



Public

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Automix™ Fast Cure Epoxy

Data Sheet

3M Part No.(s) **3M Part Descriptor(s)**
08107

3M Fax on Demand Identification Number:

Description

A clear, fast-curing, high-strength epoxy. Will bond a variety of automotive materials including plastics, metal, and rubber.

Features, Advantages, Benefits

Features

- Clear
- Fast Curing

Advantages

- High Strength

Benefits

Typical Physical Properties

Container	1.6 oz. Duo-Pak
Base	Epoxy
Color	Clear
Solids Content (Appx.)	100%
Consistency	Thin Syrup
Work Life	4 minutes
Handling Strength	20 minutes @ 75°F

Product Uses

Performance Properties

Overlap Shear

Overlap shear strengths were measured in pounds per square inch. Test samples were conditioned 24 hours before testing. Test samples were tested on an Instron Tester at a separation rate of 0.1" per minute for metal, 2" per minute for plastic and 20" per minute for rubber.

<u>Substrate</u>	<u>Overlap Shear Strength (psi)</u>
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Steel/Steel	1100
SBR Rubber/Steel	36
Neoprene/Steel	30
ABS/ABS	490
PVC/PVC	400

T-Peel

T-Peel strengths were measured on 1" wide bonds. The bond thickness was 0.004". The jaw separation rate was 20 inches per minute.

<u>Substrate</u>	<u>T-Peel Pounds Per Inch Width</u>
Aluminum/Aluminum	2
Steel/Steel	2

Handling and Application Information

Directions for Use

1. Surfaces should be clean and dry.
2. Attach mixing nozzle P.N. 08190 to Duo-Pak.
3. Place Duo-Pak in Application Cup.
4. Apply adhesive to one surface.
5. Join bonding surfaces within 3-5 minutes after application.
6. Prevent parts from moving during cure.

Cleanup:

Excess adhesive and equipment may be cleaned prior to curing with toluene or ketone solvents*.

*NOTE: These solvents are flammable! When using solvents, extinguish all sources of ignition in the area and observe proper precautionary measures for handling such materials.

Applications

Metal, Plastics, Rubber

Storage and Handling

Store at room temperature. Rotate stock on a "first-in-first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

Country

US

This document is public. It may be distributed.

Important Notice to Purchaser

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* If 'Directions for Use' reference P.N.'s 8984, 8986, or 8987, please read below.

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.

LIMITATION OF REMEDIES AND LIABILITY: If the 3M product is proved to be defective, **THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT.**

3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

For Additional Health and Safety Information

See Material Safety Data Sheet (Fax on Demand 1-800-305-0419), or call: **3M Automotive Aftermarket Division**
3M Center, Building 223-6N-01
Phone: 877-MMM-CARS (877-666-2277)

3M Fax on Demand Identification Number

Reference: Goto Ref

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