Urethane Seam Sealer
08360 • 08361 • 08364

Technical Data

<table>
<thead>
<tr>
<th>3M Part Numbers</th>
<th>3M Part Descriptor</th>
</tr>
</thead>
<tbody>
<tr>
<td>08360</td>
<td>3M™ Urethane Seam Sealer (white)</td>
</tr>
<tr>
<td>08361</td>
<td>3M™ Urethane Seam Sealer (gray)</td>
</tr>
<tr>
<td>08364</td>
<td>3M™ Urethane Seam Sealer (beige)</td>
</tr>
</tbody>
</table>

Product Description

3M™ Urethane Seam Sealer is a premium one-part moisture-curing automotive seam sealer designed for application to exterior and interior body seams. 3M™ Urethane Seam Sealer may be applied to properly prepared primer/paint coated surfaces or properly prepared bare metal surfaces. 3M™ Urethane Seam Sealer also functions as a weld through sealer when used in conjunction with squeeze type resistance spot welding (STRSW) operations. 3M™ Urethane Seam Sealer may be painted with common automotive type paint systems (water and solvent borne systems) in thirty minutes and up to 24 hours later (scuff after 24 hours).

Features

- Moisture Cure Technology
- Weld Through Capability
- Direct to Metal Application
- 310 mL Flexible Sleeve

Typical Physical Properties

<table>
<thead>
<tr>
<th></th>
<th>310mL Flexible Sleeve</th>
</tr>
</thead>
<tbody>
<tr>
<td>Container</td>
<td>310mL Flexible Sleeve</td>
</tr>
<tr>
<td>Base</td>
<td>Moisture Curing Urethane</td>
</tr>
<tr>
<td>Density lbs./Gallon (Approx.)</td>
<td>9.8</td>
</tr>
<tr>
<td>Color</td>
<td>White (08360), Gray (08361), Beige (08364)</td>
</tr>
<tr>
<td>Flash Point</td>
<td>92°F (33°C) (closed cup method)</td>
</tr>
<tr>
<td>Solids Content (Approx.)</td>
<td>95%</td>
</tr>
<tr>
<td>Consistency</td>
<td>Viscous Paste</td>
</tr>
<tr>
<td>Service Temperature</td>
<td>-20°F to 180°F (-28°C to 82°C)</td>
</tr>
<tr>
<td>Solvent</td>
<td>Minimal Xylene</td>
</tr>
</tbody>
</table>

NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.
3M™ Urethane Seam Sealer
08360 • 08361 • 08364

Product Uses
General sealing of interior and exterior automotive seams including floor pans, hem flanges, frame rails, rear body panels, aprons and other seams including those requiring weld through applications using squeeze type resistance spot welding.

Use with the following accessories:

- 3M™ Flexible Package Applicator – Pneumatic (PN 08399)
- 3M™ Flexible Package Applicator – Manual (PN 08398)
- 3M™ Flexible Package Nozzles (PN 08188 box/25)

For professional use only. Not intended for retail sale.

Performance Properties
NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

<table>
<thead>
<tr>
<th>Property</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cold Temperature Resistance at -20°F (-29°C)</td>
<td>Remains flexible</td>
</tr>
<tr>
<td>Heat Resistance: 8 Weeks at 200°F (93°C)</td>
<td>Remains flexible</td>
</tr>
<tr>
<td>Adhesion: Primed Metal: Excellent</td>
<td>Cohesive failure</td>
</tr>
<tr>
<td>Bare Metal: Excellent</td>
<td>Cohesive failure</td>
</tr>
<tr>
<td>Tensile Strength: Good</td>
<td>(230 psi)</td>
</tr>
<tr>
<td>Flexibility: Excellent</td>
<td>600% Elongation</td>
</tr>
</tbody>
</table>

Directions for Use

PRIMER OR PAINT SURFACE
1. Clean the surface with a VOC compliant surface cleaner to remove any contaminants.
2. Scuff the surface using a Scotch-Brite™ Scuff Pad or grade P180 to P320 abrasive.
3. Blow off and re-clean the surface to ensure proper adhesion.
4. Install foil package into barrel of 3M™ Flexible Package Applicator Gun (PN 08398).
5. Using a scissors, cut a small opening across the top end of package and fold back flaps.
6. Place nozzle over the opened end onto the gun barrel.
7. Replace the retaining collar.
8. Cut nozzle to provide desired bead size.
9. Apply seam sealer and tool (if necessary) to desired finished appearance.
10. Allow 30 minutes before painting, after 24 hours scuff with a Scotch-Brite™ Scuff Pad.
Directions for Use, cont.

WELD THROUGH

NOTE: For weld through operations (prior to welding the panel(s) make test welds on scrap parts to assure proper welding machine settings).

1. Remove coatings on all sides of weld flanges.
2. Apply seam sealer to all bare metal between weld flanges (brush to cover all bare metal).
3. Mate parts together and clamp in place.
4. Be sure to use a shunt clamp and start welds near the clamp.

BARE METAL

1. Clean the surface with a VOC compliant surface cleaner to remove any contaminants.
2. Grind any weld nuggets (grade 50 to 80) or scuff spot weld locations using a non-woven coarse grade surface conditioning disc or belt.
3. Blow off and re-clean the surface to ensure proper adhesion.
4. Install foil package into barrel of 3M™ Flexible Package Applicator Gun (PN 08398).
5. Using a scissors, cut a small opening across the top end of package and fold back flaps.
6. Place nozzle over the opened end onto the gun barrel.
7. Replace the retaining collar.
8. Cut nozzle to provide desired bead size.
9. Apply seam sealer and tool (if necessary) to desired finished appearance.
10. Allow 30 minutes before painting, after 24 hours scuff with a Scotch-Brite™ Scuff Pad

NOTE: 3M™ Urethane Seam Sealer may be applied to properly prepared bare metal and/or primer/paint coated surfaces, and can be used as a “weld through” sealer when squeeze type resistance spot welding equipment is used.

Acid etch primer is not recommended to be used in direct contact with any 3M seam sealer. Residual acid can weaken the bond.

Applications
General purpose automotive seams, including door skins, rocker panels, rear body panels, trunk seams, floor pans, etc.

Storage and Handling
Store at room temperature. Rotate stock on a “first-in-first-out” basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months. Use in a well-ventilated area.
Precautionary Information

Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOCs) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area.

Technical Information

The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use

Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy and Disclaimer

Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability

Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.