

# Leading bodyshops follow OEM repair procedures



Help protect yourself, your bodyshop  
and your customer by repairing  
the right way, every time.



# Setting your shop up for success



## Research

Search the original equipment manufacturer's website for the most up-to-date repair procedures, process guides, bulletins and positioning statements important to the repair.



## Document the procedure

Make sure to document the procedure at the time of repair. If a vehicle needs reinspection, the original repair order should include a copy of the OEM repair procedures used, before and after photos and the detailed report of any scan.



## Improve accuracy

Checking OEM repair procedures before starting a repair can help you write more accurate estimates, order the correct parts and source the proper products.



## Always validate

Even if you have repaired the same vehicle multiple times, it is important to validate OEM procedures and products as they can change frequently with updated technology and materials.



## Select the right products

When repairing a vehicle, it's not just how you do it, it's also about using the right solutions to complete the repair in the right way. OEMs call out specific products for use in the repair to achieve the best results.



## Get paid

Following OEM repair procedures can help you get paid for the work you do and the materials you use to complete the repair. Build your research and materials into the repair estimate.

# Use trusted products

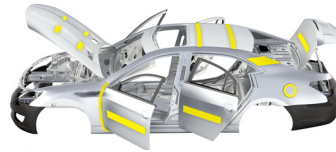
3M has been working with OEMs for decades and is more often referenced in OEM repair procedures for panel bonding and impact resistant structural adhesives than any other adhesive supplier.

## Common applications for OEM repairs.

Always validate and follow OEM procedures.



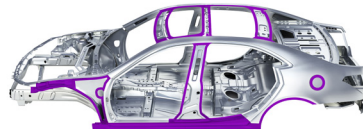
● PANEL BOND



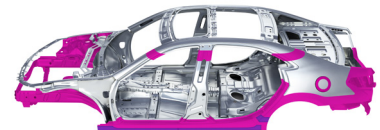
● FLEXIBLE FOAM/NVH



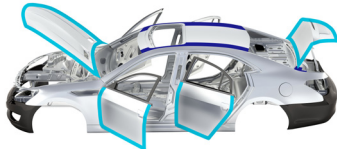
● OEM MATCH, 1-PT  
URETHANES AND MSP



● STRUCTURAL ADHESIVES



● CAVITY WAX



● OEM MATCH, 05887

● OEM MATCH, 05887



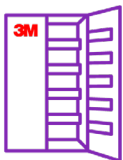
● STONECHIP COATING

## Unlock more opportunities for profit at your bodyshop.

Coming  
soon!

### 3M™ RepairStack™ Performance Solutions

Designed to help advance bodyshop efficiency, profitability and performance. A fully integrated and automated material management, invoicing and performance analytics solution to help you track and get paid for the materials you use to complete the repair the right way.



#### 3M™ RepairStack™ Inventory Management

Helps keep your body shop well-organised

- Track usage of 3M and non-3M products
- Automatically reorder supplies
- Stock all necessary materials to improve touch and cycle time



#### 3M™ RepairStack™ Billables Invoicing

Designed to help get paid for 3M and non-3M materials

- Bill for materials you never knew were recoverable
- Integrate with leading bodyshop management systems
- Streamline blueprinting and billing processes



#### 3M™ RepairStack™ Performance Analytics Tool

Get valuable insights and help increase profits

- Integrate with leading bodyshop management systems
- Analyse your business performance
- Monitor KPIs in real-time to identify areas for profitability


# 3M solutions for OEM repair procedures

When impact resistance matters.

## 3M™ Impact Resistant Structural Adhesive (IRSA)

3M™ Impact Resistant Structural Adhesive (IRSA) is formulated for true automotive OEM specified structural bonding applications. A two-part epoxy adhesive delivers extended worktimes – up to 1 hour – and can be rapidly heat cured. The adhesive changes from silver to purple as the adhesive cures.




Adhesives	Part #	Size	Colour	Chemistry	Qty/case	Description
 <b>3M™ Impact Resistant Structural Adhesive</b>	07333	200mL	Dispenses ● Silver  Cures ● Purple	Epoxy	6/case	<div> <div>1 hr</div> <div>Work time</div> </div> <div> <div>8 hr</div> <div>Clamp time</div> </div> <div> <div>24 hr</div> <div>Cure time</div> </div> <p>Meets specific strength requirements for parts such as frame rails, strut towers, sills, pillars and other areas where impact resistance is important. Possesses a much greater ability than traditional bonding adhesives to absorb and manage energy under a variety of forces, especially peel and cleavage stresses in extreme temperature conditions. Use in conjunction with rivets, spot welds or mechanical fasteners.</p>

Proven and trusted performance.

## 3M™ Panel Bonding Adhesive

3M™ Panel Bonding Adhesive is a cost-effective two-part epoxy adhesive for bonding replacement body panels. From its fast, convenient cartridge system the adhesive seals and bonds steel, aluminium, SMC and FRP securely in a single operation.




Adhesives	Part #	Size	Colour	Chemistry	Qty/case	Description
 <b>3M™ Panel Bonding Adhesive</b>	08115	200mL	● Black	Epoxy	6/case	<div> <div>90 min</div> <div>Work time 31°C</div> </div> <div> <div>4-6 hr</div> <div>Clamp time</div> </div> <div> <div>24 hr</div> <div>Cure time</div> </div> <p>Designed to meet specific strength requirements for outer sheet metal panel replacement. Typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.</p>
	08116	200mL				

Fast, flexible and easy to sand.

## 3M™ EZ Sand Multi Purpose Repair Material

3M™ EZ Sand Multi Purpose Repair Material is a ready-to-use 2-part epoxy finishing adhesive material that dries to a flexible hardness, ideal for repairing plastic parts such as bumper covers and body panels. It applies easily from a 3M applicator gun mixing nozzle, with no pre-mixing or measuring. It is quickly sandable for excellent featheredge and paintable in as little as 30 minutes.



Plastic Repair	Part #	Size	Colour	Qty/case	Description
 <b>3M™ EZ Sand Multi Purpose Repair Material</b>  Can be used as seam sealer	35887	50mL	● Grey	6/case	<div> <div>5 min</div> <div>Work time</div> </div> <div> <div>15 min</div> <div>Sand time</div> </div> <div> <div>24 hr</div> <div>Cure time</div> </div> <p>Two-part epoxy used to repair most flexible parts. May also be used as a seam sealer where a rounded edge seam is required. This semi-flowable material creates the perfect bead matching many OEM applications.</p>
	05887	200mL			

\* Note: The above are general descriptions, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.



Bring it all together.

## Accessories for IRSA, Panel Bonding Adhesives and 3M™ EZ Sand Multi-Purpose Repair Material


Accessories	Part #	Size	Features/applications
3M™ Static Mixing Nozzle	04908	47.5mL	Bulk pack (50)
3M™ Static Mixing Nozzle	08193	200mL	nozzle for 2 component products 200mL
3M™ Performance Pneumatic Applicator	09930	200mL	Pneumatic (for 200mL product)
3M™ Performance Manual Applicator	08117		Manual (for 200mL product)
3M™ Performance Manual Applicator	08190	50mL	Manual (for 50mL product)
3M™ Standard Manual Applicator	08571	200mL	Economy line applicator with heavy duty construction

Corrosion protection you can trust for internal cavities in a convenient aerosol can.

### 3M™ Cavity Wax Plus

3M™ Cavity Wax Plus is a non-hardening, self-healing corrosion protection coating for internal auto body panels and structural enclosures, as well as new replacement parts. It is designed to cover and seal internal joints, hem flanges and other areas where OEM e-coat may be compromised. It will not chip, peel or crack.



Spray coatings	Part #	Size	Qty/case
 <b>3M™ Cavity Wax Plus</b>	08852	538mL	4/case

Accessories	Part #	Size
3M™ Cavity Wax Plus Applicator Wand Kit	08851	20cm, 51cm and 86cm wands

Note: the above are general descriptions, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.





# 3M solutions for OEM repair procedures






For OEM Seam Sealer replication.

## 3M OEM Match Family Overview

3M offers professional grade seam sealers, nozzles, tips and applicators to allow technicians of all skill levels to easily replicate OEM seams. The OEM Match family joins the full line of 3M™ Seam Sealers to give bodyshops a full toolset to meet the demands of OEM procedures.

Additionally, all nuzzles and seam sealers are recoverable items when using the 3M™ RepairStack™ and billable materials invoicing software.

Sealers applicators	Part #	Size	Qty/case	Description
 <b>3M™ Flexible Package Pneumatic Applicator</b>	08012	310mL	1/case	Pneumatic – For smooth application of 310mL and 290mL cartridges Fully enclosed
 <b>3M™ Manual Applicator</b>	08014	310 mL, sachets (up to 415 ml) where an air line is not available	1/case	3M™ Manual Gun for Cartridge and Sachet, High Power Version



OEM Match Nozzles	Part #	Colour	Qty/case	Fitting
 <b>3M™ OEM Match Wing Nozzle 1K Tip</b>	33992	○ White	10 nozzles/pack, 5 packs/case	1K MSP or Urethane Seam Sealer in Cartridge
 <b>3M™ OEM Match Wide Stream 1K Tip</b>	33993	○ White		
 <b>3M™ OEM Match Ripple 1K Tip</b>	33994	○ White		
 <b>3M™ OEM Match Sprayable 1K Tip</b>	33991	○ White		1K MSP Seam Sealer in Cartridge
 <b>3M™ OEM Match Air Supply Kit</b>	33999	● Black	10 kits/case	Fits to all 3M™ Pneumatic Applicators to allow spray application of seam sealers



# Improve your repair process with 3M™ Multi-Purpose Seam Sealer.

## 3M™ Multi-Purpose Seam Sealer


Our sealer allows wet on wet painting for faster sealing processing times. It can be sprayed, extruded or brushed.

One-Part Seam Sealers	Part #	Size	Colour	Chemistry	Qty/case	Description
 <b>3M™ MSP Seam Sealer</b>	08855	290mL	○ White	MSP	6/case	<div> <div>5 min</div> <div>Work time</div> </div> <div> <div>0 min</div> <div>Paint time Solvent</div> </div> <div> <div>5 min</div> <div>Paint time Water</div> </div> <p>One-part formula is ready to use without any mixing. High quality, heavy-bodied, general purpose, moisture-curing seam sealer for interior and exterior body joints. Adheres well to properly prepared primer, paint and bare metal surfaces.</p> <p>Tack free in 30 minutes and is immediately paintable.</p>
	50740	310mL cartridge	● Beige			
 <b>3M™ MSP Sprayable Seam Sealer</b>	08851	290mL cartridge	● Grey	MSP	6/case	<div> <div>5 min</div> <div>Work time</div> </div> <div> <div>0 min</div> <div>Paint time Solvent</div> </div> <div> <div>5 min</div> <div>Paint time Water</div> </div> <p>High-performance, general-purpose seam sealer that can be caulked or sprayed. Convenient, easy-to-apply sealer adheres well to all primed surfaces, except acrylic lacquer. It offers the convenience of allowing for painting almost immediately after being applied.</p>

## Create tight, long-lasting seals.

## 3M™ Urethane Seam Sealer




3M™ Urethane Seam Sealer is a high solids seam sealer ideal for sealing automotive and RV seams and joints. It adheres well to bare metal, primed metal and painted surfaces, and if desired can be smoothed to a featheredge and/or brushed.

One-Part Seam Sealers	Part #	Product description	Colour	Packaging type	Volume	Description
 <div>3M™ Urethane Seam Sealer</div>	08694	Polyurethane range	● Black	Cartridge	310mL	<div><div><div>5 min</div><div>Work Time</div></div><div><div>30 min</div><div>Paint Time Solvent</div></div><div><div>45 min</div><div>Paint Time Water</div></div></div> <p>A high performance seam sealer ideal for sealing interior and exterior automotive and RV seams and joints. Adheres well to properly prepared bare metal, primer and e-coat surfaces. May be welded through using STRSW equipment. Can be smoothed to a featheredge and/or brushed. Reduces the risk of re-dos associated with the use of solvent-based seam sealers.</p>
	08684		● Grey			
	08689		○ White			
	08365		● Beige			
	08789	Polyurethane seam sealer	● Black	Sachet	310mL	
	08782		● Grey			
	08787		○ White		600mL	
	08793		● Black			
	08783		● Grey			
	08788		○ White			



# The extended family

## Additional 3M solutions to help follow OEM repair procedures.

Sound deadening material	Part #	Size	Colour	Chemistry	Qty/case	Description
	08463	200mL	● Grey	Two-part urethane	6/case	<div><div><div>40 sec</div><div>Work time</div></div><div><div>1 hr</div><div>Cure time</div></div></div> <p>Fast, easy and effective replacement of OEM flexible foams in automotive applications. Material expands to 10 times its liquid volume, creating a closed-cell foam that won't shrink and closely mimics OEM foam properties for insulation, sound-deadening and temperature resistance.</p>
Spray coatings	Part #	Size	Colour		Qty/case	Description
	50410	377mL	● Grey		6/case	Aerosol coating designed to prevent corrosion between welded metal surfaces. Featuring a zinc base that draws corrosion away from bare metals, it helps prevent costly comebacks due to corrosion at welds. Spray coating applies fast, resists weld spatter common to some weldable primers and dries in as little as 5 minutes.
Fast Cure Epoxy Metal Filler	Part #	Size	Colour		Qty/case	Description
	37455	180 mL	● Hardener: Black, ○ Base: Cream-White		1 cartridge + 1 nozzle	3M™ FC Epoxy Metal Filler is a fast curing filler for all metal substrates (steel, aluminium) to fill deeper dents, shape and model structures of the surface and provide corrosion protection for welded seams.

Note: the above are general descriptions, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.

Scan the QR code to discover more  
3M Solutions for Collision Repair



3M United Kingdom PLC  
Automotive Aftermarket  
3M Centre, Cain Road,  
Bracknell, RG12 8HT  
Phone: +44 (0)161 237 6391  
aadukenquiries@mmm.com

For additional information, including important safety and warranty information, regarding 3M Automotive Aftermarket Products, please visit: [www.3M.co.uk/aad-info](http://www.3M.co.uk/aad-info)

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