



**Document Library**  
**Technical Data Sheet 08273;**  
**Technical Data Sheet 08269**

**Public**

Rev:1

Effective: 11/17/2003

Status: Active

**3M™ Automix™ Truck Line SMC/Fiberglass Repair Adhesive-35**

**Data Sheet**

**3M Part No.(s)**                      **3M Part Descriptor(s)**  
 08273; 08269

**3M Fax on Demand Identification Number:**

**Description**

3M™ Automix™ Truck Line SMC/Fiberglass Repair Adhesive-35 is a two part urethane used to adhere SMC and FRP (traditional fiberglass) body panels to each other and to metal frames. (Metal must be primed with a two part epoxy primer). Approved and used at OEM.

**Features, Advantages, Benefits**

<b>Features</b>	Automatic mixing Excellent sag resistance Fast cure time Same as OEM Flexible
<b>Advantages</b>	Takes out guesswork, Stays where applied, no running down the panel Speeds up repair time Same flexibility and strength as OEM Will not crack or release under stresses
<b>Benefits</b>	Consistent cure rate Less clean up Saves time Back to original adhesive used at OEM Quality repair

**Typical Physical Properties**

<b>Container</b>	400 ml and 600 ml duo pack cartridge	Part B
<b>Base</b>	Part A Urethane	Curative
<b>Density g/cc (Appx.)</b>	1.28	
<b>Color</b>	Green	White
<b>Solids Content (Appx.)</b>	100 %	100 %
<b>Consistency</b>	Viscous Liquid	Viscous Liquid

---

### Product Uses

3M™ Automix™ Truck Line SMC/Fiberglass Repair Adhesive-35 is used to bond SMC and FRP (traditional fiberglass) to each other, such as fenders, roofs and large panels.

---

### Performance Properties

At 72° F:

Work time = 35 minutes

Clamp time = 2 hours

Cure time = 3 hours

## Handling and Application Information

---

### Directions for Use

Complete Directions for Use are in each package.

\* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. 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.

---

### Applications

Dry fit the new panel. Clean the bonding areas with 3M™ General Purpose Adhesive Cleaner (P.N. 08984, 08986) or 3M™ Automix™ Super Fast Adhesive Cleaner (P.N. 08215) . Abrade the area to be bonded with P 80 grade sandpaper. Blow off with clean compressed air; do not solvent wipe. Apply a continuous 1/2" X 1/2" bead of adhesive to the abraded area. Mate the two parts and clamp for 2 hours (at 72 Deg. F).

---

### Storage and Handling

Store at room temperature. Shelf life is 24 months.

---

### Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product  
MSDS Doc# 09-5341-4

### Country

**This document is public. It may be distributed.**

---

### Warranty and Limited Remedy

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

**LIMITATION OF LIABILITY: 3M and seller will not be liable for any loss or damage arising from this 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.**

---

### For Additional Health and Safety Information

3M Automotive After Markets  
3M Center, Building 223-6N-01  
Saint Paul, MN 55144-1000  
1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.  
Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

**3M Fax on Demand/MSDS Identification Number**

**Author:** Kathy M. Morales/US-Corporate/3M/US

**Modifiers:** Kathy M. Morales/US-Corporate/3M/US

**This is the last page**