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**Technical Data Sheet 08217**

**Public**

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## 3M™ Automix™ Universal Adhesive

### Data Sheet

**3M Part No.(s)**                      **3M Part Descriptor (s)**  
08217                                      3M™ Automix™ Universal Adhesive

**3M Fax on Demand Identification Number :** 08217

#### Description

Two-part epoxy used as a general purpose adhesive for metal, glass and plastic. This clear, non-yellowing adhesive has a 3 minute work time, 25 minute handling time, and 60 minute cure time.

#### Features, Advantages, Benefits

<b>Features</b>	Strong, durable adhesive Self-mixing
<b>Advantages</b>	Works on a wide variety of substrates Proper product ratio everytime
<b>Benefits</b>	Excellent for applications where clear adhesive is required Increases productivity

#### Typical Physical Properties

<b>Container</b>	200 mL cartridge
<b>Base</b>	Epoxy
<b>Density lbs/Gallon (Appx.)</b>	9.6 lbs/gal.
<b>Color</b>	Opaque
<b>Flash Point - °F</b>	Not applicable
<b>Viscosity (CPS) Brookfield Viscometer</b>	8,000 - 15,000 centipoise
<b>Solids Content (Appx.)</b>	100%
<b>Consistency</b>	Paste
<b>Solvent</b>	None
<b>Service Temperature - °F</b>	-20 to 180 deg F
<b>Propellant</b>	N/A

#### Product Uses

Strong, durable adhesive and works on a variety of substrates. Excellent for use in applications where a clear adhesive is required.

#### Performance Properties

Work time:	5 min
Clamp time:	10 min
Cure time:	1 hour

## Handling and Application Information

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### Directions for Use

1. Size all parts for proper alignment.
  2. Clean plastic or metal surfaces to be bonded.
  3. Abrade plastic surfaces to be bonded with grade P80 3M™ Hookit™ Gold Film. Primed metal surfaces should be scuffed with Scotch-Brite™ General Purpose Hand Pad.
  4. Wipe with a clean rag. Then clean all abraded surfaces a second time with lacquer thinner.
  5. Insert 3M™ Automix™ Universal Adhesive cartridge into an appropriate applicator gun (such as PN 8117 or 9930).
  6. Remove end seal cap.
  7. Extrude a small amount of adhesive until both parts dispense equally.
  8. Attach 3M™ Mixing Nozzle to syringe. Lock in place with retaining collar.
  9. Apply a sufficient amount of adhesive to one surface.
  10. Assemble as soon as possible - no to exceed 3 minutes after applying adhesive. Clamp if necessary. Allow material to cure before continuing repair. Typically 25 minutes is sufficient for handling strength.
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### Applications

Strong, durable adhesive and works on a variety of substrates. Excellent for use in applications where a clear adhesive is required.

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### Storage and Handling

#### HANDLING

Avoid eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining. Avoid breathing of vapors, mists or spray. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Avoid contact with oxidizing agents.

#### STORAGE

Store away from acids. Store away from oxidizing agents.

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### Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product . May cause severe eye irritation. May cause severe skin irritation. May cause allergic skin reaction.

### Country

US

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

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### 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.**

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### 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 08217**

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