



Public

Rev:1

Effective: 02/06/2006

Status: Active

3M™ Automix™ Semi-Rigid Plastic Parts Repair

Data Sheet

3M Part No.(s)	3M Part Descriptor (s)
08237	3M™ Automix™ Semi-Rigid Plastic Parts Repair

3M Fax on Demand Identification Number : 08237

Description

Two-part urethane used to repair semi rigid plastics such as Xenoy, RRIM, GTX, PPO, ABS, and a variety of other types. Longer work time for larger area repairs.

Features, Advantages, Benefits

Features	Urethane Chemistry
Advantages	Longer work time than 8235
Benefits	Great for larger repair areas

Typical Physical Properties

Container	200mL Automix™ cartridge
Base	Urethane
Density lbs/Gallon (Appx.)	10.7/10.2
Color	White/Black
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 Temperature - °F	>95 °F

Product Uses

Two-part urethane used to repair semi rigid plastics such as Xenoy, RRIM, GTX, PPO, ABS, and a variety of other types. Longer work time for larger area repairs.

Performance Properties

Work time:	3 min
Sand time:	30 sec
Cure time:	4 hour

Handling and Application Information

Directions for Use

1. Clean the areas to be bonded with soap and water. Next, use 3M™ General Purpose Adhesive Cleaner to remove any grease, wax and/or tar. Read manufacturer's recommended guidelines for safe handling of the above chemical products.

2. Grind the repair area with a 3 in. 3M™ Green Roloc™ Disc, grade 36 using a pistol grip air sander. Grind 1.5 in. around the actual damage, tapering into the damaged area.

NOTE: When involved in or near grinding operations, wear impact-resistant protective glasses and full face shield as specified in ANSI standard Z87.1

3. Observe the repair area.

a. If the part grinds cleanly with NO melted plastic next to the repair area proceed to System I, Step 4.

b. If the grinding operation melted the plastic (there is actually melted plastic next to the area that was ground), the part requires the use of 3M™ Automix Polyolefin Adhesion Promoter for both the repair material and any subsequent priming and/or painting operations. Proceed to System II, Step 4.

4. Featheredge paint around the repair with grade 180 disc on the DA sander. Also sand the outer edges of the repair area to round off any SHARP edges.

5. Wipe with a clean, dry rag and blow off with compressed air.

6. Insert 3M™ Automix™ Semi-Rigid Plastic Parts Repair 200mL syringe into 3M™ Applicator Gun.

7. Remove end seal cap.

8. Extrude a small amount of filler until both parts dispense equally.

9. Attach 3M™ Mixing Nozzle to syringe and lock in place with retaining collar.

10. Apply a thin coat of mixed filler material to the repair area making certain to completely "WET OUT" the surface.

11. Add additional extruded material. building up the repair higher than the surrounding undamaged area.

12. Allow the repair material to cure 30 minutes at 65-75°F.

13. Sand with a grade 180 abrasive followed by 240.

14. Wipe and blow off the surface with compressed air.

* 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

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Storage and Handling

HANDLING

Avoid contact with water to prevent potentially violent reaction or fire. 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 eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining.

STORAGE

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

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 08237

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