$3M^{TM}$ Automix TM SMC/Fiberglass Panel Adhesive 08219/60-9800-2976-7

Directions for Use:

3MTM AutomixTM SMC/Fiberglass Panel Adhesive is designed to bond and seal automotive plastics (SMC, FRP, Urethane) and metal.

NOTE: 3MTM AutomixTM SMC/Fiberglass Panel Adhesive should be used at 65°F or above.

- 1. Size all parts for proper alignment. Clean and prime bare metal surfaces with a two-part primer.
- 2. Clean the areas to be bonded with soap and water. Next, use 3M[™] General Purpose Adhesive cleaner (N. 08984, 08986 or 08987 aerosol) or use 3M[™] Super Fast Adhesive cleaner (N. 08215) to remove any grease, wax and/or tar. Read manufacturer's hazard communication and follow manufacturer's recommended guidelines for safe handling of the above chemical products.*
- 3. Abrade surface to be bonded with grade P80 3MTM HookitTM Gold film.
- 4. Wipe with a clean rag. Then clean all abraded surfaces a second time with lacquer thinner.
- 5. Insert 3MTM AutomixTM SMC/Fiberglass Panel Adhesive 6 fl. oz. syringe into 3MTM Applicator Gun (N. 08198) or 3MTM AutomixTM SMC/Fiberglass Panel Adhesive 200 mL syringe into MixPac® Applicator Gun (N. 08117-manual or N. 09930-pneumatic).
- 6. Remove end seal cap.
- 7. Extrude a small amount of adhesive until both parts dispense equally.
- 8. Cut end of mixing nozzle to provide desired bead size.
- 9. Attach 3MTM Mixing Nozzle (N. 08193) to syringe. Lock in place with retaining collar.
- 10. Apply adhesive.
- 11. Assemble as soon as possible not to exceed 25 minutes after applying adhesive. Clamp if necessary. Allow material to cure before continuing repair. Typically 2 hours is sufficient for handling strength.

*3MTM General Purpose Adhesive Cleaner, (N. 08984, 08986) has a VOC of 816 grams per liter (6.81 lbs. per gallon). 3MTM General Purpose Adhesive cleaner, (N. 08987-aerosol) has a VOC of 738 grams per liter (6.16 lbs. per gallon). 3MTM Super Fast Adhesive Cleaner (N. 08215) has a VOC content of 849 grams/liter (7.08 lbs. per gallon). Local air quality regulations may regulate or prohibit the use of surface preparation and clean-up materials based on VOC content. Consult your local air quality regulations.

Contact your local 3M Automotive Aftermarket Division Sales Representative for any additional information that may be needed.

3M Automotive Aftermarket Division

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