



OEM Match Sprayable Tip 2K

33996

Technical Data

July 2024

3M Part Number	3M Part Descriptor
33996	3M™ OEM Match Sprayable Tip 2K

Product Description

3M™ OEM Match Sprayable Tip 2K is the solution for 3M™ 2-Part Seam Sealers and 3M™ 1-Part sachet seam sealers (using nozzle 08206) to help replicate the original look and appearance of some sprayed seam sealers applied at the factory.

Features

- Easy attachment to 3M™ 2-Part Static Mix Nozzles PN08194 and PN08193
- Easy Attachment to 3M™ 1-Part Sachet Nozzle PN08206
- Works with 3M™ 2K Sealers and 1K MSP Sealers in sachets
- Recoverable item when using 3M™ RepairStack™ and Billables Invoicing Software

Typical Physical / Performance Properties

3M™ OEM Match Sprayable Tip 2K is comprised of 2 parts that rotate independently from each other. Do not attempt to disassemble the tip as this may affect the performance. Both parts are made of Polypropylene.

Product Uses

3M™ OEM Match Sprayable Tip 2K is designed to help technicians replicate some robotically applied seam sealers from the factory. Typical areas these beads can be found will include, but are not limited to, trunk floors, rear body panels, rear frame rails, floor pans, quarter panels, strut towers, front frame rails and more.

The tip is designed to work with 3M™ 2-Part Seam Sealers, 3M™ 1-Part Sachet Seam Sealers along with 3M™ OEM Match Sprayable Air Supply Kit PN 39999. All seam sealers, including bare metal seams sealers, should be applied over a 2K Epoxy or 2K Urethane primer. Using seam sealers other than the recommended seam sealers could result in performance issues in both replication appearance and product performance.

When using the 3M™ OEM Match Sprayable Tip 2K, make sure it is applied to a properly prepared and equalized cartridge. Not doing so could lead to product failure.

3M™ OEM Match Sprayable Tip 2K

33996

Product Uses Continued

When using 3M™ OEM Match Sprayable Tip 2K, make sure it is firmly applied to a 3M™ 2K static mix nozzle (PN08193/08194) or sachet nozzle (PN08206). Improper or loose fit could lead to leaking, poor performance, and excess material waste.

3M™ OEM Match Sprayable Tip 2K is designed for one-time use. Do not attempt to reuse tip as remnants left behind could cause problems for the tip, the material, the cartridge, Sachet or applicator when attempting to reuse.

3M™ OEM Match Sprayable Tip 2K is recommended to be used with 3M™ Pneumatic Applicators. Manual applicators will not work with the 3M™ OEM Match Sprayable Tip 2K.

Directions for Use

PRODUCT PREPARATION: (1-Part Sachets with 08206 Nozzle)

1. Do not use damaged or leaking sachets.
2. Install sachet into appropriate applicator for application.
3. Using scissors or side cutter, cut the sachet below the tie ring on the material side.
4. Install Nozzle 3M™ 08206 onto sachet, followed by applicator retailing ring and tighten in place.
5. Dispense a small amount of material onto a disposable sheet or panel.
6. Install 3M™ OEM Match Sprayable Tip 2K to the sachet nozzle until its fully pressed on.
7. Install 3M™ OEM Match Sprayable Air Supply Kit to the applicator air fitting. Make sure valve is in the closed position (90 degrees to the body of the attachment).
8. Install end of the air supply hose to the 3M™ OEM Match Sprayable Tip 2K air inlet on the nozzle by pressing fully onto the nozzle port.
9. Adjust pattern and texture on a disposable sheet by adjusting regulator on applicator for fluid control, and valve on air supply attachment for fan pattern. Note the settings. Close valve on air supply attachment.

PRODUCT PREPARATION: (2-Part Seam Sealers)

1. Do not use damaged or leaking cartridges.
2. Install cartridge into appropriate applicator for application.
3. Install 3M™ OEM Match Air Supply Kit PN39999 onto air fitting on applicator. Make sure valve is in the close position (90 degrees to the body of the attachment).
4. Install air supply line to the Air Supply attachment. Remove cartridge plug or used static mix nozzle and equalize cartridge upright into a disposable towel. Attach new static mix nozzle.
5. Dispense a bead (2"-4") of material onto a disposable sheet or panel.

3M™ OEM Match Sprayable Tip 2K

33996

Directions for Use Continued

6. Install 3M™ OEM Match Sprayable Tip 2K onto the static mix nozzle making sure its fully seated. Install Air Supply hose to the port on the Sprayable Tip by pressing onto the port until fully seated.
7. Adjust pattern and texture on a disposable sheet by adjusting the regulator on the applicator for fluid control, and valve on the air supply attachment for fan pattern. Note the settings. Close the valve on Air Supply attachment.

GENERAL REPAIR PROCESS (*On vehicle*):

1. Apply 2K epoxy or 2K urethane primer to all bare metal surfaces and allow to cure following TDS for products being used.
2. Follow steps for **Product Preparation**.
3. With the valve on air supply attachment closed, apply seam sealer to vehicle and panels requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
4. On a disposable sheet or panel, open the valve on air supply attachment to the previous noted position and test the pattern to ensure it meets replication pattern desired.
5. After testing the nozzle pattern, install seam sealer using the 3M™ OEM Match Sprayable Tip 2K to repair areas requiring OEM replication.
6. Once complete close valve on air supply attachment and disconnect supplied air.
7. Once the application is complete, finish by completing any tooling required to replicate the original look and appearance in the repair area. Make sure any gaps or voids are filled to prevent dirt or moisture from infiltrating the seam sealer.
8. For difficult applications such as overhead, vertical, or tight corners and curves or tight spaces that don't allow access with the applicator, refer to "Off vehicle application" directions to replicate desired finish.
9. Remove the 3M™ OEM Match Sprayable Tip 2K from the nozzle once application is complete. If material cures prior to removing the tip, use a cutting tool to remove the tip to avoid damaging the retaining ring on the next use.
10. Discard 3M™ OEM Match Sprayable Tip 2K in proper waste stream in accordance with local regulations.
11. Follow recommendations on material TDS or cartridge label for paint times before top coating.

GENERAL REPAIR PROCESS: (*Off vehicle*)

1. Apply 2K epoxy or 2K urethane primer to all bare metal surfaces and allow to cure following TDS for products being used.
2. On a flat bench top lay out strips of packaging tape.

3M™ OEM Match Sprayable Tip 2K

33996

Directions for Use Continued

3. Follow steps for product preparation.
4. On a disposable mixing sheet or panel, open the air supply attachment valve while dispensing material until desired pattern or texture is achieved. Adjust as needed.
5. With desired replication achieved apply beads onto clean packaging tape free of any dirt or debris. If the final application requires tight curves or transitions lay material out in these forms on the packaging tape.
6. Remove the 3M™ OEM Match Sprayable Tip 2K from the nozzle once application is complete. If material cures prior to removing the tip use a cutting tool to remove the tip to avoid damaging retaining ring on next use.
7. Discard 3M™ OEM Match Sprayable Tip 2K in proper waste stream in accordance with local regulations.
8. Allow material to cure. Do not remove beads from tape until you are ready to install on the vehicle.
9. Prior to installing beads onto vehicle, remove from packaging tape and dry fit in the locations to be applied. Trim beads if necessary. Lay on clean surface with the backside of bead facing up.
10. When ready to install premade beads onto the vehicle, prepare a cartridge of the same material following the **Product Preparation** steps. Apply seam sealer to the panels on the vehicle requiring seam sealer and tool with a brush or other tools to seal any gaps or voids. Wet out the entire back side of the premade beads with the same material the bead was made from using a brush or other tool.
11. With both sides wet, install bead onto vehicle and press firmly into place to ensure wet material on the vehicle side and wet material on the beads side is free of gaps and voids. In some cases, beads will need to be held in place until material begins to cure.
12. After the material is cured, check for any large gaps or voids. If any exist apply material and tool to fill the areas with gaps or voids.
13. After applying the bead, finish by tooling material to replicate any brush or tooling marks in the repair area and allow to cure following the product recommendations.
14. Follow recommendations on material TDS or cartridge label for paint times before top coating.

Materials and Accessories

3M™ Pneumatic Applicators

- 09930 3M™ Performance Pneumatic Applicator
- 08399 3M™ Flexible Package Applicator – Pneumatic

3M™ Accessories

- 33999 3M™ OEM Match Air Supply Kit

3M™ OEM Match Sprayable Tip 2K

33996

Materials and

Accessories Continued

3M™ Nozzles

- 08194 3M™ Static Mix Nozzle
- 08193 3M™ Static Mix Nozzle
- 08206 3M™ OEM Seam Sealer Tip Adapter

3M™ 1K Products (Sachets)

- 08369 3M™ MSP Seam Sealer White
- 08370 3M™ MSP Seam Sealer Gray

3M™ 2K Products

- 08308 3M™ Heavy Bodied Seam Sealer
- 08310 3M™ Bare Metal Seam Sealer
- 08522 3M™ OEM Match Epoxy Seam Sealer Beige
- 08524 3M™ OEM Match Epoxy Seam Sealer White
- 08526 3M™ OEM Match Epoxy Seam Sealer Gray
- 08528 3M™ OEM Match Epoxy Seam Sealer Black
- 04274 3M™ NVH Dampening Material

Storage and Handling

Store in packaging until ready to use.

Product does not have an expiration date.

Product is NOT reusable.

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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3M™ OEM Match Sprayable Tip 2K

33996

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