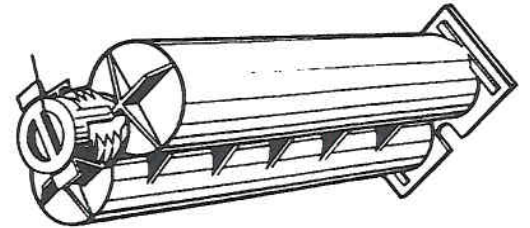


3M™ SMC/Fiberglass Repair Adhesive - 6 fl.oz. 3M™ SMC/Fiberglass Repair Adhesive - 200 mL (Work Time - 50 Seconds)

N. 08242 and 08243

Directions for Use



3M™ Automix Rigid Parts Repair is a two-part urethane repair material designed to be used as both a structural adhesive and as a cosmetic filler when repairing SMC and fiberglass.

Directions for use (as an adhesive)

1. 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.*
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.
IMPORTANT: Do not use enamel reducer, wax and grease removers, or recycled lacquer thinner.
5. Insert 3M™ Automix™ SMC/Fiberglass Repair Adhesive 6 fl. oz. syringe into 3M™ Applicator Gun (N. 08198) or 3M™ Automix™ SMC/Fiberglass Repair 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 product until both parts dispense equally.
8. Attach 3M™ Mixing Nozzle (N. 08214) 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.

PRINTER SPECS for Automix
SMC Fiberglass Adhesive
PN.8242 and PN.8243
INSTRUCTION SHEET

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All Repairs
(continued)

1. Wipe repair area with a clean, dry rag and blow off with compressed air.
IMPORTANT: Do not solvent wipe.
2. Insert 3M™ Automix™ SMC/Fiberglass Repair Adhesive 6 fl. oz. syringe into 3M™ Applicator Gun (N. 08198) or 3M™ Automix™ SMC/Fiberglass Repair Adhesive 200 mL syringe into MixPac® Applicator Gun (N. 08117- manual or N. 09930- pneumatic).
3. Remove end seal cap.
4. Extrude a small amount of product until both parts dispense equally.
NOTE: If you choose not to use a mixing nozzle, extrude the amount of product required, and mix by hand to a uniform color using a clean spreader and then go to step 10.
5. Attach 3M™ Mixing Nozzle (N. 08214) to syringe and lock in place with retaining collar.
6. Apply adhesive material to the repair area using a plastic spreader.

*3M™ General Purpose Adhesive Cleaner, (N. 08984 and 08986) has a VOC of 816 grams per liter (6.81 lbs. per gallon). 3M™ General Purpose Adhesive Cleaner, (N. 08987-Aerosol) has a VOC of 738 grams per liter (6.16 lbs. per gallon). 3M™ 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 cleanup materials based on VOC content. Consult your local air quality regulations.

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