



Universal Adhesive Clear

08107

Technical Data

June 2017

Product Description A clear, fast-curing, high-strength epoxy. Will bond a variety of materials including plastics, metal, rubber, and glass.

- Features**
- Clear
 - Fast curing
 - 50 ml Duo-Syringe Cartridge System

Typical Physical Properties

Container	1.6 oz. dual-syringe cartridge system
Base	Epoxy
Color	Clear
Solids Content (Approx.)	100%
Consistency	Thin Syrup

Product Uses Will bond a variety of automotive materials including plastics, metal, rubber, and glass.

Use with the following applicator: PN 08190 (manual)

3M™ Mixing Nozzle: (PN 38191 and 38193)

For professional use only. Not intended for retail sale.

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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.

The following times have been determined with ambient air temperature and substrate temperature @ 70°F and are considered typical values.

WORK TIME

3 minutes

MIX NOZZLE DWELL TIME:

2 minutes

CLAMP TIME

30 minutes

CURE TIME

1 hour

HANDLING STRENGTH

20 minutes @ 75°F

Overlap Shear

Overlap shear strengths were measured in pounds per square inch. Test samples were conditioned 24 hours before testing. Test samples were tested on an Instron Tester at a separation rate of 0.1" per minute for metal, 2" per minute for plastic and 20" per minute for rubber.

Substrate	Overlap Shear Strength (psi)
Steel/Steel	1100
SBR Rubber/Steel	35
Neoprene/Steel	30
ABS/ABS	490
PVC/PVC	400

T-Peel

T-Peel strengths were measured on 1" wide bonds. The bond thickness was 0.004". The jaw separation rate was 20 inches per minute.

Substrate	T-Peel Pounds Per Inch Width
Aluminum/Aluminum	2
Steel/Steel	2

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Directions for Use

SURFACE PREPARATION:

1. Wash surface with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate VOC compliant product for removal of surface contaminants.
2. Prime the clean, abraded metal surfaces with a two part primer (epoxy or urethane, NOT acid-etch).
3. Sand plastic surfaces with a grade P80 abrasive. Primed metal surfaces should be scuffed with a Scotch-Brite™ General Purpose Hand Pad (Ultrafine), (PN 07448).
4. Remove dust from surface using clean, un-oiled compressed air and a clean, dry rag.

PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
2. Remove plug from end of cartridge.
3. Extrude a small amount of product until both parts A and B dispense equally.
4. Attach 3M™ Mixing Nozzle (PN 38193) to cartridge and lock in place with retaining collar.

CAUTION: *Before proceeding with next step have all parts accessible and ready for repair.*

5. Dispense a small amount of material and discard.

GENERAL REPAIR PROCESS:

1. Apply adhesive to one of the parts and assemble the parts within 3 minutes.
2. Clamp parts together for 30 minutes.

NOTE: Allow to cure 1 hour before putting repaired part into service.

Applications

See “Product Uses” above.

Storage and Handling

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 24 months from the date of manufacture. Store in a dry area at 72°F for optimal shelf life. Store away from acids and other oxidizing agents. Rotate stock on a “first-in-first-out” basis. Store away from acids and other oxidizing agents.

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 (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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