

Now A Metal Bonding Adhesive

3M™ SMC/FRP Panel Adhesive is now Composite and Metal Bonding Adhesive

3M™ SMC/FRP Panel Adhesive, 200 mL (PN 08219) and 3M™ 3M™ SMC/FRP Repair - 35, 400 mL (PN 08273) have now been approved for Bonding Door Skins. This product is a fast drying product with a 35 minute work time. It is designed to bond composite and metal to each other, along with metal to metal applications.



Ordering Information

Part No.	Description	Size	Cartridges/Case
08219	3M™ SMC/FRP Panel Adhesive	200 mL Cartridge	6
08273	3M™ SMC/FRP Repair - 35	400 mL Cartridge	6

At participating distributors. For complete details, contact your 3M Distributor or 3M Sales Representative.





35 Minute Panel Adhesive

Metal Bonding Adhesive

08219 • 08273

Technical Service Bulletin

3M technical service has tested and approves 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) for use in direct-to-metal applications either without welding or for use in conjunction with squeeze type resistance spot welding (STRSW) operations. Apply 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) to clean, dry steel that has been abraded in preparation for spot welding procedures (follow OEM recommended procedures for Weld Bonding through uncured adhesive). Always perform and destructively test spot welds to determine proper spot-welding machine settings when using as a weld bond adhesive. Do not attempt to MIG plug weld through the adhesive. Clean abraded surfaces using a VOC compliant surface cleaner and apply 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) **covering all bare metal surfaces for protection against corrosion**. Fixture the parts together, taking care to maintain coverage of the bare metal. Maintain fixtures (clamps) for 2 hours at 70°F (23°C) prior to handling. Maintain spacing between clamps of 2 to 3 inches. If spot-welding, weld as per standard squeeze type resistance spot-welding procedures through the **uncured** adhesive. Remove excess adhesive using a VOC compliant cleaner and proceed with the repair as per normal methodology. 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) is well suited for installation of door skins or other small panel replacement operations. Do not use 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) when bonding “cosmetic” areas or areas requiring finish over-coating with body filler. 3M™ SMC/FRP Panel Adhesive (PN 08219 and 08273) is compatible with common automotive solvent and water base coatings when sanded.

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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For Additional Health and Safety Information

3M Automotive Aftermarket Division

3M Center
Building 223-6N-01
St. Paul, MN 55144-1000
U.S.A.
Call 877-666-2277
www.3MCollision.com

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