



# Flexible Foam

## 08463

Technical Data

August 2018

3M Part Numbers	3M Part Descriptor
08463	3M™ Flexible Foam

### Product Description

3M™ Flexible Foam is an easy and effective way to produce a replacement of OEM flexible foams used in automotive applications. Working time of 40 seconds ensures prompt foam activation in closed cavities and tight spaces, full cure is one hour. This two-part urethane foam-in-place material is packaged in a 200mL cartridge utilizing static mixing for direct application. One 200mL cartridge expands to approximately 73 cubic inches (185 cubic centimeters).

Note: It is a best practice to keep OEM NVH material in place to maintain proper spacing between panel structure and skin. For this type repair use 3M™ NVH Material (PN 4274) on the original foam sealing and securing it to the new replacement panel during installation.

### Features

- Designed for professional aftermarket collision repair use
- Replaces OEM Flexible Foam
- 40 Second Work Time (Foam Forms)
- Remains Flexible After Full Cure

### Typical Physical Properties

NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Container	200mL Duo Syringe Cartridge	
Base	Urethane	Curative
Color	Black	Amber/Brown
Flash Point	>300°F (>149°C)	
Solids Content (Approx.)	100%	
Consistency	Liquid prior to mixing	
Service Temperature	-20°F to 180°F (-20°C to 82°C)	
Foam Density (unrestricted expansion)	~ 1.1 lb./gal.	

### Typical Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 73°F (23°C) and are considered typical values.

**WORK TIME:** 40 Seconds

**CLAMP TIME:** N/A

**CURE TIME:** 1 hour

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### Product Uses

Generally used in automotive body repair when replacing flexible foam located inside body structures such as, to areas including door intrusion beam, roof bows, body side panels and other auto body closed cavities requiring flexible foam for NVH reduction.

Use with the following accessories:

- 3M™ Manual Applicator (PN 08571 or PN 08117)
- 3M™ Pneumatic Applicator (PN 09930)
- 3M™ Static Mix Nozzle (PN 08193, 6-bag)
- 3M™ Static Mix Nozzle (PN 08194, 50-box)

**For professional use only. Not intended for retail sale.**

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### Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 73°F (23°C) and are considered typical values.

#### **WORK TIME:**

40 Seconds

#### **CLAMP TIME:**

N/A

#### **SAND TIME:**

N/A

#### **CURE TIME:**

1 hour

3M™ Flexible Foam PN 08463 has been tested under SAE J 369 (section 3) and is rated SE/0 (self-extinguishing).

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### Directions for Use

#### **CARTRIDGE PREPARATION**

1. Insert the cartridge into the applicator and remove the collar and plug. Discard a small amount of material to a disposable surface and reinstall the nozzle and collar.
2. Dispense a small amount of material through the mixing nozzle on to a disposable surface, preparation is now complete. Work quickly after this step as foaming occurs in 40 seconds.

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### Directions for Use (continued)

### STANDARD SOUND DEADENER APPLICATION

1. Cover areas such as interior trim to prevent accidental spillage or damage
2. Some applications require the use of a damming material, if the OEM material has been damaged insert a suitable substitute to form a dam maintaining proper positioning of the foam material, (a balloon may work well in some cases)
3. Apply flexible foam to previous OEM locations after final installation of outer sheet metal. Do not apply prior to welding operation completion. Consider the 40 second working time during the application.
4. In some cases the use of a flexible hose such as clear vinyl may aide in accessing areas deep within structures, be sure to extrude the material quickly when using nozzle extensions
5. After application is complete keep the applicator plunger mechanism engaged to prevent the foam from migrating back into the cartridge. After a few minutes the cartridge may be removed from the applicator and placed in storage with the nozzle in place.

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### Applications

Sound deadening and vibration reduction material for automotive body repairs, such as door skins to intrusion beam, trunk floors, roof bow to skin locations.

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### 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. Use in a well-ventilated area.

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### Precautionary Information

Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOCs) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area.

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### Technical Information

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