3M Aerospace
Top products.
The Greatest Asset in Aerospace:
A Reliable Partner.

You strive to reduce weight, improve rates and increase efficiency, in production and in the aircraft itself. 3M can help. For more than 70 years, we have quietly, passionately worked with leading professionals to solve some of the greatest challenges in the aerospace industry. Our work has resulted in a wide-ranging portfolio of aircraft solutions – films, adhesives, sealants and surface protection to name a few. But it also makes us the most valuable asset you can have in aerospace: a reliable partner. One with a curious nature, and a willingness to push beyond the status quo. One that's committed to helping you continually optimize costs throughout the entire cycle of aircraft design, production and maintenance. And, as one of the world’s most ethical companies, 3M is equally committed to sustainable solutions that help you build and maintain the safest and most efficient aircraft in the world. Discover how 3M can partner with you.

Segment Solutions

➤ Interiors
With the right solutions, every challenge in aircraft interiors – every void, every bracket, every veneer and every monument – becomes an opportunity. Learn more now.

➤ Exteriors
Succeed on tighter timelines and budgets with high-quality aerospace sealants that have superb shop-handling characteristics, lower weight, reduce VOC’s, offer fast cure times and meet various OEM approvals.

➤ Structures
Optimizing designs, meeting stringent build-to-print requirements and cutting weight are just the start to truly setting you apart. Explore 3M aircraft structural solutions now.

➤ Propulsion
Fabricating and bonding to composites, high-temp adhesive films, surface protection... 3M has invented and reinvented in key areas of aircraft engine design and integration.

➤ MRO
From adhesives to abrasives and films, from tapes to safety products, 3M has a deep and extensive offering of solutions tailored specifically for the aerospace industry.

➤ Aircraft Painting
True excellence in aircraft painting requires products that work – not just at a glance, but below the surface and behind the scenes. 3M delivers with a broad range of solutions for performance, reliability and added efficiency from strip/sand to surface prep to sealing.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

### Top products

#### Interiors

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<th>Interior Component Fabrication</th>
<th>Interior Part Assembly &amp; Installation</th>
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<td><strong>Bracket Bonding Adhesives</strong></td>
<td><strong>Sprayable Contact Adhesives</strong></td>
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<td>• 3M™ Scotch-Weld™ EC-7202</td>
<td>• 3M™ Scotch-Weld™ Adhesive EC-1357</td>
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<td><strong>Core Reinforcement Compounds</strong></td>
<td><strong>3M™ Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive EC-1300/EC-1500L</strong></td>
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<td>• 3M™ Scotch-Weld™ Core Splice Adhesive EC-3500 B/A</td>
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<tr>
<td>• 3M™ Scotch-Weld™ Structural Void Filling Compound EC-3550 B/A FST</td>
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<tr>
<td><strong>Edge and Void Fillers</strong></td>
<td><strong>Structural Honeycomb Monument Build</strong></td>
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<tr>
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<td><strong>Insert Potting Compounds</strong></td>
<td><strong>Thermoplastic Bonding</strong></td>
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<td>• 3M™ Scotch-Weld™ EC-7246-2 FST</td>
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<td><strong>Sprayable Contact Adhesives</strong></td>
<td><strong>Honeycomb Splicing and Edge Finishing</strong></td>
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<td>• 3M™ Scotch-Weld™ Structural Core Splice Film AF 3074FST</td>
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<td>• 3M™ Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive EC-1300/EC-1500L</td>
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<td><strong>Floorboard Sealing</strong></td>
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### Top products

#### Exteriors

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<th>Surface Prep</th>
<th>Surface Protection and Enhancement</th>
<th>Structural Adhesive Surfacing and Lightning Strike Protection Films</th>
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<td><strong>Surface Pre-Treatment</strong></td>
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<td>• 3M™ Scotch-Weld™ Composite Surfacing Film AF 325 M &amp; AF 325LS</td>
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<td>• 3M™ Aerospace Sealant AC-350</td>
<td>• 3M™ Aerospace Sealant AC-380</td>
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<td><strong>Fuselage Sealants</strong></td>
<td>• 3M™ Aerospace Sealant AC-770</td>
<td><strong>Advanced Composite Protection 3M™ Cocure films</strong></td>
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<td><strong>Non Chromate Corrosion Inhibitive Sealants</strong></td>
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<td>• 3M™ Polyurethane Protective Tape 8730NA</td>
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<td><strong>Windshield Sealant</strong></td>
<td>• 3M™ Aerospace Sealant AC-251</td>
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<td><strong>Tamper Proof Sealing</strong></td>
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<td>• 3M™ RP-2220</td>
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<td><strong>Corrosion Prevention Tapes</strong></td>
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<td>• 3M™ Polyurethane Protective Tape 8671 and/or 8671HS</td>
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<td><strong>Thermoformed Protection Boots</strong></td>
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<td><strong>Urethane Repair Pastes / Edge Sealers</strong></td>
<td>• 3M™ Scotch-Weld™ Repair Paste 2110</td>
<td>Typical application areas: Radome, winglet, antenna leading edge protection, fairings, light/ lens protection, landing gear</td>
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<td><strong>Application Accessories</strong></td>
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<tr>
<th>Composite Part Fabrication</th>
<th>Metal Component Fabrication</th>
<th>Assembly &amp; Completions</th>
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<td>• 3M™ Scotch-Weld™ Structural Adhesive Film AF 126 and AF 126-2</td>
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<td>• 3M™ Matrix Resin 2897</td>
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<td>• 3M™ Scotch-Weld™ Repair Paste 2110</td>
<td>• 3M™ Surface Pre-Treatment AC-130-2</td>
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<td>• 3M™ Scotch-Weld™ Repair Paste 2220</td>
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## Top products

### Propulsion

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<th>Paint Applique Film</th>
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<td><strong>Surface Pre-Treatment</strong></td>
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<td><strong>Fan Track Abradable / Void Fillers</strong></td>
<td><strong>Structural Adhesive Surfacing and Lightning Strike Protection Films</strong></td>
<td><strong>Paint Applique Film</strong></td>
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<td>3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3500 B/A</td>
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### Top products

#### Fan Blades

- **Surface Pre-Treatment**
  - 3M™ Surface Pre-Treatment AC-130-2

- **Structural Adhesive Bond Primers**
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EC-3917
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EC-3924B
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EW-5005

- **Structural Adhesive Films**
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 191
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2

- **Structural Adhesive Composite Surfacing Films**
  - 3M™ Scotch-Weld™ Composite Surfacing Film AF 325 M
  - 3M™ Scotch-Weld™ Composite Surfacing Film AF 536

#### Propulsion

- **Advanced Composite Protection Cocure Films**
  - 3M™ Polyurethane Protective Tape 8730NA
  - 3M™ Polyurethane Protective Tape 8732NA
  - 3M™ Polyurethane Protective Tape 8734NA

- **Urethane Repair Pastes**
  - 3M™ Scotch-Weld™ Repair Paste 2110
  - 3M™ Scotch-Weld™ Repair Paste 2220

- **Composite Resins**
  - Matrix Resin 4891
  - Matrix Resin 2896

#### Rotor Blades

- **Surface Pre-Treatment**
  - 3M™ Surface Pre-Treatment AC-130-2

- **Structural Adhesive Bond Primers**
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EC-3924B
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EC-3917
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EC-1660
  - 3M™ Scotch-Weld™ Structural Adhesives Primer EW-5005

- **Structural Adhesive Films**
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 191
  - 3M™ Scotch-Weld™ Structural Adhesive Film AF 30

- **Core Splice Structural Adhesive Films**
  - 3M™ Scotch-Weld™ Structural Core Splice Film AF 3021
  - 3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
  - 3M™ Scotch-Weld™ Structural Core Splice Film AF 3028
  - 3M™ Scotch-Weld™ Structural Core Splice Film AF 3074 FST

- **Advanced Composite Protection Cocure Films**
  - 3M™ Polyurethane Protective Tape 8730NA
  - 3M™ Polyurethane Protective Tape 8732NA
  - 3M™ Polyurethane Protective Tape 8734NA

- **Polyurethane Protection Films and Tapes**
  - 3M™ Polyurethane Protective Tape 8545HS
  - 3M™ Polyurethane Protective Tape 8542HS
  - 3M™ Polyurethane Protective Tape 8999 K11 Rotor Blade Protection Kit
  - UH-60M: SJ8542HS FP641 Patch

- **Urethane Repair Pastes**
  - 3M™ Scotch-Weld™ Repair Paste 2220
  - 3M™ Scotch-Weld™ Repair Paste 2110

- **Thermoformed Boots**
  - FP 637, FP 532, FP 557, FP 558, FP 595
  - 3M™ Polyurethane Protective Boot SJ8542HS FP637
  - 3M™ Polyurethane Protective Tape SJ8542HS FP641 (UH-60M)
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Top products

**Abrasives**
- Abrasives for Structural Repair
- Light Corrosion and Sealant Removal
- Sand Fairings and Flight Control
- Abrasives for Composites
- Decal and Placard Removal on Metal
- Metal Stress Relieving

**Aircraft Painting**
- Chemically Strip and/or Sand
- Surface Preparation and Primer Application
- Base Coat and Paint Application, Striping, Livery and Clear Coat Detail Finish and Repair

**Cleaning**
- General Cleaning
- Interior
- Exterior
- Seat Track Cleaning
- Borehole Cleaning
- Oxygen Line Cleaning

**Composite Repair**
- Tapes for Composite Repair
- Adhesives for Composite Repair
- 3M™ Scotch-Weld™ Epoxy Adhesives and Accessories

**Corrosion Management**
- Wet Area Corrosion Prevention
- Abrasives for Corrosion Removal

**Electrical Systems and Maintenance**
- Tapes

**Engine Overhaul**
- Metal Stress Relieving
- Surface Protection Film Repair
- Abradable Compound
- Fluid Containment

**Personal Safety**
- High Noise Environments
- Fall Protection Safety
- Head, Eye and Face Protection
- Respiratory Exposures
- Welding Safety
- Confined Spaces

**Sealing, Bonding and Joining**
- Sealants
- Sealant Removal
- Bonding
- Joining
- Cargo Compartment Sealing
- Decorative Laminate Bonding

**Specialty and Processing Aid Tapes**
- Adhesion Testing Tapes
- Temporary Part Marking
- Metal Processing Tapes
- Welding Protection Tapes
- Media Blasting
- Floor Marking Tapes
- Vibration Damping Tapes

**Surface Protection**
- Temporary Protection for Parts, Carpets or Facilities
- Erosion Protection and Edge Sealing
- Chemical Protection
- Impact Protection
- Chafing Protection
Go above and beyond with 3M’s aircraft interior solutions designed to boost assembly efficiency and out-perform most materials used in aircraft construction. 3M’s low-density compounds are some of the lightest on the market, offer reduced voids and are built tough. Streamline operation with solutions designed to fit your process.
Bracket Bonding Adhesives
- Simple two-step process, apply and bond without using fixtures
- Instant hold with no sag or mess
- Low-flow for use in vertical or overhead applications

Core Reinforcement Compounds
- Superior compressive strength
- Excellent performance over a wide temp range
- Some meet Fire Retardant (FR) per 14CFR 25.853 and others meet Flame Smoke Toxicity (FST) requirements

Edge and Void Fillers
- Saves weight with one of the lightest pumpable/extrudable Fire Retardant (FR) void filler in the industry
- Industry-leading combination of density with compression strength
- Some meet FR per 14CFR 25.853 and others meet Flame Smoke Toxicity (FST) requirements

Insert Potting Compounds
- High torque resistance ideal for inset potting application
- Fast cure and lightweight options available
- Fire Retardant (FR) compliant per 14CFR 25.853 (a)
Aircraft Interiors
Part Fabrication

Sprayable Contact Adhesives
- Bonds to flexible foams, wood, fabric, plastic and metal surfaces
- Can be applied by spray, brush or roller
- Applications include bonding of decorative veneer, gaskets and de-icing boots

Thermoplastic Bonding
- Can be used to bond thermoplastics to metal and composite surfaces
- Low sag formulation delivers controlled flow for vertical applications
- Flame Smoke Toxicity (FST) options are available

Honeycomb Splicing and Edge Finishing
- Repeatable expansion rates add consistency to the parts
- Up to six months shelf life and shop life at room temperature
- Core splice adhesive film can be cured at 120°C or 180°C with service temperatures from -55°C to 135°C

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**Bracket Bonding Adhesives**

3M™ Scotch-Weld™ EC-7202 – No-sag eliminates support fixtures to help reduce waste and save time

3M™ Scotch-Weld™ Epoxy Adhesive EC-3542 B/A FR – Fast flow and strong mechanical performance for easy panel forming. Work life is 30 min

**Core Reinforcement Compounds**

3M™ Scotch-Weld™ Core Splice Adhesive EC-3500 B/A – Superior compressive strength of 6000 psi (41 MPa) with only 0.64 g/cm density

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3550 B/A FST – Meets Airbus FST (Flame, Smoke, Toxicity) Requirement, ABD-0031

**Core Reinforcement Compounds**

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3505 B/A FR – Very low density, FR (Fire Retardant)

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3550 B/A FST – Meets Airbus FST (Flame, Smoke, Toxicity) Requirement, ABD-0031

**Edge and Void Fillers**

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3524 B/A FST – Very low density, FST

**Thermoplastic Bonding**

3M™ Scotch-Weld™ EC-7246-2 FST – Excellent flow control for vertical applications. Not formulated with Antimony-Trioxide

**Edge and Void Fillers**

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3505 B/A FR – Very low density, FR (Fire Retardant)

3M™ Scotch-Weld™ Structural Void Filling Compound EC-3550 B/A FST – Meets Airbus FST (Flame, Smoke, Toxicity) Requirement, ABD-0031

**Insert Potting Compounds**

3M™ Scotch-Weld™ Epoxy Adhesive EC-3542 B/A FR – Two-part epoxy potting compound, fire retardant, with fast gel and cure time at room temperature

**Insert Potting Compounds**

3M™ Scotch-Weld™ Epoxy Adhesive EC-3542 B/A FR – Fast flow and strong mechanical performance for easy panel forming. Work life is 30 min

**Sprayable Contact Adhesives**

3M™ Scotch-Weld™ Adhesive EC-1357 - Polychloroprene Based Adhesive, Sprayable

3M™ Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive EC-1300/ EC-1300L

**Sprayable Contact Adhesives**

3M™ Scotch-Weld™ Adhesive EC-1357 - Polychloroprene Based Adhesive, Sprayable

**Structural Honeycomb**

**Monument Build**

3M™ Scotch-Weld™ Epoxy Adhesive EC-2815 B/A FR – Maximum mechanical strength for overhead luggage bins, stowage panels and monuments. Work life is 60 min

3M™ Scotch-Weld™ EC-9356 FST – Fast cure option compared to EC-9300 FST

3M™ Scotch-Weld™ EC-9300 FST – Best choice for ditch and pot applications

**Honeycomb Splicing and Edge Finishing**

3M™ Scotch-Weld™ Structural Core Splice Film AF 3074 FST. Low Density Expanding Core Splice Film with FST (Flame, Smoke, Toxicity) Resistance

3M™ Scotch-Weld™ Structural Core Splice Film AF 3070 FST. Low Density Expanding Core Splice Film with FST (Flame, Smoke, Toxicity) Resistance

**Other 3M Products (consumables)**

To aid in your bonding, use 3M™ Polyester Tapes 875 and 876. These non-silicone tapes provide a secure hold for composite parts manufacturing and metal bonding processes, even when exposed to high temperatures. In addition, they’re easy to apply and remove cleanly, leaving no residue.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Aircraft Interiors
Part Assembly & Installation

Everything you need to assemble your interior and complete the best-in-class design - from edge and void fillers, bracket-bonding, insert bonding, to corrosion prevention, sealants and thermal acoustic products. We have the complete solution to create a lighter, safer and quieter aircraft.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Aircraft Interiors**

**Interior Part Assembly & Installation**

**Bracket Bonding**
- Simple two-step process, apply and bond without having to use fixtures
- Instant hold with no sag or mess
- Low-flow for use in vertical or overhead applications

**Floorboard Sealing**
- Polysulfide sealant fills voids and seals fuselages
- Offers outstanding resistance to jet fuel, chemicals and petroleum products
- Fast cure, tack free in as little as 3 hours
- Low non-volatile content to reduce shrinkage and rework
- Easy to apply and work with

**Corrosion Prevention**
- Prevent fluids from reaching floorbeams and other metal structures
- Highly durable, puncture-resistant and Fire Retardant (FR) rated
- Conformable and easy to apply

**Thermal Acoustic Solutions**
- Thermal and Acoustic kits and materials to improve cabin comfort
- Supplemental Type Certificate (STC) kits available for a variety of aircraft
- Parts Manufacturer Approval (PMA) certified materials

**Temporary Protection Tapes**
- Easy removal without surface residue
- Flame resistant
- Conform to curved and uneven surfaces

*Information on this page includes products from Aearo Technologies LLC, a 3M company.*
Interior Part Assembly & Installation – Top Products

Bracket Bonding
3M™ Scotch-Weld™ EC-7202 – No-sag eliminates support fixtures to help reduce waste and save time

Floorboard Sealing
3M™ Aerospace Sealant AC-770 B
3M™ Aerospace Sealant AC-735 B

Corrosion Prevention
3M™ Polyurethane Protective Tape 8658DL – Flame resistant tape meets FAR 25.852 for aircraft interior burn certifications and is used to seal floor panels
3M™ Polyurethane Protective Tape 8663DL – Moisture barrier tape that is used in wide areas or seam sealing applications and passes burn testing as a sandwich construct
3M™ Polyurethane Protective Tape 8657DL – For wet-area corrosion prevention areas such as aircraft lavatories and galleys. Flame resistant tape meets FAR 25.852 for aircraft interior burn certifications and is used for wide area applications
3M™ Polyurethane Protective Tape 8666

Temporary Protection Tapes
3M™ Polyurethane Protective Tape 8547-1 - Protects components from surface damage during manufacturing and transportation, and removes cleanly from a variety of substrates

Thermal Acoustic Solutions
Aircraft Damping Composites – a low surface weight, high-performing aircraft damping composite for structural applications optimized across a variety of temperature ranges
Carpet Pad – An under-carpet cushion, acts as an acoustic barrier and absorber in addition to helping provide thermal comfort
Primary Insulation - Encapsulated fiberglass bags are thermally and acoustically tuned, and control both fiber fly and moisture

Other Featured Products
3M Aerospace Paste Adhesives are available in a variety of work life, cure time and density to fit your specific design. Contact your local 3M sales representative or aerospace authorized distributor for more information.
Aircraft Exteriors
Surface Prep

Succeed on tighter timelines and budgets with high-quality aerospace sealants that have superb shop-handling characteristics, light-weight, low VOC, fast cure times and various OEM approvals.
Aircraft Exteriors
Surface Prep

Surface Pre-Treatment
- Excellent for preparing aluminum, and titanium alloy parts subsequently finished with epoxy-based and polyurethane-based organic coatings
- Helps reduce labor time and water usage; no scrubbing or rinsing required
- Superior adhesion of organic coatings to metal substrates
- Eliminates chromates from surface treatment process

Fuel Tank Sealants
- Universal sealants that can be used across fuel tank and fuselage applications
- Multiple OEM and MRO approvals
- Class B sealants help reduce shrinkage and rework for total cost reduction

Fuselage Sealants
- Non-Chromate Corrosion Inhibiting (NCCI) sealants available
- Excellent shop-handling characteristics including less stringing, low sag and optimized formulas to help reduce odor
- Easier application – less effort to tool and shape

Non Chromate Corrosion Inhibitive Sealants
- Non-chromate corrosion inhibitive formula helps comply with chromate reduction initiatives
- Allows for total cost reduction; helps reduce shrinkage and rework
- Low density formula weighs 3–4 lbs. less per gallon than traditional sealants
- Helps process improvement; excellent tooling properties, easily applied and cures quickly

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Helpful Tools

### Product Configuration

<table>
<thead>
<tr>
<th>Product</th>
<th>Usage</th>
<th>Application</th>
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<tbody>
<tr>
<td>CLASS A (Brushable)</td>
<td>For fasteners and brush-coat sealing</td>
<td>Brush applied</td>
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<tr>
<td>CLASS B (Extrudable)</td>
<td>For fillet and injection seals; little to no flow (sag)</td>
<td>Usually applied with a sealant gun</td>
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<tr>
<td>CLASS C (Rollable)</td>
<td>For fay surface seals</td>
<td>Applied using a roller or a sealant gun</td>
</tr>
</tbody>
</table>

### Windshield Sealant
- Formulated for sealing acrylic, glass, and polycarbonate aircraft canopies and windshields
- Class B Sealants contain no solvents and do not craze
- Quickly cure and exhibit excellent adhesion and resistance to UV and weather exposure.

### Adhesion Promoters
- Allows for faster initial adhesion build rate of polysulfide sealant
- One component formula for simple application
- Available in a water-based formula for solvent sensitive surfaces.

### Tamper Proof Sealing
- One-part formula for convenient dispensing
- Protect settings and calibrations
- Indicates whether fastener has been tampered with or has moved.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Surface Prep – Top Products

Surface Pre-Treatment
3M™ Surface Pre-Treatment AC-131 BB & CB - Version of sol gel appropriate for paint surface preparation

Fuel Tank Sealants
3M™ Aerospace Sealant AC-380
3M™ Aerospace Sealant AC-350
3M™ Aerospace Sealant AC-370

Fuselage Sealants
3M™ Aerospace Sealant AC-770
3M™ Aerospace Sealant AC-735
3M™ Aerospace Sealant AC-370

Aerospace Polysulfide Sealants

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<tr>
<th>Sealant</th>
<th>Fuel Tank</th>
<th>Fuselage</th>
<th>Fast Cure</th>
<th>Standard Density (1.5+)</th>
<th>Reduced Density (1.3-1.4)</th>
<th>Low Density (1.1)</th>
<th>No Solvent (Class B)</th>
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Non Chromate Corrosion Inhibitive Sealants
3M™ Aerospace Sealant AC-735

Windshield Sealant
3M™ Aerospace Sealant AC-251

Adhesion Promoters
3M™ Adhesion Promoter AC-160
3M™ Adhesion Promoter AC-137
3M™ Adhesion Promoter AC-132

Tamper Proof Sealing
3M™ Scotch-Weld™ Tamper Proof Sealant EC-1252 – Available in blue, pink, yellow and white

Other 3M Products (consumables)
Use 3M 231A masking tape and 471 vinyl tape for effective masking of aircraft lap joints, doublers and other sealant applications.
Aircraft Exteriors
Surface Protection and Enhancement

You need to think ahead, to fix things before they’re broken, to prevent errors before they happen. You need built-in, proactive protection. You need to take control of future issues while you still can—now.

3M surface protection solutions can help.

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Aircraft Exteriors
Surface Protection and Enhancement

Structural Adhesive Surfacing and Lightning Strike Protection Films
- Resistant to effects of humidity exposure
- Cocure compatible with most epoxy composite pre-preg systems
- Excellent for surfacing composite parts

Advanced Composite Protection Cocure Films
- Game-changing technology for protecting advanced composite parts
- Processing temperatures up to 400 °F and service temperatures up to 250 °F
- Unique flow capabilities to stack protection where you need it

Corrosion Prevention Tapes
- Prevent fluids from reaching floorbeams and other metal structures
- Highly durable and puncture-resistant with flame resistant options available
- Conformable and easy to apply

Rotor Blade Tapes
- Highly durable, long service life
- Meets several OEM specifications
- Protect rotor blades to avoid replacement

Military Grade Tapes
- Proven military use
- Available in various colors
- NSNs available

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Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

### Aircraft Exteriors - Surface Protection and Enhancement

#### Commercial Grade Tapes
- Transparent tapes with a superior UV package
- Easy to apply and conforms to curved surfaces
- Can be painted over, or applied to painted surfaces

#### Fuel Cell/Anti-Chafe Tapes
- Adhere to a wide variety of substrates
- Solvent-free technology
- Conform to curvatures

#### FOD Impact Protection Tapes
- Extremely tough elastomer for aerospace applications
- Can be perforated for easier application
- Adheres to a wide variety of substrates

#### Indoor Grade Tapes
- Highly durable in challenging environments
- Easy to apply
- Constant adhesion and easy removal

#### Paint Replacement Tapes
- Designed to resist fluid ingress
- Low surface energy for interior and exterior applications
- Conform to irregular surfaces
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Aircraft Exteriors - Surface Protection and Enhancement**

**Temporary Protection Tapes**
- Easy removal without surface residue
- Flame resistant
- Conform to curved and uneven surfaces

**Thermoformed Protection Boots**
- Hundreds of pre-shaped shapes to meet your needs and prevents damage caused by rain and sand
- Can be formulated to be UV-stable to hold clarity and not yellow over time.
- Virtually no reduction in radar transmissivity

**Urethane Repair Pastes / Edge Sealers**
- On-aircraft repairs, no vacuum bagging required
- Erosion resistance in the harshest conditions
- Tack free, flyable and fully cured in less than 24 hours

**Application Accessories**
- Allows to easily apply 3M™ Polyurethane Protective Tapes and Boots
- Aids proper installation
- Easy to use and allows faster application
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Surface Protection and Enhancement – Top Products

**Structural Adhesive Surfacing and Lightning Strike Protection Films**

- 3M™ Scotch-Weld™ Composite Surfacing Film AF 325 M & AF 325LS – Available in white and blue versions
- 3M™ Scotch-Weld™ Composite Surfacing Film AF 191XS
- 3M™ Scotch-Weld™ Composite Surfacing Film AF 536 – Multiple film weight options available. Can be cured at either 250°F (120°C) or 350°F (175°C)

**Advanced Composite Protection Cocure Films**

- 3M™ Polyurethane Protective Tape 8730NA – (12 mil thick)
- 3M™ Polyurethane Protective Tape 8732NA – (24 mil thick)
- 3M™ Polyurethane Protective Tape 8734NA – (6 mil thick)
- 3M™ Scotch-Weld™ Repair Paste 2110 Kit – Urethane paste designed for durable erosion resistance equivalent to original 3M film.
- 3M™ RP-2220

**Corrosion Prevention Tapes**

- 3M™ Polyurethane Protective Tape 8658DL – Flame resistant tape meets FAR 25.852 for aircraft interior burn certifications and is used to seal floor panels
- 3M™ Polyurethane Protective Tape 8663DL – Moisture barrier tape that is used in wide areas or seam sealing applications and passes burn testing as a sandwich construct
- 3M™ Polyurethane Protective Tape 8657DL – For wet-area corrosion prevention areas such as aircraft lavatories and galleys. Flame resistant tape meets FAR 25.852 for aircraft interior burn certifications and is used for wide area applications
- 3M™ Polyurethane Protective Tape 8666

**Rotor Blade Tapes**

- 3M™ Polyurethane Protective Tape 8542HS – 10x better rain and sand erosion performance than 8663HS (43 mil thick)
- 3M™ Polyurethane Protective Tape 8545HS & 8545NA – 7x better rain and sand erosion performance than 8663HS (22 mil thick)
- 3M™ Polyurethane Protective Tape 8663HS Matte Black – Meets multiple military specifications (18 mil thick)

**Military Grade Tapes**

- 3M™ Polyurethane Protective Tape 8667HS – Commonly used in industrial applications. Erosion protection with high shear adhesive. (28 mil thick)
- 3M™ Polyurethane Protective Tape 8681HS – Available in Matte Clear and 36118, 36173, 36251, 36270, 36320 and 36375 Grays (14 mil thick)

**Commercial Grade Tapes**

- 3M™ Polyurethane Protective Tape 8671 and/or 8671HS
- 3M™ Polyurethane Protective Tape 8672
- 3M™ Polyurethane Protective Tape 8673 – Best UV stability package and is 3M’s first choice for exterior leading edge protection.
- 3M™ Polyurethane Protective Tape 8674 – Thinner version of 8673

**Fuel Cell/Anti-Chafe Tapes**

- 3M™ Polyurethane Protective Tape 8544 – Prevents chafing of rivets on aircraft fuel cells and bladders

**FOD Impact Protection Tapes**

- 3M™ Polyurethane Protective Tape 8641 – “Belly Tape” protects against small foreign object damage (FOD) on underside of aircraft. Impact protection tape — our thickest tape (41 mil thick)

**Indoor Grade Tapes**

- 3M™ Polyurethane Protective Tape 8560 – Indoor grade, high-tack, repositionable, abrasion resistant (14 mil thick)
- 3M™ Polyurethane Protective Tape 8561 – Indoor grade, impact and erosion resistance. Commonly used in industrial applications. (14 mil)
- 3M™ Polyurethane Protective Tape 8562 – Indoor grade, for isolation, abrasion resistant (8 mil) than 8663HS (43 mil thick).

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CLICK FOR ONLINE PRODUCT INFORMATION
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Surface Protection and Enhancement – Top Products

Paint Replacement Tapes
3M™ Surface Protection Film 3952 – Provided without adhesive for cocure applications
3M™ Paint Replacement Tape 5004 – Designed as a paint replacement. Excellent moisture barrier and Skydrol resistant

Temporary Protection Tapes
3M™ Polyurethane Protective Tape 8547 – Protects components from surface damage during manufacturing and transportation.
3M™ Polyurethane Protective Tape 8547-1

Thermoformed Protection Boots
Visit 3M.com/boots to see a full list of available aerospace boots
Typical application areas: Radome, Winglet, Antenna

Urethane Repair Pastes / Edge Sealers
3M™ Scotch-Weld™ Repair Paste 2110 – black repair paste used with our black protective tapes
3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also perfect for edge sealing

Application Accessories
3M™ Protective Tape Application Solution – Ready-to-use spray bottles save time and guesswork mixing - includes an application squeegee
3M™ Adhesion Promoter 86A – Allows for faster initial adhesion build rate of 3M™ Polyurethane Protective Tapes and Boots

Other Featured Products

Corrosion Prevention Tapes
3M™ Polyurethane Protective Tape 8658DL – Flame resistant seam-sealing tape meets FAR 25.852 for aircraft interior burn certifications.
3M™ Polyurethane Protective Tape 8663DL – A transparent polyurethane protective tape that is qualified to multiple leading aircraft manufacturer specifications for corrosion prevention, wide area protection.
3M™ Polyurethane Protective Tape 8657DL – A white polyurethane protective tape that meets FAR 25.853. Corrosion prevention, wide area protection tape.
3M™ Polyurethane Protective Tape 8686 – Meets FAR 25.853. Thin and removable commonly used as an interior patch tape.
Aircraft Structures
Composite Component Fabrication

Manufacture a toughened composite part with 3M products that bring you the best lightweight, durable and shop-handling characteristics in the industry. We have the complete composite part fabrication package with toughened resin system (nano technology), integrated composite protection and multiple composite bonding options to fit exactly what your design calls for.

3M Structural Adhesive Bonding solutions can help.

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Aircraft Structures
Composite Component Fabrication

Composite Resins
• Excellent high strength and stiffness
• Improved toughness and durability
• High temperature performance

Advanced Composite Protection Cocure Films
• Game-changing technology for erosion and abrasion protection of composite parts
• Processing temperatures up to 400 °F and service temperatures up to 250 °F
• Able to be cocured with composite parts or post bonded with structural adhesives (built-in erosion protection)

Repair Pastes
• On-aircraft repairs, no vacuum bagging required
• Erosion resistance in the harshest conditions
• Tack free, flyable and fully cured in less than 24 hours

Structural Adhesive Films
• High fracture toughness and peel strength
• Excellent pre-bond humidity performances
• Available in multiple cure temperatures

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Structural Adhesive Composite Surfacing Films
- Cocure compatible with most epoxy composite prepreg systems
- Smooth surfacing with minimal pinholes and imperfections
- Available in multiple cure temperatures

Structural Adhesive Lightning Strike Protection Film
- Cocure compatible with most epoxy composite prepreg systems
- Smooth surfacing with minimal pinholes and imperfections
- Available in multiple cure temperatures

Honeycomb Void Filler
- Strong, low-density formulas save weight
- Non-sag compound dispenses easily
- Cartridge and bulk dispensing options available
Aircraft Structures
Composite Component Fabrication

Paste Adhesives
• High peel and shear strength for aerospace applications
• Maintain bond strength at high and low temperatures
• FR and FST solutions available

Core Splice Structural Adhesive Films
• Thermally expanding films for gap filling
• High performance over a broad range of temperature
• Excellent shear strength even at elevated temperatures

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Composite Resins
3M™ Matrix Resin 4891 – For structural parts requiring high compression strength and high temperature performance.
3M™ Matrix Resin 2897

Advanced Composite Protection Cocure Films
3M™ Polyurethane Protective Tape 8730NA – (12 mil thick)
3M™ Polyurethane Protective Tape 8732NA – (24 mil thick)
3M™ Polyurethane Protective Tape 8734NA – (6 mil thick)
3M™ Polyurethane Protective Tape RP-2220

Repair Paste/Edge Sealers
3M™ Scotch-Weld™ Repair Paste 2110 – black repair paste used with our black protective tapes.
3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also perfect for edge sealing

Structural Adhesive Films
3M™ Scotch-Weld™ Structural Adhesive Film AF 126 and AF 126-2 – 250°F (120°C) cure.
3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2 – 250°F (120°C) cure.
3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2 – Dual cure 250°F (120°C) or 350°F (175°C)
3M™ Scotch-Weld™ Structural Adhesive Film AF 555 – 350°F (175°C) cure.
3M™ Scotch-Weld™ Structural Adhesive Film AF 191 – 350°F (175°C) cure.
3M™ Scotch-Weld™ Structural Adhesive Film AF 131-2 – 350°F (175°C) cure

Structural Adhesive Lightning Strike Protection Film
3M™ Scotch-Weld™ Composite Surfacing Film AF 325 LS – Available in white and blue for color contrast
3M™ Scotch-Weld™ Composite Surfacing Film AF 536 – Multiple film weight options available. Standard temperature cure from 250°F (120°C) up to 350°F (175°C)

Honeycomb Void Filler
3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3500 B/A
3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3500-2 B/A
3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3524 B/A – Versatile formula can be used for bonding inserts

Pastes Adhesives
3M™ Scotch-Weld™ Epoxy Adhesive EC-2214 – 350°F (175°C) cure.
3M™ Scotch-Weld™ Epoxy Adhesive EC-2615 B/A – Room temperature cure.
3M™ Scotch-Weld™ Epoxy Adhesive EC-2792 B/A – Reaches handling strength in approximately 5 hours and is fully cured in 24 hours

Core Splice Structural Adhesive Films
3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
3M™ Scotch-Weld™ Structural Core Splice Film AF 3024 – Highest expansion and lowest density of core splice films in our portfolio. Dual cure 250°F (120°C) or 350°F (175°C)
3M™ Scotch-Weld™ Structural Core Splice Film AF 3028 and AF 3028FR
3M™ Scotch-Weld™ Structural Core Splice Film AF 3074 FST – Low Density Expanding Core Splice Film with FST (Flame, Smoke, Toxicity) Resistance

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Aircraft Structures
Metal Component Fabrication

Rely on 3M engineered solutions for your aerospace metal part fabrication and make it easier to maintain lighter, safer and more fuel-efficient aircraft.
Aircraft Structures
Metal Component Fabrication

Structural Adhesive Films
• High fracture toughness and peel strength
• Excellent pre-bond humidity performances
• Available in multiple cure temperatures

Surface Pre-Treatment
• Excellent for preparing aluminum, stainless steel and titanium alloy parts subsequently finished with epoxy-based and polyurethane-based organic coatings.
• Helps reduce labor time and water usage; no scrubbing or rinsing required
• Eliminates chromates from surface treatment process

Structural Adhesive Bond Primers
• Corrosion inhibitive pigment allows for increased service life
• Protect high-cost surface preparation helps preserve Chemical Surface Preparation Prior to bonding
• Water based and non-chromate options available
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Aircraft Structures**

**Metal Component Fabrication**

---

**Paste Adhesives**

- Excellent adhesion on primed or painted metal
- Maintain bond strength at high and low temperatures
- High peel and shear strength for aerospace applications

---

**Core Splice Structural Adhesive Films**

- Thermally expanding films for gap filling
- High performance over a broad range of temperature
- Excellent shear strength even at elevated temperatures

---
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Structural Adhesive Films**

3M™ Scotch-Weld™ Structural Adhesive Film AF 126 and AF 126-2 – 250°F (120°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2 – 250°F (120°C) cure
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3M™ Scotch-Weld™ Structural Adhesive Film AF 555 – 350°F (175°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 191 – 350°F (175°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 131-2 – 350°F (175°C) cure

**Surface Pre-Treatment**

3M™ Surface Pre-Treatment AC-130-2 – Sol-gel based surface preparation for adhesive bonding of aluminum alloys, stainless steel and titanium

**Structural Adhesive Bond Primers**

3M™ Scotch-Weld™ Structural Adhesive Primer EC-3917 – Solvent based, chromated inhibitor
Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesives Primer EC-3924B – Solvent based, chromated inhibitor. Complimentary to 250°F (120°C) cure adhesive films
Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films
Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesive Primer EW-5005 – Water based, non-chromated inhibitor.
Appropriate for use with AC 130-2 sol gel surface prep. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films

**Paste Adhesives**

3M™ Scotch-Weld™ Epoxy Adhesive EC-2214
3M™ Scotch-Weld™ Epoxy Adhesive EC-2615 B/A
3M™ Scotch-Weld™ Structural Epoxy Adhesive EC-9323-2 B/A
3M™ Scotch-Weld™ Epoxy Adhesive EC-2792 B/A – Reaches handling strength in approximately 5 hours and is fully cured in 24 hours

**Core Splice Structural Adhesive Films**

3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
3M™ Scotch-Weld™ Structural Core Splice Film AF 3024 – Highest expansion and lowest density of core splice films in our portfolio. Dual cure 250°F (120°C) or 350°F (175°C)
3M™ Scotch-Weld™ Structural Core Splice Film AF 3028 and AF 3028FR
3M™ Scotch-Weld™ Structural Core Splice Film AF 3074FST – Low Density expanding Core Splice Film with FST (Flame, Smoke, Toxicity) resistance

**Other 3M Products (consumables)**

Aircraft need the best abrasives available to assist with construction to maintenance. 3M offers a full line of abrasives including quick change discs, flap wheels, cartridge rolls, fiber discs and non-woven wheels, brushes, flap discs, hand pads, belts and more to fit your needs.

**Surface Pre-Treatment**

3M™ Surface Pre-Treatment AC-130-2 – Sol-gel based surface preparation for adhesive bonding of aluminum alloys, stainless steel and titanium

**Structural Adhesive Bond Primers**

3M™ Scotch-Weld™ Structural Adhesive Primer EC-3917 – Solvent based, chromated inhibitor
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**Paste Adhesives**

3M™ Scotch-Weld™ Epoxy Adhesive EC-2214
3M™ Scotch-Weld™ Epoxy Adhesive EC-2615 B/A
3M™ Scotch-Weld™ Structural Epoxy Adhesive EC-9323-2 B/A
3M™ Scotch-Weld™ Epoxy Adhesive EC-2792 B/A – Reaches handling strength in approximately 5 hours and is fully cured in 24 hours

**Core Splice Structural Adhesive Films**

3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
3M™ Scotch-Weld™ Structural Core Splice Film AF 3024 – Highest expansion and lowest density of core splice films in our portfolio. Dual cure 250°F (120°C) or 350°F (175°C)
3M™ Scotch-Weld™ Structural Core Splice Film AF 3028 and AF 3028FR
3M™ Scotch-Weld™ Structural Core Splice Film AF 3074FST – Low Density expanding Core Splice Film with FST (Flame, Smoke, Toxicity) resistance

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Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Aircraft Structures
Assembly & Completions

3M structural solutions are driving new efficiencies and raising the bar for performance of aerospace components.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Paste Adhesives**
- Excellent adhesion on primed or painted metal
- Maintain bond strength at high and low temperatures
- High peel and shear strength for aerospace applications

**Liquid Shim Adhesives**
- Fast curing at ambient temperature
- Excellent adhesion and compression properties
- Extrudable from cartridges or bulk material

**Bracket Bonding Adhesives**
- Simple two-step process, apply and bond without having to use fixtures
- Instant hold with no sag or mess
- Low-flow for use in vertical or overhead applications
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Polysulfide Sealants**
- Excellent shop-handling characteristics including less stringing and low sag
- Quick tack free times and short cure times for increased throughput

**Tamper Proof Sealants**
- One-part formula in multiple colors for convenient dispensing
- Self-extinguishing
- Numerous OEM approvals
Assembly & Completions – Top Products

Paste Adhesives
3M™ Scotch-Weld™ Epoxy Adhesive EC-2615
3M™ Scotch-Weld™ Structural Epoxy Adhesive EC-9323-2 B/A

Liquid Shim Adhesives
3M™ Scotch-Weld™ EC-7272 B/A – Good for gap filling

Bracket Bonding Adhesives
3M™ Scotch-Weld™ EC-7202 – cures within 90 minutes to handling strength

Polysulfide Sealants
Ideal for fuel tank and fuselage sealing applications
3M™ Aerospace Sealant AC-350 A,B
3M™ Aerospace Sealant AC-370 B
3M™ Aerospace Sealant AC-380 B

Tamper Proof Sealants
3M™ Scotch-Weld™ EC-1252 – available in white, pink, blue and yellow

Aerospace Polysulfide Sealants

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<th>Sealant</th>
<th>Fuel Tank</th>
<th>Fuselage</th>
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<th>Low Density (1.1)</th>
<th>No Solvent (Class B)</th>
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Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
3M has a long successful history in the use of structural adhesives for bonding metal to composite. Learn more.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

**Surface Pre-Treatment**
- Eliminates chromates from surface treatment process
- Allows for out-of-tank preparation of metal substrates

**Structural Adhesive Bond Primers**
- Corrosion inhibitive pigment allows for increased service life
- Protect high-cost surface preparation helps preserve Chemical Surface Preparation Prior to bonding
- Water based and non-chromate options available

**Structural Adhesive Films and Pastes**
- High fracture toughness and peel strength
- Excellent pre-bond humidity performance on composite substrates
- Available in multiple cure temperatures

**Advanced Composite Protection Cocure Films**
- Game-changing technology for erosion and abrasion protection of composite parts
- Processing temperatures up to 400 °F and service temperatures up to 250 °F
- Able to be cocured with composite parts or post bonded with structural adhesives (built-in erosion protection)
Urethane Repair Pastes

- Urethane paste designed for durable erosion resistance equivalent to original 3M film
- In-place repairability of cured 3M Cocure film helps reduce waste and downtime
- No intentionally added solvent in composition helps reduce shrinkage and rework

Fan Track Abradable / Void Fillers

- Increases engine efficiency due to effective fan blade sealing
- Compound is sandable within 3 hours of mixing to reduce cycle time
- Numerous OEM approvals

Composite Resins

- One-part epoxy system for resin transfer molding
- High service temperature
- High compression strength
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

### Engine Components – Top Products

#### Surface Pre-Treatment

3M™ Surface Pre-Treatment AC-130-2 – Sol-gel based surface preparation for adhesive bonding of aluminum alloys, stainless steel and titanium

#### Structural Adhesive Bond Primers

3M™ Scotch-Weld™ Structural Adhesive Primer EC-3917 – Solvent based, chromated inhibitor. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films

3M™ Scotch-Weld™ Structural Adhesive Primer EC-3924B – Solvent based, chromated inhibitor. Complimentary to 250°F (120°C) cure adhesive films

3M™ Scotch-Weld™ Structural Adhesive Primer EW-5005 – Water based, non-chromated inhibitor. Appropriate for use with AC 130-2 sol gel surface prep. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films

#### Structural Adhesive Films and Pastes

3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2

3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2

3M™ Scotch-Weld™ Structural Adhesive Film AF 191

3M™ Scotch-Weld™ Epoxy Adhesive EC-3448

#### Urethane Repair Pastes

3M™ Scotch-Weld™ Repair Paste 2110 – black repair paste used with our black protective tapes.

3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also perfect for edge sealing

#### Fan Track Abradable / Void Fillers

3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3524 B/A – Fire retardant, void filling, edge-sealing, potting and complex gap-filling epoxy compound for aerospace weight reduction. Available in blue, white and black

3M™ Scotch-Weld™ Void Filling and Edge Sealing Compound EC-3500 B/A

#### Composite Resins

3M™ Matrix Resin 2894

3M™ Matrix Resin 2896

#### Advanced Composite Protection Cocure Films

3M™ Polyurethane Protective Tape 8730NA – (12 mil thick)

3M™ Polyurethane Protective Tape 8732NA – (24 mil thick)

3M™ Polyurethane Protective Tape 8734NA – (6 mil thick)

#### Other 3M Products

3M™ Nextel™ Ceramic Fibers and Textiles for Aerospace

- Nextel ceramic textiles can withstand extremely high temperatures and are extraordinarily durable, yet are also flexible and lightweight. Proven in flight and in space, they have long been used to manufacture seals and heat blankets that protect metal and composite components from engine heat and fire. Nextel ceramic fibers are also used to reinforce Ox-Ox Ceramic Matrix Composites (CMCs) for exhaust components and heat shields.
Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

Propulsion

Nacelle

3M solutions for honeycomb core structure such as engine nacelles include surface preparation, corrosion inhibiting bond primers, structural adhesives and surfacing films. Learn more.
Surface Pre-Treatment
• Helps reduce labor time and water usage
• Eliminates chromates from surface treatment process
• Allows for out-of-tank preparation of metal substrates

Structural Adhesive Bond Primers
• Corrosion inhibitive pigment allows for increased service life
• Protect high-cost surface preparation helps preserve Chemical Surface Preparation Prior to bonding
• Water based and non-chromate options available

Structural Adhesive Films and Pastes
• High fracture toughness and peel strength
• Excellent pre-bond humidity performance on both metal and composite substrates
• Available in multiple cure temperatures

Core Splice Structural Adhesive Films
• Thermally expanding films for gap filling
• High performance over a broad range of temperature
• Excellent shear strength even at elevated temperatures

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Propulsion
Nacelle

Advanced Composite Protection Cocure Films
- Game-changing technology for erosion and abrasion protection of composite parts
- Processing temperatures up to 400 °F and service temperatures up to 250 °F
- Able to be cocured with composite parts or post bonded with structural adhesives (built-in erosion protection)

Urethane Repair Pastes
- Urethane paste designed for durable erosion resistance equivalent to original 3M film
- In-place repairability of cured 3M Cocure film helps reduce waste and downtime
- No intentionally added solvent in composition helps reduce shrinkage and rework

Fan Track Abradable / Void Fillers
- Increases engine efficiency due to effective fan blade sealing
- Compound is sandable within 3 hours of mixing to reduce cycle time
- Numerous OEM approvals
Propulsion
Nacelle

Structural Adhesive Surfacing and Lightning Strike Protection Films
- Resistant to effects of humidity exposure during manufacture
- Cocure compatible with most epoxy composite pre-preg systems
- On both metal and composite substrates

Paint Replacement Films
- Fluoropolymer film is inherently resistant to chemicals and environmental agents to provide excellent substrate protection and long-term color stability
- Acrylic adhesive provides high initial adhesion and long-term holding power to a variety of substrates
- Meets industry flame resistance requirements for aircraft interiors, and has successfully been used in general aviation, commercial and military aircraft applications
- Usable for surface protection and paint replacement applications

Thermoformed Boots
- Hundreds of pre-formed shapes to meet your needs and prevents damage caused by rain and sand
- UV-stable polyurethane holds its clarity and minimal yellowing over time
- Virtually no reduction in transmissivity
Propulsion Nacelle – Top Products

Surface Pre-Treatment

Structural Adhesive Bond Primers
3M™ Scotch-Weld™ Structural Adhesive Primer EC-3917 – Solvent based, chromated inhibitor. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films.

3M™ Scotch-Weld™ Structural Adhesive Primer EC-3924B – Solvent based, chromated inhibitor. Complimentary to 250°F (120°C) cure adhesive films.

3M™ Scotch-Weld™ Structural Adhesive Primer EW-5005 – Water based, non-chromated inhibitor. Appropriate for use with AC 130-2 sol gel surface prep. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films.

Structural Adhesive Films and Pastes
3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2
3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2
3M™ Scotch-Weld™ Structural Adhesive Film AF 191
3M™ Scotch-Weld™ Epoxy Adhesive EC-3448

Core Splice Structural Adhesive Films
3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
3M™ Scotch-Weld™ Structural Core Splice Film AF 3024 – Highest expansion and lowest density of core splice films in our portfolio. Dual cure 250°F (120°C) or 350°F (175°C).
3M™ Scotch-Weld™ Structural Core Splice Film AF 3028
3M™ Scotch-Weld™ Structural Core Splice Film AF 3074 FST – Low Density Expanding Core Splice Film with FST (Flame, Smoke, Toxicity) Resistance

Advanced Composite
Protection Cocure films
3M™ Polyurethane Protective Tape 8730NA – (12 mil thick)

3M™ Polyurethane Protective Tape 8732NA – (24 mil thick)
3M™ Polyurethane Protective Tape 8734NA – (6 mil thick)

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3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also perfect for edge sealing

Fan Track Abradable / Void Fillers
3M™ Scotch-Weld™ Core Splice Adhesive EC-3524 B/A
3M™ Scotch-Weld™ Core Splice Adhesive EC-3500 B/A – Superior compressive strength of 6000 psi with only 0.64 g/cm density

Structural Adhesive Surfacing and Lightning Strike Protection Films
3M™ Scotch-Weld™ Composite Surfacing Film AF 325 M & AF 325LS
3M™ Scotch-Weld™ Composite Surfacing Film AF 191XSA
3M™ Scotch-Weld™ Composite Surfacing Film AF 536

Paint Replacement Films
3M™ Surface Protection Film 3952 – Provided without adhesive for cocure applications
3M™ Paint Replacement Tape 5004 – Designed as a paint replacement. Excellent moisture barrier and Skydrol™ hydraulic fluid resistant

Thermoformed Boots
FP 151, FP 231, FP 232

Protect Your Crew
Products that work as hard as you do. From the most basic to the most specialized needs, 3M offers the health and safety protection you and your workers need most, so everyone can perform at their best.
Propulsion
Fan Blades

Structural adhesive bonding for high temperature applications and bonded-in composite erosion protection solutions are just the start. Learn more about 3M fan blade/cold-side engine applications.

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Propulsion
Fan Blades

Surface Pre-Treatment

- Helps reduce labor time and water usage
- Eliminates chromates from surface treatment process
- Allows for out-of-tank preparation of metal substrates

Structural Adhesive Bond Primers

- Corrosion inhibitive pigment allows for increased service life
- Protect high-cost surface preparation helps preserve Chemical Surface Preparation Prior to bonding
- Water based and non-chromate options available

Structural Adhesive Films

- High fracture toughness and peel strength
- Excellent pre-bond humidity performance on composite substrates
- Available in multiple cure temperatures

Structural Adhesive Composite Surfacing Films

- Cocure compatible with most epoxy composite prepreg systems
- Smooth surfacing with minimal pinholes and imperfections
- Available in multiple cure temperatures

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Propulsion
Fan Blades

Advanced Composite Protection Cocure Films
- Game-changing technology for erosion and abrasion protection of composite parts
- Processing temperatures up to 400°F and service temperatures up to 250°F
- Able to be cocured with composite parts or post bonded with structural adhesives (built-in erosion protection)

Urethane Repair Pastes
- Urethane paste designed for durable erosion resistance equivalent to original 3M film
- In-place repairability of cured 3M cocure film helps reduce waste and downtime
- Composition helps reduce shrinkage and rework

Composite Resins
- One-part epoxy system for resin transfer molding
- High service temperature
- High compression strength
Propulsion Fan Blades – Top Products

Surface Pre-Treatment
3M™ Surface Pre-Treatment AC-130-2 – Sol-gel based surface preparation for adhesive bonding of aluminum alloys, stainless steel and titanium

Structural Adhesive Bond Primers
3M™ Scotch-Weld™ Structural Adhesive Primer EC-3917 – Solvent based, chromated inhibitor. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesives Primer EC-3924B – Solvent based, chromated inhibitor Complimentary to 250°F (120°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesive Primer EW-5005 – Water based, non-chromated inhibitor Appropriate for use with AC 130-2 sol gel surface prep. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films

Structural Adhesive Films
3M™ Scotch-Weld™ Structural Adhesive Film AF 191 – 350°F (175°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2 – 250°F (120°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2 – Dual cure 250°F (120°C) or 350°F (175°C)

Structural Adhesive
Composite Surfacing Films
3M™ Scotch-Weld™ Composite Surfacing Film AF 325 M & AF 325LS – Available in white and blue versions
3M™ Scotch-Weld™ Composite Surfacing Film AF 536 – Multiple film weight options available. Can be cured at either 250°F (120°C) or 350°F (175°C)

Urethane Repair Pastes
3M™ Scotch-Weld™ Repair Paste 2110 – black repair paste used with our black protective tapes
3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also could be used for edge sealing

Composite Resins
3M™ Matrix Resin 4891 – For structural parts requiring high compression strength and high temperature performance
3M™ Matrix Resin 2896

Advanced Composite
Protection Cocure Films
3M™ Polyurethane Protective Tape 8730NA – 12 mil thick
3M™ Polyurethane Protective Tape 8732NA – 24 mil thick
3M™ Polyurethane Protective Tape 8734NA – 6 mil thick

Please ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.
Propulsion
Rotor Blades

3M has long been the supplier of choice for challenging helicopter rotor blade bonding and surface protection applications. Learn more.
Propulsion
Rotor Blades

Surface Pre-Treatment
- Helps reduce labor time and water usage
- Eliminates chromates from surface treatment process
- Allows for out-of-tank preparation of metal substrates

Structural Adhesive Bond Primers
- Corrosion inhibitive pigment allows for increased service life
- Protect high-cost surface preparation Helps Preserve Chemical Surface Preparation Prior to Bonding
- Water based and non-chromate options available

Structural Adhesive Films
- High fracture toughness and peel strength
- Excellent pre-bond humidity performance on composite substrates
- Available in multiple cure temperatures

Core Splice Structural Adhesive Films
- Thermally expanding films for gap filling
- High performance over a broad range of temperature
- Excellent shear strength even at elevated temperatures

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**Propulsion**

**Rotor Blades**

**Advanced Composite Protection Cocure Films**
- Game-changing technology for erosion and abrasion protection of composite parts
- Processing temperatures up to 400 °F and service temperatures up to 250 °F
- Able to be cocured with composite parts or post bonded with structural adhesives (built-in erosion protection)

**Polyurethane Protection Films and Tapes**
- Highly durable, long service life
- Meets several OEM specifications
- Protect rotor blades to avoid replacement

**Urethane Repair Pastes**
- Urethane paste designed for durable erosion resistance equivalent to original 3M film
- In-place repairability of cured 3M cocure film helps reduce waste and downtime
- Helps reduce labor time and water usage

**Thermoformed Boots**
- Hundreds of pre-formed shapes to meet your needs and prevents damage caused by rain and sand
- UV-stable polyurethane holds its clarity and minimal yellowing over time
- Virtually no reduction in transmissivity
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## Propulsion Rotor Blades – Top Products

### Surface Pre-Treatment
3M™ Surface Pre-Treatment AC-130-2 – Sol-gel based surface preparation for adhesive bonding of aluminum alloys, stainless steel and titanium

### Structural Adhesive Bond Primers
3M™ Scotch-Weld™ Structural Adhesives Primer EC-3924B – Solvent based, chromated inhibitor. Complimentary to 250°F (120°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesives Primer EC-3917 – solvent based, chromated inhibitor. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films
3M™ Scotch-Weld™ Structural Adhesives Primer EC-1660
3M™ Scotch-Weld™ Structural Adhesives Primer EW-5005 – Water based, non-chromated inhibitor. Appropriate for use with AC 130-2 sol gel surface prep. Complimentary to both 250°F (120°C) and 350°F (175°C) cure adhesive films

### Structural Adhesive Films
3M™ Scotch-Weld™ Structural Adhesive Film AF 3109-2 – Dual cure 250°F (120°C) or 350°F (175°C)
3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2 – 250°F (120°C) cure
3M™ Scotch-Weld™ Structural Adhesive Film AF 191 – 350°F (175°C) cure
3M™ Scotch-Weld™ Epoxy Adhesive AF 30

### Core Splice Structural Adhesive Films
3M™ Scotch-Weld™ Structural Core Splice Film AF 3024
3M™ Scotch-Weld™ Structural Core Splice Film AF 3002
3M™ Scotch-Weld™ Structural Core Splice Film AF 3028
3M™ Scotch-Weld™ Structural Core Splice Film AF 3074FST

### Advanced Composite Protection Cocure Films
3M™ Polyurethane Protective Tape 8730NA – (12 mil thick)
3M™ Polyurethane Protective Tape 8732NA – (24 mil thick)
3M™ Polyurethane Protective Tape 8734NA – (6 mil thick)

### Polyurethane Protection Films and Tapes
3M™ Polyurethane Protective Tape 8545HS
3M™ Polyurethane Protective Tape 8542HS
3M™ Polyurethane Protective Tape 8999 K11 Rotor Blade Protection Kit
UH-60M: SJ8542HS FP641 Patch
3M™ Polyurethane Protective Boot SJ 8542 HSFP637 Boot
3M™ Polyurethane Protective Boot SJ8542HS FP-641 (UH-60M)

### Urethane Repair Pastes
3M™ Scotch-Weld™ Repair Paste 2110 – black repair paste used with our black protective tapes
3M™ Scotch-Weld™ Repair Paste 2220 – clear repair paste used with our transparent tapes, also perfect for edge sealing

### Thermoformed Boots
FP 637, FP 532, FP 557, FP 558, FP 595

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One source. Many solutions.
3M Aircraft MRO Heavy Check

From adhesives to abrasives and films, from tapes to safety products, 3M has a deep and extensive offering of solutions tailored specifically for the aerospace industry.
Aircraft MRO Heavy Check Applications

**Abrasives**
Engineered to last longer, 3M’s diverse and distinct family of abrasives help return surfaces to their original state.
- Abrasives for Structural Repair
- Light Corrosion and Sealant Removal
- Sand Fairings and Flight Control Surfaces
- Abrasives for Composites
- Decal and Placard Removal on Metal
- Metal Stress Relieving

**Aircraft Graphics**
3M™ graphics and films help preserve and enhance an aircraft’s appearance.
- Interior

**Aircraft Painting**
Achieve a clean and smooth surface to apply paint and decorative livery with a breadth of 3M™ aircraft painting solutions.
- Chemically Strip and/or Sand
- Surface Preparation and Primer Application
- Base Coat and Paint Application, Striping, Livery and Clear Coat
- Detail Finish and Repair

**Cleaning**
Prevent corrosion and inspire confidence with an extensive offering of 3M™ products that will help you clean surfaces inside and out.
- General Cleaning
- Interior
- Exterior
- Seat Track Cleaning
- Borehole Cleaning
- Oxygen Line Cleaning

**Composite Repair**
To ensure the strongest and longest lasting bond, rely on 3M and our vast offering of tapes, abrasives and adhesives designed for composite maintenance.
- Tapes for Composite Repair
- Adhesives for Composite Repair
- 3M™ Scotch-Weld™ Epoxy Adhesives and Accessories

**Corrosion Management**
Preventing and removal of corrosion is critical in ensuring the long-term viability of an aircraft. Rely on 3M’s corrosion management solutions.
- Wet Area Corrosion Prevention
- Corrosion Removal

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Aircraft Painting

Broad solutions. Beautiful Results.

True excellence in aircraft painting requires products that work – not just at a glance, but below the surface and behind the scenes. 3M delivers with a broad range of solutions for performance, reliability and added efficiency from strip/sand to surface prep to sealing.
You’re Fully Covered

Chemically Strip and/or Sand

3M provides the right solutions for comprehensive cleaning, paint removal, masking and sanding procedures. 3M™ Cubitron™, Scotch-Brite™ and Versaflo™ brands, among others, deliver reliable performance and protection inside and outside the aircraft.

1. Protecting Aircraft Interior
2. Clean & Wash Aircraft
3. Masking
4. Applying Paint Stripper
5. Removing Paint Residue

Surface Preparation and Primer Application

Preparing surfaces for painting requires some of the most precise solutions for aircraft maintenance, repair and operations. 3M provides world-class masking solutions, pre-treatments, primer application equipment and personal protective equipment for almost every phase of the job.

1. Remasking
2. DeOxidizing Aluminum Surfaces
3. Applying Surface PreTreatment
4. Applying Primer
Base Coat and Paint Application, Striping, Livery and Clear Coat

It’s not enough just to create the right patterns and colors in the right places. Through our 3M™ Accuspray™ spray gun system and our 3M™ PPS™ Paint Preparation System of disposable paint cups, 3M ensures that you apply coatings quickly and efficiently as well.

1. Applying Base Coat
2. Painting Stripes & Decorative Livery
3. Painting Composite Fairings & Access Panels

Detail Finish and Repair

When the right finish really matters, 3M delivers. Our critical edge masking tapes, time-honored Wetordry™ and Trizact™ abrasives designed specifically for the finishing, high-performance sealants and more provide results that stand up to scrutiny.

1. Painting Touch-Ups
2. Paint Defect Repairs
3. Applying Sealants
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A Century of Science. The Full Depth of Solutions.

Cleaning
3M™ Doodlebug™ Pad Holder 6472
Scotch-Brite™ Aircraft Cleaning Pad

Abrasives, Sanding and Buffing
3M™ Cubitron™ II Film Disc 775L
3M™ Cubitron™ II Hookit™ Clean Sanding Film Disc 775L
Scotch-Brite™ Hand Pad 7447
3M™ Elite Random Orbital Sanders
Scotch-Brite™ 7447 PRO Disc
3M™ Trizact™ Hookit™ Foam Abrasive Disc 443SA
3M™ Trizact™ Hookit™ Clear Coat Sanding Abrasive Disc 471LA
3M™ Trizact™ Finesse-it™ Film Disc Roll 466LA
3M™ Finesse-it™ Polish - K211
3M™ Buffers
3M™ Purple Finishing Film Abrasive Disc 260L
3M™ Perfect-it™ EX AC Rubbing Compound
3M™ Perfect-it™ EX Machine Polish
3M™ Perfect-it™ EX Ultrafine Machine Polish
3M™ Hookit™ Dust Free Sanding Block
3M™ Hookit™ Purple Clean Sanding Abrasive Disc

Masking
3M™ High Performance Green Masking Tape 401+
3M™ Aluminum Foil Tape 425 PL1308
3M™ Aluminum Foil Tape 427
3M™ Plastic Sheeting
3M™ Vinyl Tape 471
3M™ Vinyl Tape 471+
3M™ Paint Masking Tape 231/231A
Scotch® Fine Line Tape 218
3M™ Hand-Masker™ Advanced Masking Film
3M™ Masking Paper
Scotch® Solvent Resistant Masking Tape 226
3M™ High Performance Masking Tape 232
3M™ Performance Masking Tape 2380

Surface Protection
3M™ Dirt Trap Protection Material Floor Applicators
3M™ Dirt Trap Protection Material
3M™ Self-Stick Liquid Protection Fabric
3M™ Dirt Trap Protection Material Dispenser
3M™ Dirt Trap Protection Material Wall Applicator

Painting
3M™ Accuspray™ ONE Spray Gun System with Standard PPS™
3M™ High Power Spray Gun Cleaner
3M™ PPS™ Paint Preparation System
3M™ PPS™ Series 2.0 Spray Cup System
3M™ Accuspray™ Regulator and Air Flow Control Valve
3M™ Surface Pre-Treatment AC-131

Safety Equipment
Eye, Hearing and Body Protection
3M™ Disposable Protective Coverall 4540+
3M™ Chemical Protective Coverall 4570
3M™ SecureFit™ Protective Eyewear Family
3M™ GoggleGear™ 500 Series GG501SGAF, Clear Scotchgard™ Anti-fog lens
3M™ E-A-R™ UltraFit™ Earplugs 340-4004
3M™ E-A-R™ Reusable Earplugs
3M™ PELTOR™ X4 Earmuffs X4A/37273(AAD), Over-the-Head
3M™ Ratchet Headgear H8A with 3M™ Clear Polycarbonate Faceshield WP96

Respiratory
3M™ Versaflo™ Powered Air Purifying Respirator Painters Kit TR-800-PSK/94248(AAD)
3M™ Ultimate FX Full Facepiece Reusable Respirator, FF-400 Series
3M™ Organic Vapor/Acid Gas Cartridge/Filter 60923, P100
3M™ Particulate Respirator 8511, N95
3M™ Particulate Filter 2097/07184(AAD), P100, with Nuisance Level Organic Vapor Relief
3M™ Rugged Comfort Half Facepiece Reusable Respirator, 6500 Series

Fall Protection
3M™ DBI-SALA® Delta™ Vest-Style Resist Web Harness 1110994
3M™ DBI-SALA® Web Scaffold Choker 1201390
3M™ DBI-SALA® Nano-Lok™ Quick Connect Self Retracting Lifeline, Web 3101225

Sealants
3M™ Aerospace Sealant AC-350
3M™ Aerospace Sealant AC-380
3M™ Aerospace Sealant AC-735
3M™ Aerospace Sealant AC-770
3M™ Aerospace Sealant AC-251


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Thank you.

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