



Public

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3M™ Automix™ SMC/Fiberglass Adhesive

Data Sheet

3M Part No.(s) **3M Part Descriptor(s)**
08227 3M™ Automix™ SMC/Fiberglass Adhesive

3M Fax on Demand Identification Number : 08227

Description

Two-part epoxy used to adhere backup strips and patches to SMC and FRP (traditional fiberglass). With a 4 minute work time.

Features, Advantages, Benefits

Features	Strong two part epoxy adhesive, automatic mixing delivery system.
Advantages	medium work time for larger repairs,
Benefits	Excellent choice for bonding strips and backer patch applications.

Typical Physical Properties

Container	200ml Automix™ cartridge	
Base	Epoxy	
Density lbs/Gallon (Appx.)	9.80 - 10 lbs per gallon	
Color	white/black	
Flash Point - °F	N/A	
Viscosity (CPS) Brookfield	21 - 27 secs (Pressflow Viscosity) Part A	16 - 24 secs (Pressflow Viscosity) part B
Viscometer	Part A	
Solids Content (Appx.)	100%	
Consistency	paste	
Solvent	none	
Service Temperature - °F	-20 to 180 deg F	
Propellant	N/A	

Product Uses

Bonding of backer strips and patches to the back side of SMC and FRP repairs. Head lamp buckets, and other composite to composite bonding requirements. The front side (cosmetic portion) of the repair should be filled with PN 05885 Automix™ EZ Sand Rigid Parts Repair

Performance Properties

Work time: 4 min.
Clamp time: 30 min.
Cure time: 2 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 P.N.'s 08984, 08986, or 08987 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, 40, or 80 abrasive, either by hand or machine. Removing any damaged, or loose composite material from the bonding site.
3. Wipe the areas with a clean, dry rag and blow off with clean, dry, compressed air. Do not solvent wipe.
4. Insert 3M™ Automix™ SMC/Fiberglass Adhesive 200mL syringe into 3M™ Applicator Gun.
5. Remove end seal cap.
6. Extrude a small amount of product until both parts dispense equally.
7. Attach 3M™ Mixing Nozzle to syringe and lock in place with retaining collar.
8. Apply adhesive to one of the surfaces to be bonded.
9. Clamp parts together and immediately remove adhesive "squeeze out" with a putty knife or similar tool. Allow 30 minutes cure time before removing clamps.
10. If the repair requires a cosmetic finish (sanded and painted) use 3M™ Automix™ EZ Sand Rigid Parts Repair material PN 05885 on the cosmetic portion of the repair, following directions for use for 05885.

* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

Applications

Bonding of backer strips and patches to the back side of SMC and FRP repairs. Head lamp buckets, and other composite to composite bonding requirements. The front side (cosmetic portion) of the repair 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.

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.

Country

US

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For Additional Health and Safety Information

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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 08227

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