



# Factory-Match Seam Sealer

08323

Technical Data

January 2024

3M Part Numbers	3M Part Descriptor
08323	3M™ Factory-Match Seam Sealer

<b>Product Description</b>	3M™ Factory-Match Seam Sealer uses two-part urethane technology to provide a tough flexible material for the sealing of joints on primed or painted substrates such as steel or aluminum enclosures. This material provides excellent flexibility and elongation properties along with a medium/high viscosity and produces a slight flow-out after application. 3M™ Factory-Match Seam Sealer may be top coated with paints in 45 minutes under normal temperature and humidity conditions.
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<b>Features</b>	<ul style="list-style-type: none"><li>• Two-Part Urethane Technology</li><li>• 200 mL Dual - Syringe Cartridge</li><li>• Metered Static Mixing</li></ul>
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<b>Typical Physical Properties</b>	NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.
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<b>Container</b>	200 mL Dual-Syringe Cartridge
<b>Base</b>	Urethane
<b>Density lbs./Gallon (Approx.)</b>	8.5 / 8.7
<b>Color</b>	Black / Amber
<b>Viscosity (CPS) Brookfield Viscometer</b>	1,000 – 3,000
<b>Consistency</b>	Paste
<b>Service Temperature</b>	-20°F to 180°F (-29°C to 82°C)
<b>Solvent</b>	N/A

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<b>Product Uses</b>	A two-part seam sealer suitable for the sealing of seams on primed or painted substrates such as steel or aluminum enclosures. This material provides excellent flexibility and elongation properties along with a medium/high viscosity and produces a slight flow-out after application. 3M™ Factory-Match Seam Sealer may be top coated with paints in 45 minutes under normal conditions.
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Use with the following applicators: PN 08117 (manual), PN 08571 (manual), PN 09930 (pneumatic).

3M™ Mix Nozzle: PN 08193 (6/bag, PN 08194 (50/box)

**For professional use only. Not intended for retail sale.**

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<b>Performance Properties</b>	NOTE: The following times have been determined with ambient air temperature and substrate temperature @ 70°F (21°C) and are considered typical values.
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<b>Work Time:</b>	10 minutes
<b>Mix Nozzle Dwell Time:</b>	6 minutes
<b>Cure Time:</b>	4 hours
<b>Paint Time:</b>	45 minutes
<b>Tensile Strength:</b>	2515 psi
<b>Elongation:</b>	390%

## 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.

### SURFACE PREPARATION:

**NOTE:** Apply only to surfaces primed with a 2K urethane, 2K epoxy primer, or clean, sanded paint. Acid etch primers should never be in direct contact with seam sealer.

1. Scuff primed surface with a Scotch-Brite™ General Purpose Hand Pad Ultra Fine (PN 07448).
2. Blow off dust with clean, compressed air and wipe with an appropriate VOC compliant surface cleaner.

### PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
2. Remove retaining collar and plug from end of cartridge. Discard plug, save retaining collar.
3. Extrude a small amount of product until both parts A and B dispense equally.
4. Attach 3M™ Mixing Nozzle (PN 08193) to cartridge and lock in place with retaining collar.
5. Dispense a small amount of material and discard.

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## **Directions for Use, cont.**

### **GENERAL REPAIR PROCESS:**

1. Extrude sealer onto surface.
2. Allow to cure a minimum of 15 minutes before beginning the painting process.  
NOTE: If the sealer is allowed to cure more than 24 hours, scuff the sealer prior to any painting steps.

### **APPLICATION WARNINGS:**

- Not to be used in direct contact with acid etch primers.

### **CLEAN UP:**

Prior to curing, 08323 may be cleaned from most surfaces with an appropriate VOC compliant product for removal of surface contaminants.

### **STORAGE:**

After initial use, leave mix nozzle in place to seal the cartridge.

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## **Applications**

A two-part seam sealer for seams of primed or painted substrates such as steel or aluminum enclosures. This sealer is not recommended for the repair of vessels designed to contain liquids or liquids under pressure and is primarily used in the auto body repair industry.

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## **Storage and Handling**

### **HANDLING**

Do not eat, drink, or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding, or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

### **STORAGE**

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months from the date of manufacture. Store in a dry area at 72°F (22°C) for optimal shelf life. Store away from acids and other oxidizing agents.

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**After use, leave mix nozzle in place to seal the cartridge**

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## 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.

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## Technical Information

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