



3M Science.
Applied to Life.™

When impact resistance matters.

3M™ Impact Resistant Structural Adhesive

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07333 / 57333



Designed specifically to meet OEM requirements where impact strength matters most.

3M™ Impact Resistant Structural Adhesive is designed to meet specific strength requirements for parts such as frame rails, strut towers, rocker panels, pillars and other members where impact resistance is important. This type of adhesive possesses a much greater ability than traditional bonding adhesives to absorb and manage energy under a variety of forces, especially peel and cleavage stresses in extreme temperature conditions. Typically impact resistant structural adhesive is used in conjunction with rivets, spot welds or mechanical fasteners.

The above is a general description, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.



Curing process has begun, as indicated by silver to purple color change (30 min. at 175°F)



- Higher impact strength versus traditional bonding adhesives
- Recommended by many OEMs
- Provides corrosion protection with lifetime warranty
- Room temperature curing (accelerated curing with heat)
- Can be weld bonded or rivet bonded within working time
- Adheres to a wide variety of properly prepared steel and aluminum substrates
- Dispenses silver, color changes to purple to indicate proper mixing and curing process has begun
- Glass bead technology protects against overclamping and maintains a minimum bond line thickness
- Has excellent shelf life opened or unopened, reducing unused product replacement costs

Optimized for Shear, Peel and Impact Performance

3M™ Impact Resistant Structural Adhesive is optimized to duplicate collision energy management pathways and energy absorption.



3M™ Impact Resistant Structural Adhesive

Part No.	Size	Color	Chemistry	Work Time	Clamp/ Handling Time*	Cure Time
07333	200mL	Dispenses Silver, Cures Purple	Epoxy	60 min	8 hrs	24 hrs
57333	450mL DMS					

*May be accelerated with heat.

Following OEM recommendations is very important for several reasons.

Help Ensure Safety: Meet the adhesive standards that have been set by the OEMs to manage crash energy and help protect occupants.

Use Trusted Products: Use products that have been rigorously tested to the OEM's performance requirements for strength and corrosion resistance.

Mitigate Risk: Help protect yourself and your business from potential liability — the vehicle was repaired as directed by the OEM.

Simplify Your Process: Eliminate confusion about which adhesive should be used and where. You're using the OEM recommended adhesive that is specifically called out for that procedure.

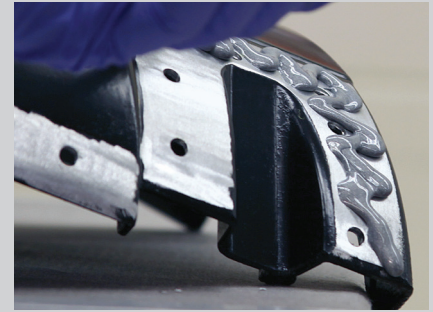
Get Reimbursed: OEM recommendations, which include 3M products, enable you to provide documentation to justify correct product usage and procedures needed for safe and responsible repairs.

OEM Recommendations

- ✓ 3M™ Panel Bonding Adhesive
- ✓ 3M™ Impact Resistant Structural Adhesive

3M PN	Fiat/ Chrysler	Ford	General Motors	Honda	Hyundai/ Kia	Jaguar/ Land Rover	Nissan	Tesla	Toyota	Volvo
08115		✓		✓	✓		✓		✓	✓
08116	✓		✓							✓
07333			✓	✓	✓	✓		✓		✓

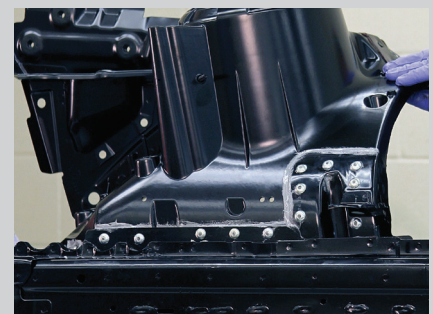
Please reference OEM Repair Procedures: Collision repair shops should follow OEM recommendations. Always reference the OEM repair procedure to make sure the correct adhesive is being selected for that repair.



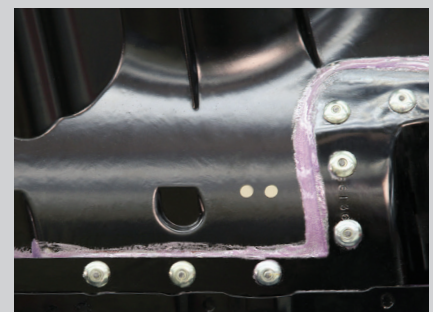
Applies easily to properly prepared substrates.



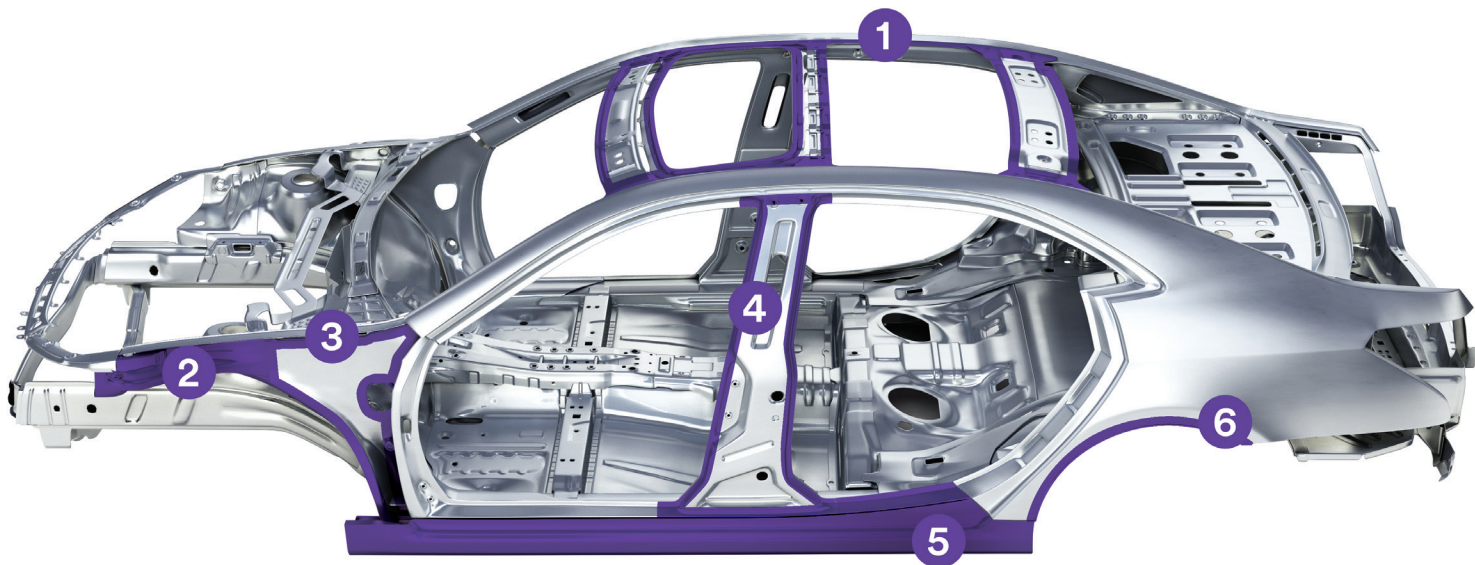
Can be weld bonded or rivet bonded within working time.



Adhesive bead dispenses silver.



Color changes to purple to indicate proper mixing and curing has begun.



Quick Reference: Areas where 3M™ Impact Resistant Structural Adhesive may be used.

- | | | |
|---------------------------------|--------------------------|-------------------------------------|
| 1 Roof Skin | 3 Body Side | 5 Rocker Panel |
| 2 Front Upper/Lower Rail | 4 B Pillar/Unside | 6 Rear Unibody/Wheel Opening |

Please reference OEM Repair Procedures.

Ordering Information

3M™ Impact Resistant Structural Adhesive			
Part No.	Size	Product	Case Qty.
07333	200mL	3M™ Impact Resistant Structural Adhesive	3/Case
57333	450mL DMS	3M™ Impact Resistant Structural Adhesive	2/Case

For more information, visit:
[3MCollision.com/IRSA](https://www.3M.com/collision/IRSA)

Accessories		
Part No.	Size	Features/Applications
08193	200mL, 400mL	3M™ Static Mixing Nozzle: 3/8 in. nozzle
08194	200mL, 400mL	3M™ Static Mixing Nozzle: 3/8 in. nozzle, Bulk pack (50)
09930	200mL	3M™ Performance Pneumatic Applicator: Pneumatic — For 200mL product
08117	200mL	3M™ Performance Manual Applicator: Manual — For 200mL product
08571	200mL	3M™ Standard Manual Applicator: Economy Line Applicator with heavy duty construction
55847	2:1, 1:1	3M™ Dynamic Mixing Nozzles: DMS nozzle for adhesives, sealers and plastic repair products
58207	50:1, 2:1, 1:1	3M™ Dynamic Mixing Nozzle Extension: Use with DMS nozzles to provide a thinner bead and to get into hard to reach areas
05846	All DMS Products	3M™ Dynamic Mixing Applicator: Pneumatic — Professional applicator to dispense DMS products



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For health and safety information please refer to product labels and Safety Data Sheets.