



Document Library
Technical Data Sheet 08223

Public

Rev:1

Effective: 02/06/2006

Status: Active

3M™ Automix™ Universal Adhesive

Data Sheet

3M Part No.(s)	3M Part Descriptor (s)
08223	3M™ Automix™ Universal Adhesive

3M Fax on Demand Identification Number : 08223

Description

Two-part urethane that is a general purpose black adhesive for metal, glass and plastic. It is strong and durable and works on a wide variety of substrates.

Features, Advantages, Benefits

Features	Strong, durable adhesive Self-mixing
Advantages	Works on a wide variety of substrates Proper product ratio everytime
Benefits	Bonds similar and dissimilar materials in minutes Increases productivity

Typical Physical Properties

Container	200mL Automix™ cartridge
Base	Urethane
Density lbs/Gallon (Appx.)	10.2/10.7
Color	Black/White
Flash Point - °F	>200 °F
Viscosity (CPS) Brookfield	12000 - 20000 centipoise
Viscometer	
Solids Content (Appx.)	100%
Consistency	Paste
Solvent	None
Service Temperature - °F	-20 to 180 deg F
Propellant	N/A
Boiling Point - °F	>=95 °F

Product Uses

Two-part urethane that is a general purpose black adhesive for metal, glass and plastic. It is strong and durable and works on a wide variety of substrates.

Performance Properties

Work time:	3 min
Clamp time:	25 min
Cure time:	4 hour

Handling and Application Information

Directions for Use

1. Size all parts for proper alignment.
 2. Clean plastic or metal surfaces to be bonded.
 3. Abrade plastic surfaces to be bonded with grade P80 3M™ Hookit™ Gold Film. Primed metal surfaces should be scuffed with Scotch-Brite™ General Purpose Hand Pad.
 4. Wipe with a clean rag. Then clean all abraded surfaces a second time with lacquer thinner.
 5. Insert 3M™ Automix™ Universal Adhesive 200mL syringe into 3M™ Applicator Gun.
 6. Remove end seal cap.
 7. Extrude a small amount of adhesive until both parts dispense equally.
 8. Attach 3M™ Mixing Nozzle to syringe. Lock in place with retaining collar.
 9. Apply a sufficient amount of adhesive to one surface.
 10. Assemble as soon as possible - no to exceed 3 minutes after applying adhesive. Clamp if necessary. Allow material to cure before continuing repair. Typically 25 minutes is sufficient for handling strength.
-

Applications

Two-part urethane that is a general purpose black adhesive for metal, glass and plastic. It is strong and durable and works on a wide variety of substrates.

Storage and Handling

HANDLING

Avoid eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining. Avoid breathing of vapors, mists or spray. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Contents may be under pressure, open carefully. Avoid contact with water to prevent potentially violent reaction or fire.

STORAGE

Keep container tightly closed. Store away from acids. Store away from heat. Store out of direct sunlight. Keep container in well ventilated area.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product . Hazardous polymerization may occur. May cause allergic skin reaction. May cause allergic respiratory reaction. Contains a chemical or chemicals which can cause cancer.

Country

US

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 Aftermarket Division

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 08223

Author: Brett D. Einerson/US-Corporate/3M/US

Modifiers: Brett D. Einerson/US-Corporate/3M/US

This is the last page

