

Urethane Seam Sealer

08362 • 08365 • 08367 • 08368

Technical Data

June 2020

3M Part Numbers	3M Part Descriptor
08362	3M™ Urethane Seam Sealer (gray)
08365	3M™ Urethane Seam Sealer (beige)
08367	3M™ Urethane Seam Sealer (black)
08368	3M™ Urethane Seam Sealer (white)

Product Description

3M™ Urethane Seam Sealer is a premium one-part moisture-curing automotive seam sealer designed for application to exterior and interior body seams. 3M™ Urethane Seam Sealer may be applied to properly prepared primer/paint coated surfaces or properly prepared bare metal surfaces. 3M™ Urethane Seam Sealer also functions as a weld through sealer when used in conjunction with squeeze type resistance spot welding (STRSW) operations. 3M™ Urethane Seam Sealer may be painted with common automotive type paint systems (water and solvent borne systems) in thirty minutes and up to twenty four hours later (scuff after 24 hours).

Features

- Moisture Cure Technology
- Weld Through Capability
- Direct to Metal Application
- 310 mL Metal Cartridge

Typical Physical Properties

NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Container	310mL Aluminum Cartridge
Base	Moisture Curing Urethane
Density lbs./Gallon (Approx.)	9.8
Color	Gray (08362), Beige (08365), Black (08367), White (08368)
Flash Point	>200°F (93.3°C) (closed cup method)
Solids Content (Approx.)	95%
Consistency	Viscous Paste
Service Temperature	-20°F to 180°F (-28°C to 82°C)
Solvent	Minimal Xylene

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Product Uses

General sealing of interior and exterior automotive seams including floor pans, hem flanges, frame rails, rear body panels, aprons and other seams including those requiring weld through applications using squeeze type resistance spot welding.

Use with the following accessories:

- 3M™ Single Component Cartridge Applicator – Pneumatic (PN 08990)
- 3M™ Professional Caulk Applicator – Manual (PN 08993)
- 3M™ Threaded Cartridge Nozzles (PN 08187 box/50)

For professional use only. Not intended for retail sale.

Performance Properties

NOTE: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Cold Temperature Resistance at -20°F (-29°C)	Remains flexible
Heat Resistance: 8 Weeks at 200°F (93°C)	Remains flexible
Adhesion: Primed Metal: Excellent	Cohesive failure
Bare Metal: Excellent	Cohesive failure
Tensile Strength: Good	(230 psi)
Flexibility: Excellent	600% Elongation

Directions for Use

PRIMER OR PAINT SURFACE

1. Clean the surface with a VOC compliant surface cleaner to remove any contaminants.
2. Scuff the surface using a Scotch-Brite™ Scuff Pad or grade P180 to P320 abrasive.
3. Blow off and re-clean the surface to ensure proper adhesion.
4. Perforate the seal at the cartridge outlet and install the nozzle. Use the pull tab to remove the metal seal at the cartridge base. Install the cartridge in a suitable caulking gun (see reference in “Product Uses” section).
5. Cut nozzle to provide desired bead size.
6. Apply seam sealer and tool (if necessary) to desired finished appearance.
7. Allow 30 minutes before painting, after 24 hours scuff with a 3M™ Scotch-Brite scuff pad.

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Directions for Use, cont.

WELD THROUGH

NOTE: For weld through operations (prior to welding the panel(s) make test welds on scrap parts to assure proper welding machine settings).

1. Remove coatings on all sides of weld flanges.
2. Apply seam sealer to all bare metal between weld flanges (brush to cover all bare metal).
3. Mate parts together and clamp in place.
4. Be sure to use a shunt clamp and start welds near the clamp.

BARE METAL

1. Clean the surface with a VOC compliant surface cleaner to remove any contaminants.
2. Grind any weld nuggets (grade 50 to 80) or scuff spot weld locations using a non-woven coarse grade surface conditioning disc or belt.
3. Blow off and re-clean the surface to ensure proper adhesion.
4. Perforate the seal at the cartridge outlet and install the nozzle. Use the pull tab to remove the metal seal at the cartridge base. Install the cartridge in a suitable caulking gun (see reference in “Product Uses” section).
5. Cut nozzle to provide desired bead size.
6. Apply seam sealer and tool (if necessary) to desired finished appearance.
7. Allow 30 minutes before painting, after 24 hours scuff with a 3M™ Scotch-Brite® scuff pad.

NOTE: 3M™ Urethane Seam Sealer may be applied to properly prepared bare metal and/or primer/paint coated surfaces, and can be used as a “weld through” sealer when squeeze type resistance spot welding equipment is used.

Acid etch primer is not recommended to be used in direct contact with any 3M seam sealer. Residual acid can weaken the bond.

Applications

General purpose automotive seams, including door skins, rocker panels, rear body panels, trunk seams, floor pans, etc.

Storage and Handling

Store at room temperature. Rotate stock on a “first-in-first-out” basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months. Use in a well-ventilated area.

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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