



# Urethane Seam Sealer

08360 • 08361 • 08364

Technical Data

January 2018

3M Part Numbers	3M Part Descriptor
08360	3M™ Urethane Seam Sealer (white)
08361	3M™ Urethane Seam Sealer (gray)
08364	3M™ Urethane Seam Sealer (beige)

## 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 24 hours later (scuff after 24 hours).

## Features

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

## 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 Flexible Sleeve
Base	Moisture Curing Urethane
Density lbs./Gallon (Approx.)	9.8
Color	White (08360), Gray (08361), Beige (08364)
Flash Point	92°F (33°) (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™ Flexible Package Applicator – Pneumatic (PN 08399)
- 3M™ Flexible Package Applicator – Manual (PN 08398)
- 3M™ Flexible Package Nozzles (PN 08188 box/25)

**For professional use only. Not intended for retail sale.**

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## Performance Properties

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

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

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## 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. Install foil package into barrel of 3M™ Flexible Package Applicator Gun (PN 08398).
5. Using a scissors, cut a small opening across the top end of package and fold back flaps.
6. Place nozzle over the opened end onto the gun barrel.
7. Replace the retaining collar.
8. Cut nozzle to provide desired bead size.
9. Apply seam sealer and tool (if necessary) to desired finished appearance.
10. Allow 30 minutes before painting, after 24 hours scuff with a 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. Install foil package into barrel of 3M™ Flexible Package Applicator Gun (PN 08398).
5. Using a scissors, cut a small opening across the top end of package and fold back flaps.
6. Place nozzle over the opened end onto the gun barrel.
7. Replace the retaining collar.
8. Cut nozzle to provide desired bead size.
9. Apply seam sealer and tool (if necessary) to desired finished appearance.
10. Allow 30 minutes before painting, after 24 hours scuff with a 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.**

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## Applications

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

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## 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.

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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 (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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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. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (*e.g.*, OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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