



Science.  
Applied to Life.™

3M Body Repair  
Materials Guide


| Adhesives |   |                |       |                                |                   |                                |  |                     |               |
|-----------|---|----------------|-------|--------------------------------|-------------------|--------------------------------|--|---------------------|---------------|
|           | Product Name                                  | Part No.       | Size  | Color                          | Chemistry         | Work Time                      |  | Clamp/Handling Time | Cure Time     |
|           | 3M™ Panel Bonding Adhesive                    | 08115<br>08116 | 200mL | Black                          | Epoxy             | 90 min @ 70°F / 45 min @ 90°F* |  | 4 hrs*              | 24 hrs        |
|           |   |                |       |                                |                   | 2 hrs @ 70°F / 1 hr @ 90°F*    |  | 6 hrs*              | 24 hrs        |
|           | 3M™ Impact Resistant Structural Adhesive      | 07333          | 200mL | Dispenses Silver, Cures Purple | Epoxy             | 60 min                         |  | 8 hrs*              | 24 hrs        |
|           | 3M™ Composite and Metal Bonding Adhesive – 35 | 08219          | 200mL | Green                          | Urethane          | 35 min                         |  | 90 min              | 3 hrs         |
|           | 3M™ Universal Adhesive                        | 08217<br>08223 | 200mL | Clear<br>Black                 | Epoxy<br>Urethane | 3 min<br>3 min                 |  | 30 min<br>30 min    | 1 hr<br>4 hrs |


\*May be accelerated with heat

| Plastic Repair |   |                |               |                |                   |           |                    |           |   |
|----------------|---|----------------|---------------|----------------|-------------------|-----------|--------------------|-----------|---|
|                | Product Name  | Part No.       | Size          | Color          | Chemistry         | Work Time | Sand/Handling Time | Cure Time | Features  |
|                | 3M™ Polyolefin Adhesion Promoter  | 05907          | 12 oz aerosol | Clear          | –                 | –         | –                  | 5 min     | • Provides excellent adhesion of filler materials to TPO type substrates (Type II)<br>• Compatible with all 3M Flexible, Semi-Rigid and TPO repair products                       |
|                | 3M™ EZ Sand Multi Purpose Repair Material<br><i>Approved as Seam Sealer</i> | 05887          | 200mL         | Grey           | Two-Part Epoxy    | 8 min     | 15 min             | -         | • Use this 3M Polyolefin Adhesion Promoter PN 05907<br>• Flexible for use on exterior bumper covers<br>• Excellent sandability  |
|                | 3M™ Super Fast Plastic Repair Adhesive                                      | 04247<br>04248 | 200mL         | Clear<br>Black | Two-Part Urethane | 20 sec    | 5 min              | 1 hr      | • Super-fast setting<br>• Use for rebuilding tabs and fixing broken eyelets<br>• Excellent gap-filling capabilities<br>• Withstands wide temperature range (unlike cyanoacrylate) |
|                | 3M™ Semi-Rigid Plastic Repair   | 04240          | 200mL         | Black          | Two-Part Urethane | 50 sec    | 15 min             | 1 hr      | • Very rigid material<br>• Use to reinforce backside  |
|                | 3M™ Semi-Rigid Parts Repair – 1   | 08235          | 200mL         | Black          | Two-Part Urethane | 50 sec    | 30 min             | 1 hr      | • Reinforcement strips, patch bonding, small bonding apps   |
|                | 3M™ Semi-Rigid Parts Repair – 3   | 08237          |               |                |                   | 3 min     |                    | 4 hrs     | • Fix Xenoy, RRIM, GTX, PPO, ABS and other semi-rigid plastics and bumper covers  |
|                | 3M™ Plastic Contour Sheet   | 04903          | 5" x 12 ft    | –              | –                 | –         | –                  | –         | • Contour sheet to be used while creating new plastic tabs  |
|                | 3M™ Reinforcement Patch   | 04904          | 5" x 12 ft    | –              | –                 | –         | –                  | –         | • Use for reinforcing the backside of plastic repairs   |


| Two-Part Seam Sealers |   |                                  |        |                                 |                |           |            |           |   |
|-----------------------|---|----------------------------------|--------|---------------------------------|----------------|-----------|------------|-----------|---|
|                       | Product Name                              | Part No.                         | Size   | Color                           | Chemistry      | Work Time | Paint Time | Cure Time | Features  |
|                       | 3M™ OEM Match Epoxy Seam Sealer           | 08522<br>08524<br>08526<br>08528 | 200 ml | Beige<br>White<br>Grey<br>Black | Two-Part Epoxy | 6 min     | 15 min     | 1 hr      | • Tough yet flexible material for sealing seams and joints on properly prepared bare metal, as well as primed or painted substrates<br>• Can be used to replicate a variety of factory seam sealer beads<br>• Formulated for matching OEM Seam Sealer appearances |
|                       | 3M™ EZ Sand Multi Purpose Repair Material | 05887                            | 200mL  | Grey                            | Two-Part Epoxy | 5 min     | 15 min     | 24 hrs    | • Must be applied over primer<br>• Provides great rounded edges<br>• Match OEM seams, sandable, semi flowable, flexible   |
|                       | 3M™ Heavy-Bodied Seam Sealer              | 08308                            | 200mL  | Black                           | Two-Part Epoxy | 6 min     | 15 min     | 1 hr      | • Heavy-bodied, non-sagging, non-flowing seam sealer<br>• Match OEM seams on floor pans, door skins, truck beds<br>• Use for cosmetic seams   |
|                       |   |                                  |        |                                 |                |           |            |           |   |
|                       |   |                                  |        |                                 |                |           |            |           |   |



\*Varies based on temperature and humidity

| Seam Sealer Tips  |                                 |          |              |  |
|---|---------------------------------|----------|--------------|--|
|   | Product Name                    | Part No. | Size         | Features   |
|  | 3M™ OEM Match Ripple Tips       | 05887    | 1K Ripple    | <ul style="list-style-type: none"><li>• Replicate the appearance of sprayed-on OEM seam sealers</li><li>• Fits wide variety of 1-part (1K) and 2-part (2K) sprayable</li></ul>   |
|   |                                 | 33995    | 2K Ripple    |  |
|   | 3M™ OEM Match Wing Nozzles      | 33992    | 1K Wing      | <ul style="list-style-type: none"><li>• Replicate the appearance of sprayed-on OEM seam sealers</li><li>• Fits wide variety of 1-part (1K) and 2-part (2K) sprayable Adjustable bead width to match the shape of the bead.</li></ul>   |
|   |                                 | 33997    | 2K Wing      |  |
|   | 3M™ OEM Match Wide Stream Tips  | 33993    | 1K Wide      | <ul style="list-style-type: none"><li>• Replicate the appearance of sprayed-on OEM seam sealers.</li><li>• Fits wide variety of 1-part (1K) and 2-part (2K) sprayable.</li><li>• Can be trimmed to control the bead width.</li></ul>   |
|   |                                 | 33998    | 2K Wide      |  |
|   | 3M™ OEM Match Sprayable Tips    | 33991    | 1K Sprayable | <ul style="list-style-type: none"><li>• Replicate the appearance of sprayed-on OEM seam sealers</li><li>• Fits wide variety of 1-part (1K) and 2-part (2K) sprayable</li><li>• For use with the 3M™ OEM Match Air Supply Kit</li></ul>   |
|   |                                 | 33996    | 2K Sprayable |  |
|   | 3M™ OEM Seam Sealer Tip Adapter | 08206    | 310 mL       | <ul style="list-style-type: none"><li>• Adds the ability to spray seam sealer and NVH dampening material using a standard pneumatic applicator.</li><li>• Works with both 1-part and 2-part 3M products.</li><li>• Designed to be used with 1K or 2K 3M™ OEM Match Sprayable Seam Sealer Tips.</li></ul> |
|   | 3M™ OEM Match Air Supply Kit    | 33999    | 1 pt, 2 pt   | <ul style="list-style-type: none"><li>• For use with one-part flex pack seam sealers.</li><li>• For use with OEM Match 2K Tips.</li></ul>  |

| One-Part Seam Sealers   |                                      |              |          |       |          |           |  |  |          |
|---|--------------------------------------|--------------|----------|-------|----------|-----------|--|--|----------|
|   |                                      | Product Name | Part No. | Size  | Color    | Chemistry | Work Time  | Paint Time   | Features |
| <br>08370      08369 | 3M™ Urethane Seam Sealer             | 08362        | 310mL    | Grey  | Urethane | 5–10 min* | 30 min for solvent-based; 45 min for water base    | <ul style="list-style-type: none"><li>• Apply directly over bare or primed metal</li><li>• Non-shrinking, non-cracking</li><li>• Fills large voids</li><li>• Direct-to-metal application</li></ul>   |          |
|   |                                      | 08365        |          | Beige |          |           |  |  |          |
|   |                                      | 08367        |          | Black |          |           |  |  |          |
|   |                                      | 08368        |          | White |          |           |  |  |          |
|   | 3M™ One-Part Seam Sealer (Foil Pack) | 08360        | 310mL    | White | Urethane | 5–10 min* | 30 min for solvent-based; 45 min for water base    | <ul style="list-style-type: none"><li>• Apply directly over bare or primed metal</li><li>• Non-shrinking, non-cracking</li><li>• Fills large voids</li><li>• Direct-to-metal application</li></ul>   |          |
|   |                                      | 08361        |          | Grey  |          |           |  |  |          |
|   |                                      | 08364        |          | Beige |          |           |  |  |          |
|   | 3M™ MSP Seam Sealer (Flex Pack)      | 08369        | 310mL    | White | MSP      | 5–10 min* | Immediate for solvent-based; 30 min for water base | <ul style="list-style-type: none"><li>• Apply directly over bare or primed metal</li><li>• High-quality, heavy-bodied, general purpose, moisture-curing seam sealer</li><li>• Use for interior and exterior body joints</li><li>• Prime or paint immediately or up to 72 hours</li><li>• Not for use on lacquer paints</li><li>• Direct-to-metal application</li></ul> |          |
|   |                                      | 08370        |          | Grey  |          |           |  |  |          |

\*Varies based on temperature and humidity

| Sound Deadening   |  |          |                           |       |                   |           |            |   |
|---|--|----------|---------------------------|-------|-------------------|-----------|------------|---|
|   | Product Name   | Part No. | Size                      | Color | Chemistry         | Work Time | Paint Time | Features  |
|  <div>08840</div> <div>04274</div> | 3M™ Sound Deadening Pad                                  | 08840    | 19" x 19" (500mm x 500mm) | Black | Pad               | N/A       | N/A        | <ul style="list-style-type: none"><li>● Conformable, self adhesive backing to be applied in floor pans, hood deck lids, etc.</li><li>● OEM matching diamond pattern</li><li>● Paintable</li></ul>   |
|   | 3M™ NVH Dampening Material (Noise, Vibration, Harshness) | 04274    | 200mL                     | Black | Two-Part Urethane | 60 min    | 24 hrs     | <ul style="list-style-type: none"><li>● Ideal two-part urethane for replacing factory NVH sealants and foams</li><li>● Remains pliable, yet sturdy and will not degrade</li><li>● Does not expand</li></ul>   |
|   | 3M™ Flexible Foam  | 08463    | 200mL                     | Grey  | Urethane          | 40 sec    | 1 hr       | <ul style="list-style-type: none"><li>● Stays flexible, fills and bonds</li><li>● Use to replace flexible foams in OEM applications such as trunks, door cavities, door skins and roof beams</li><li>● Works well for quarter panel applications or wherever flexible factory foam is found</li></ul> |
|   | 3M™ Rigid Pillar Foam                                    | 08458    | 200mL                     | Tan   | Urethane          | 1 min     | 1 hr       | <ul style="list-style-type: none"><li>● Rigid foam, fills and bonds</li><li>● Foams in place to fill posts, pillars and automotive body cavities</li><li>● Use for OEM replacement of rigid foams</li></ul>   |

| Coatings  |                             |          |                       |               |                       |           |  |
|---|-----------------------------|----------|-----------------------|---------------|-----------------------|-----------|--|
|   | Product Name                | Part No. | Size                  | Color         | Application           | Dry Time  | Features   |
| <br>08852 <br>05917 | 3M™ Cavity Wax Plus         | 08852    | 18 oz aerosol         | White/ Opaque | Anti-corrosion spray  | N/A       | <ul style="list-style-type: none"><li>• Corrosion protection for inner body panels, frame rails and structural enclosures</li><li>• Formulated for bare or primed automotive metals such as steel and aluminum</li><li>• Spray-on material provides consistent and uniform protection</li><li>• Remains soft and pliable — will not crack, chip, or peel</li></ul> |
|   |                             | 38854    | 18 oz aerosol         | Amber         | Anti-corrosion spray  |           |  |
|   |                             | 08851    | 8", 24" and 34" tubes | N/A           | Applicator wand kit   |           |  |
|   | 3M™ Weld-Thru Coating II    | 05917    | 12.75 oz aerosol      | Gray          | Surface coating spray | 15–20 min | <ul style="list-style-type: none"><li>• Sprayable, weldable, corrosion-resistant coating</li><li>• Dries fast with minimum spatter</li><li>• Meets CARB aerosol coating requirements</li></ul>   |
|   | 3M™ Rocker Panel Coating    | 08889    | 23 oz aerosol         | Grey          | Rocker panel coating  | 2 hrs*    | <ul style="list-style-type: none"><li>• Resilient under-the-paint protective coating</li><li>• Formulated to match factory-applied coatings on the Rocker Panel and stone-throw areas</li><li>• Paintable</li></ul>  |
|   | 3M™ Rubberized Undercoating | 08883    | 19.7 oz aerosol       | Black         | Undercoating          | 20 min    | <ul style="list-style-type: none"><li>• Premium undercoating offering corrosion protection, excellent spray pattern and coverage, as well as sound deadening</li></ul>   |

\*Varies based on coating thickness, temperature and humidity. Test to determine prior to painting

| Accessories                   |          |        |   |  | Applicators  |          |               |   |
|-------------------------------|----------|--------|---|--|--|----------|---------------|---|
| Product Name                  | Part No. | Size   | Features/Applications   |  | Product Name                                       | Part No. | Size          | Features/Applications   |
| 3M™ Threaded Cartridge Nozzle | 08187    | 310mL  | 50 Threaded cartridge nozzles to use with single component cartridges |  | 3M™ Standard Manual Applicator                     | 08571    | 200mL         | Heavy duty construction   |
| 3M™ Flex Pack Nozzle          | 08188    | 310mL  | For use with one-part flex pack seam sealers                          |  | 3M™ Premium Manual Applicator                      | 08117    | 200mL         | Heavy duty construction   |
|                               | 08193    | 200mL  | 3/8 in nozzle for all 200mL products                                  |  | 3M™ Performance Manual Applicator                  | 08190    | 50 mL         | For 1:1 and 2:1 cartridges  |
| 3M™ Static Mixing Nozzle      | 08194    | 200 mL | 3/8 in nozzle for all 200mL products                                  |  | 3M™ Performance Pneumatic Applicator               | 09930    | 200mL         | Ideal for large volume dispensing                                 |
|                               | 38195    | 50 mL  | Nozzle for all 50mL products  |  | 3M™ Single Cartridge Applicator Gun with Regulator | 39000    | 290mL, 310 mL | Pneumatic — designed for metal cartridge application              |
|                               |          |        |   |  | 3M™ Flexible Package Pneumatic Applicator          | 08399    | 310mL         | Designed for smooth application of foil and flexpack seam sealers |

**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.

3M is a trademark of 3M Company. All other trademarks are property of their respective owners. © 3M 2025. All rights reserved. 60-4402-7782-4, rev. 04/25