



Automotive Aftermarket Division

3M™ Superfast Plastic Adhesive

1) Part Numbers

55045 – Superfast Plastic Adhesive, Clear – 48.5ml cartridges
04748 - Superfast Plastic Adhesive, Black – 48.5ml cartridges

2) Description and end uses

3M™55045/04748 Superfast Plastic Adhesive is a very fast setting two components adhesive designed to allow fast, simple and durable repairs of damaged automotive plastic parts. Used in conjunction with 3M™ 04903 or 04904 Contour Sheet, it allows to completely rebuild broken plastic pieces like tabs on lamps or bumpers, interior trims, plastic covers in engine compartment, etc. Products cures within minutes then can be grinded, drilled and cut to reproduce the original shape of the broken tab or piece, even when the broken piece is missing.

3) Physical Properties

Base	:	Liquid Urethane
Consistency	:	Semi-rigid paste after curing.
Colour	:	Clear / Black
VOC	:	<=10 g/l
Flash Point	:	143 °C
Temperature resistance	:	-40 to +120°C
Temperature of application	:	+15°C to +30°C
Work Life	:	20 seconds
Tack Free time	:	30 seconds
Full cure	:	1 hour
Hardness (Shore D)	:	70



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- Two components adhesive in cartridge: no additional product like a separated accelerator. Automatic, easy and safe mixing in the mixing nozzle.
- Urethane technology: does not sag or run, easy to shape with 3M™ 04903 Contour & 04904 Reinforced Contour Sheet. Does not become brittle like cyanoacrylate adhesives and makes durable repairs.
- 20 to 30 seconds bond time: allow very fast repairs. No need to use clamps or other additional system to maintain parts together.
- Hardness achieved within minutes: can be sanded, cut, and drilled few minutes after application. Allow to rebuild and attach parts in a few minutes.
- Versatile adhesive: bond to most plastics (in conjunction with 3M™ 05917 adhesion promoter for TPO). Also bond metal, wood, glass (use glass adhesion promoter for optimum results).

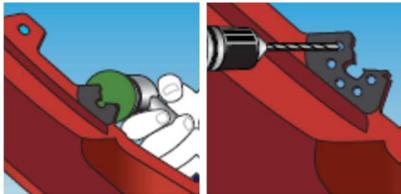
4) Directions for Use

Example for a tab repair rebuilding when the broken piece is missing.



1. Clean part

- Clean and degrease the bonding surface with 3M™ 22779 VHB™ Surface Cleaner.
- Allow to dry completely.



2. Prepare repair area

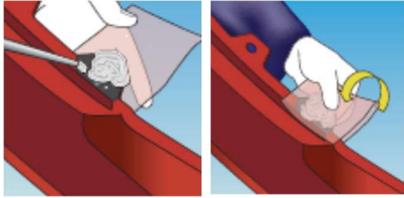
- Sand and bevel the remaining part of the tab.
- Remove all paint from the bonding area.
- Drill several holes (diam. 3 to 6 mm) to reinforce the repair.
- Spray 3M™ 05917 adhesion promoter.
- Allow to dry for 10 minutes.





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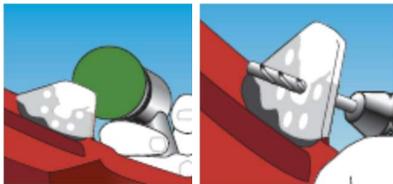


3. Rebuild broken tab

- Cut a piece of 3M™ 04903 or 04904 contour film about 2.5 times the size of the tab to be repaired.
- Apply 3M™ 55045/04748 adhesive, with 08190 applicator, using the contour sheet as a support.
- Immediately fold the sheet and shape adhesive with fingers. Force adhesive into the drilled holes. Do not press too hard to keep a 3 to 5mm layer of adhesive material on both side of the tab.

Caution: when starting to cure, adhesive becomes hot!

- Superfast adhesive is set after 20 to 30 seconds.
- Let cool down the adhesive and peel off contour sheet.



4. Finish the tab repair

- After 5 to 10 minutes, 3M 55045/04748 Superfast Plastic Adhesive can be grinded, sanded, cut and drilled to restore the original shape of the broken part.
- If necessary 3M™ 05545/04748 can be painted using your usual paint process for plastic parts or specific bumper paint in spray.

To bond broken piece when it is available or for any other plastic part it is recommended to drill holes on both pieces. During the repair process, force adhesive into the holes to add mechanical resistance to the repair.

Note: for small broken piece, if the shape is quite simple, it is often easier, faster and more durable to rebuild the part instead of trying to bond the broken piece.



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Products Guide

Description	Part N°	Size
3M™ Superfast Plastic Adhesive	55045/04748	48.5ml cartridge
Mixing nozzles for 55045/04748	04908	Box of 50
3M™ Contour Sheet	04903/04904	127mm x 3.65m roll
Polyolefin Adhesion Promoter	05917	200ml spray
VHB Surface Cleaner	22779	1l bottle
Manual gun + plunger for 50ml cartridges	08190	-

5) Storage

Storage conditions : +5°C to +35°C.
Shelf life : 9 months from date of manufacture under normal storage conditions in original closed bag.

6) Safety

Wear appropriate safety equipment, such as chemical resistant gloves, safety glasses or other protective equipment required by your local regulations or company rules.

Please refer to the Material Safety Data Sheet or contact your local 3M™ Toxicology Department before using the product.

3M™ 55045/04748 Superfast plastic Adhesive is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.

7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable as at the date of hereof, but the accuracy or completeness thereof is not guaranteed. Please ensure before using the product that it is suitable for your intended use. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, other than for fraudulent misrepresentation, 3M expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information.



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For Additional Health and Safety Information

3M South Africa & Sub-Saharan Africa, 146A Kelvin Drive, Woodmead, Sandton, South Africa, Tel: (0861) 225536
3M (East) AG Representation Office Tirane, Rruga Sami Frasheri, Pallati i Ri Perxhola Kati 2 Ap2, 1000 Albania
3M Arabia, LLC, Building 24-25 3M Saudi Arabia Zone C, Business Gate, Airport Road, Riyadh, Saudi Arabia
3M Bulgaria, Mladost 4, Business Park, bl.4, 2nd floor, Sofia 1766, Bulgaria
3M Česko, spol. s r.o., V Parku 2343/24, 148 00 - Praha 4, Czech Republic
3M (East) AG, Branch office Croatia, Avenija Većeslava Holjevca 40, 10 000 Zagreb, Croatia, Tel: +385 1 2499750, www.3m.com.hr
3M Egypt, Finance Center , New Cairo , Plot 140 , Banking Sector , 5th settlement , Cairo , Egypt
3M Hellas MEPE, Automotive Aftermarket Division, 20 Kifisias Avenue, 151 25 Marousi, Greece, Phone: +30 210 68 85 300, innovation.gr@mmm.com, www.3M.gr
3M Hungária Kft, Neumann János u. 1/E, 1117 Budapest, Hungary
3M Israel, 91 Medinat Hayehudim St., Herzliya, Israel
3M Kenya Ltd, Victoria Towers, 3rd Floor, Kilimanjaro Av, Upperhill, Kenya
3M Gulf Limited, Ein El Mreisseh, Saint Charles City Center, 4th. Floor, P.O.Box: 11-5025, Riad el Solh, Beirut 1107 2180 Lebanon
3M Minnesota Mining & Manufacturing Nigeria Limited, No 2 Sheraton Opebi Link Road, Ikeja, Lagos Nigeria
3M Pakistan, Islamic Chamber of Commerce Building, ST-2/A, Block 9, KDA Scheme 5, Clifton, Karachi, Pakistan
3M Poland, Al. Katowicka 117, Kajetany, 05-830 Nadarzyn, Poland, Telefon: +48 22 739 60 00, www.3m.pl/kontakt
3M Gulf (Representation Office), Suhaim Bin Hamad St., Al Mana Towers Tower B, 2nd Floor, Office No.4, Doha Qatar, P.O.Box 14685
3M Romania, 12 Meneuțului St., Bucharest Business Park, Building D, District 1 013713 Bucharest, Romania
3M (East) AG, Representation Office Serbia, Airport City, Omladinskih brigada 90B, 11070 Belgrade, Serbia, Tel: +381 11 2209 400, www.3m.co.rs/3M/sr_RS/3m-south-east-europe/
3M Slovensko s.r.o., Polus Tower 2, Vajnorská 100/B, 83104 Bratislava
3M (East) AG, Branch office Slovenia, Cesta v Gorice 8, 1000, Ljubljana, Slovenia, Tel: +386 1 2003 630, www.3m.com/3M/sl_SI/3m-south-east-europe/
3M Sanayi ve Ticaret As, Barbaros Mah., Mor Sümbül Sok., No:7/3F, 27-51, Nidakule Ataşehir Güney, 34746 Ataşehir, İstanbul, Turkey
3M Gulf Limited, Dubai Internet City, Building No. 11, 3rd Floor, U.A.E

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