



Flexiclear™ Body Seam Sealer

08405

Technical Data Sheet

July 2017

3M Part No.(s)	3M Part Descriptor(s)
08405	3M™ Flexiclear™ Body Seam Sealer

Product Description A medium-bodied, clear sealer with good adhesion to properly prepared primer, paint metal, glass, and aluminum. May also be used on architectural surfaces, test for suitability prior to application. This is a low-modulus, caulk grade sealer.

- Features**
- Clear, non-yellowing
 - Standard “caulk” dispensing system
 - Fast drying

Typical Physical Properties

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

Container	1/10th gallon cartridge
Base	Synthetic Rubber
Density lbs/Gallon (Appx.)	8.0
Color	Clear
Flash Point - °F	40°F
Solids Content (Appx.)	64%
Consistency	Buttery Paste
Solvent	Toluene / Xylene
Service Temperature - °F	-20 to 180°F

Product Uses A medium-bodied, clear sealer with adhesion to primed and painted metal, glass, and aluminum. May also be used on architectural surfaces, test for suitability prior to application. This is a low-modulus, caulk grade sealer.

For professional use only. Not intended for retail sale.

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08405

Typical Performance Properties

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

1. Solids	61 +/- 1%
2. Sag, 30 Minutes	
1/4 inch bead	Approximately 0 inch
3/8 inch bead	0 inch
3. Tack Free Time	45-50 Minutes
4. Adhesion to:	
Glass	Good Painted
Metal	Very Good
Aluminum	Good
5. QUV 150°F/500 Hours	No effect on clarity or elastomeric properties
6. Flexibility (60 mil spread)	Flexible over a 2 inch Mandrel @ -20°F
7. Hardness, Tex	45

Directions for Use

NOTE: 3M Best Practice is that all sealers, unless designated specifically for use on bare metal, be applied to properly prepared automotive paint or primer. Applying over bare metal may not provide adequate corrosion protection. Flexiclear body seam sealer may be applied to clean unsanded paint.

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

1. If applying Flexiclear body seam sealer over paint, skip step one and begin with step 2, otherwise, lightly scuff the area where the sealer is to be applied.
2. If apply directly to a painted surface wash surface with soap and water first. For all substrates, be sure to clean with an appropriate VOC compliant product for removal of surface contaminants prior to application of sealer.
3. Cut nozzle tip to provide 1/4" diameter bead. Puncture foil seal in base of spout. Knock out end seal at the bottom of the tube.
4. Place in 3M Professional Caulking Gun, PN 08993 and engage ratcheting mechanism.
5. Apply desired bead width and tool to final appearance, if necessary. When sealing is complete, disengage ratchet to stop flow.
6. Wait to dry before applying paint over the sealer (if painting is desired). Thicker beads of seam sealer will take longer to cure before painting.

Applications

- Adhesion to scuffed primer, clean paint, glass, and bare aluminum.
- Sealing headlight/taillight seams.
- Sealing exterior RV seams.
- Sealing any other visible seam that will not be painted afterwards.

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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 24 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 (VOC's) 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, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product 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. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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