

3M™ Automix™
SMC/Fiberglass Panel Adhesive
08219/60-9800-2976-7

Directions for Use:

3M™ Automix™ SMC/Fiberglass Panel Adhesive is designed to bond and seal automotive plastics (SMC, FRP, Urethane) and metal.

NOTE: 3M™ Automix™ SMC/Fiberglass Panel Adhesive should be used at 65°F or above.

1. Size all parts for proper alignment. Clean and prime bare metal surfaces with a two-part primer.
2. Clean the areas to be bonded with soap and water. Next, use 3M™ General Purpose Adhesive cleaner (N. 08984, 08986 or 08987 - aerosol) or use 3M™ Super Fast Adhesive cleaner (N. 08215) to remove any grease, wax and/or tar. Read manufacturer's hazard communication and follow manufacturer's recommended guidelines for safe handling of the above chemical products.*
3. Abrade surface to be bonded with grade P80 3M™ Hookit™ Gold film.
4. Wipe with a clean rag. Then clean all abraded surfaces a second time with lacquer thinner.
5. Insert 3M™ Automix™ SMC/Fiberglass Panel Adhesive 6 fl. oz. syringe into 3M™ Applicator Gun (N. 08198) or 3M™ Automix™ SMC/Fiberglass Panel Adhesive 200 mL syringe into MixPac® Applicator Gun (N. 08117-manual or N. 09930-pneumatic).
6. Remove end seal cap.
7. Extrude a small amount of adhesive until both parts dispense equally.
8. Cut end of mixing nozzle to provide desired bead size.
9. Attach 3M™ Mixing Nozzle (N. 08193) to syringe. Lock in place with retaining collar.
10. Apply adhesive.
11. Assemble as soon as possible - not to exceed 25 minutes after applying adhesive. Clamp if necessary. Allow material to cure before continuing repair. Typically 2 hours is sufficient for handling strength.

*3M™ General Purpose Adhesive Cleaner, (N. 08984, 08986) has a VOC of 816 grams per liter (6.81 lbs. per gallon). 3M™ General Purpose Adhesive cleaner, (N. 08987-aerosol) has a VOC of 738 grams per liter (6.16 lbs. per gallon). 3M™ Super Fast Adhesive Cleaner (N. 08215) has a VOC content of 849 grams/liter (7.08 lbs. per gallon). Local air quality regulations may regulate or prohibit the use of surface preparation and clean-up materials based on VOC content. Consult your local air quality regulations.

Contact your local 3M Automotive Aftermarket Division Sales Representative for any additional information that may be needed.

3M Automotive Aftermarket Division

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