any cosmetic seam where a non-sagging, non-flowing sealer is needed</li> </ul>
	58308	600 mL DMS					
3M™ Bare-Metal Seam Sealer	08310	200 mL	Beige	Epoxy	10 min.	15 min.	<ul style="list-style-type: none"> <li>Apply directly over "bare" or primed metal</li> <li>Heavy-bodied seam sealer for use on vertical or horizontal seams to match OEM sealers</li> </ul>
3M™ Self-Leveling Seam Sealer	08307	200 mL	Clear	Epoxy	8 min.	15 min.	<ul style="list-style-type: none"> <li>Designed for matching OEM seams on roof ditches and rear body panels including tail light areas</li> </ul>
3M™ Factory Match Seam Sealer	08323	200 mL	Black	Urethane	10 min.	45 min.	<ul style="list-style-type: none"> <li>Flows slightly and softens on the edges without tooling, giving a rounded appearance</li> <li>Use to duplicate factory door skin seams as well as various other factory seams</li> </ul>
3M™ Controlled Flow Seam Sealer	08329	200 mL	Black	Urethane	3 min.	40 min.	<ul style="list-style-type: none"> <li>Flexible urethane for sealing channels and seams - excellent for sloped areas</li> <li>Will run approximately 1-1/2 to 2 inches when applied at a 45 degree angle</li> </ul>
3M™ MSP Seam Sealer (Flex Pack) Now for direct to metal applications	08369/ 08370	310 mL	White	MSP	5 - 10 min.	30 min.	<ul style="list-style-type: none"> <li>Apply directly over "bare" or primed metal</li> <li>High-quality, heavy bodied, general purpose, moisture curing seam sealer - not for use on lacquer paints</li> <li>Designed for interior and exterior body joints - may be primed or painted immediately or up to 72 hours</li> </ul>
3M™ One-Part Seam Sealer (Foil Pack) Now for direct to metal applications	08360/ 08361/ 08364	310 mL	White/Grey/Beige	Urethane	5 - 10 min.	30 min.	<ul style="list-style-type: none"> <li>Apply directly over "bare" or primed metal</li> <li>One-part moisture curing urethane seam sealer that can be painted</li> </ul>
3M™ Urethane Seam Sealer (Cartridge) Now direct to metal applications	08362/ 08365/ 08367/ 08368	310 mL	Grey/Beige/Black/White	Urethane	5 - 10 min.	30 min.	<ul style="list-style-type: none"> <li>Apply directly over "bare" or primed metal</li> <li>Non-shrinking, non-cracking-able</li> <li>Fills large voids</li> </ul>
3M™ MSP Sprayable Seam Sealer (Cartridge)	08374	310 mL	Grey	MSP	5 - 10 min.	30 min.	<ul style="list-style-type: none"> <li>A high-performance non-shrinking, non-cracking general purpose seam sealer that can be caulked</li> <li>For use on door skins, hemming flanges, quarter panels and floor and truck pans</li> </ul>

Video	Product Sample	Video	Product Sample
	08310 3M™ Bare-Metal Seam Sealer		08308 3M™ Heavy-Bodied Seam Sealer
	08323 3M™ Factory Match Seam Sealer		08307 3M™ Self-Leveling Seam Sealer
	08329 3M™ Controlled Flow Seam Sealer		

## ADHESIVE REMOVERS

Product Name	Part No.	Size	Features / Applications	VOC Compliance
3M™ General Purpose Adhesive Cleaner	08987	15 oz. Aerosol	<ul style="list-style-type: none"> <li>Provides easy cleanup of most types of adhesives</li> <li>Quickly removes waxes, road tars, grease, oil and similar materials</li> <li>Will not harm most thoroughly cured automotive paint, vinyl or fabrics when properly used</li> </ul>	<ul style="list-style-type: none"> <li><b>VOC Regulated Product:</b> Not for sale in California, most OTC States, some LADCO States. Please consult State and Local Air Quality Regulations.</li> </ul>
	08984	Quart		
3M™ Specialty Adhesive Remover	38987	15 oz. Aerosol	<ul style="list-style-type: none"> <li>Removes two-component system adhesives</li> </ul>	<ul style="list-style-type: none"> <li><b>VOC compliant for intended application only as of date of manufacture.</b></li> </ul>
3M™ General Purpose Adhesive Remover	38983	12 oz. Aerosol	<ul style="list-style-type: none"> <li>Removes adhesive residue (from bumper stickers, parts labels, attachment tape, etc.), trim and adhesive overspray</li> </ul>	<ul style="list-style-type: none"> <li><b>VOC compliant for intended application only as of date of manufacture.</b></li> </ul>
3M™ Adhesive Remover	03618	12 oz. Aerosol	<ul style="list-style-type: none"> <li>Quickly removes wax and adhesive residue</li> <li>Will not harm most well-cured automotive paints (be sure to test on plastic surfaces)</li> <li>Suitable for vinyl and glass surfaces</li> </ul>	<ul style="list-style-type: none"> <li><b>VOC Regulated Product:</b> Not for sale in California, most OTC States, some LADCO States. Please consult State and Local Air Quality Regulations.</li> </ul>
	38080	Gallon		

## APPLICATORS

Product Name	Part No.	Size	Features / Applications
3M™ Dynamic Mixing Applicator	05846	All DMS Products	<ul style="list-style-type: none"> <li>Professional pneumatic applicator to dispense DMS products</li> </ul>
3M™ Performance Pneumatic Applicator	08280	400 mL	<ul style="list-style-type: none"> <li>Pneumatic applicator for large volume cartridges</li> </ul>
3M™ Performance Manual Applicator	08284	400 mL	<ul style="list-style-type: none"> <li>Manual applicator for dispensing large volume cartridges</li> </ul>
3M™ Performance Pneumatic Applicator	09930	200 mL	<ul style="list-style-type: none"> <li>Pneumatic - For 200 mL product</li> </ul>
3M™ Performance Manual Applicator	08117	200 mL	<ul style="list-style-type: none"> <li>Manual - For 200 mL product</li> </ul>
3M™ Manual Cartridge Applicator	08571	200 mL	<ul style="list-style-type: none"> <li>Economy Line Applicator with heavy duty construction</li> </ul>
3M™ Performance Manual Applicator	08190	50 mL	<ul style="list-style-type: none"> <li>Manual applicator designed to use 1:1 and 2:1 50 mL products</li> </ul>
3M™ Flexible Pneumatic Package Applicator	08399	310 mL	<ul style="list-style-type: none"> <li>Fully enclosed and pneumatic to dispense single component products</li> </ul>
3M™ Flexible Package Applicator	08398	310 mL	<ul style="list-style-type: none"> <li>A fully enclosed, all metal, rod driven, friction feed applicator gun for use with all 310 mL or smaller foil flexible packages</li> </ul>
3M™ Single Component Cartridge Pneumatic Applicator	08990	310 mL	<ul style="list-style-type: none"> <li>Designed for smooth application of 310 mL seam sealers</li> </ul>
3M™ Flex Pack Nozzle	08188	310 mL	<ul style="list-style-type: none"> <li>For use with one-part flex pack seam sealers</li> </ul>
3M™ Flex Pack Heavy Duty Applicator	08991	450 mL	<ul style="list-style-type: none"> <li>All metal, rod driven applicator for 450mL products 18:1 ratio</li> </ul>

## ACCESSORIES

Product Name	Part No.	Size	Features / Applications
3M™ Dynamic Mixing Nozzle	05847	50:1	<ul style="list-style-type: none"> <li>DMS nozzle for filler and related products</li> </ul>
3M™ Dynamic Mixing Nozzle	55847	2:1 & 1:1	<ul style="list-style-type: none"> <li>DMS nozzle for adhesives, sealers and plastic repair products</li> </ul>
3M™ Dynamic Mixing Nozzle Extension	58207	50:1, 2:1, 1:1	<ul style="list-style-type: none"> <li>Used with DMS nozzles to provide a thinner bead and to get into hard to reach areas</li> </ul>
3M™ Static Mixing Nozzle	08193-94	200 & 400 mL	<ul style="list-style-type: none"> <li>3/8" nozzle for all 200 mL and 400 mL products / 8194 - bulk pack (50)</li> </ul>
3M™ OEM Seam Sealer Tips	08201-05	200 & 400 mL	<ul style="list-style-type: none"> <li>A versatile assortment of five different tips that reproduce many OEM seam sealer beads used today</li> <li>Saves time, labor and costly redos while trying to reproduce the factory OEM seams</li> </ul>
3M™ OEM Seam Sealer Tip Adapter	08206	310 mL	<ul style="list-style-type: none"> <li>For use with the Urethane Seam Sealers and MSP Seam Sealers</li> </ul>
3M™ Bulk Nozzle Rack	02576	200 mL	<ul style="list-style-type: none"> <li>Used to hold and store boxes PNO8194, O8187, 05847 and 55847</li> </ul>
3M™ Threaded Cartridge Nozzle	08187	310 mL	<ul style="list-style-type: none"> <li>50 Threaded cartridge nozzles to use with single component cartridges</li> </ul>
3M™ Polyolefin Adhesion Promoter	05907	16 oz. Aerosol	<ul style="list-style-type: none"> <li>Provides excellent adhesion of filler materials to TPO type substrates (Type II)</li> <li>3M Compatible with all 3M Flexible, Semi-Rigid and TPO repair products</li> </ul>
3M™ Plastic Contour Sheet	04903	5 in x 12 ft	<ul style="list-style-type: none"> <li>Contour sheet to be used while creating new plastic tabs</li> </ul>
3M™ Reinforcement Patch	04904	5 in x 12 ft	<ul style="list-style-type: none"> <li>Used for reinforcing the backside of plastic repairs</li> </ul>
3M™ Automotive Adhesion Promoter	06396	25 Packs	<ul style="list-style-type: none"> <li>Liquid primer packaged in convenient, single-use applicator packets</li> <li>Strongly recommended for use with all automotive attachment tapes for the repair of large exterior body side moldings, metal trim, claddings, etc.</li> </ul>
Dynatron™ Fiberglass Mat	688	8 sq. ft.	<ul style="list-style-type: none"> <li>Designed to be used with 3M™ Fiberglass Resin (PN 05833) or 3M™ Short Strand Fiberglass Reinforced Filler (PN 05815 or 05816) to patch larger holes in metal, cracks, tears, punctures and splits in fiberglass panels</li> </ul>
Dynatron™ Fiberglass Cloth	699	8 sq. ft.	<ul style="list-style-type: none"> <li>For reinforcing fiberglass and metal repairs</li> <li>Excellent for large repairs where extra reinforcement is needed</li> </ul>
3M™ Shop Rack	02530	200 & 400 mL	<ul style="list-style-type: none"> <li>Shop rack for all 200 and 400 mL syringes - Holds 8 open or closed syringes</li> <li>Rack holds 2 applicator guns</li> </ul>

facebook "LIKE" us on FACEBOOK  
www.FACEBOOK.COM/3MCollision

YouTube Subscribe to our channel to watch comprehensive instructional videos  
www.YOUTUBE.COM/3Mautobodyrepair



Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy, and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

For health and safety information please refer to product labels and Safety Data Sheets.

3M Automotive Aftermarket  
3M Center Bldg, 223-6N-01,  
St. Paul, MN 55144-1000 U.S.A.  
1-877-MMM-CARS (666-2277)  
3MCollision.com  
Please recycle. Printed in U.S.A.  
© 3M 2014. All rights reserved.  
3M and Dynatron are trademarks of 3M Company.  
60-4402-7782-4