



OEM Match Epoxy Seam Sealer

08522 • 08524 • 08526 • 08528

Technical Data

July 2024

3M Part Numbers	3M Part Descriptor
08522	3M™ OEM Match Epoxy Seam Sealer (Beige)
08524	3M™ OEM Match Epoxy Seam Sealer (White)
08536	3M™ OEM Match Epoxy Seam Sealer (Gray)
08528	3M™ OEM Match Epoxy Seam Sealer (Black)

Product Description

3M™ OEM Match Epoxy Seam Sealer uses two-part epoxy technology to provide a tough, yet flexible material for the sealing of joints of properly prepared bare metal as well as primed or painted substrates. This material provides quick cure time and non-sag properties that aid during vertical applications. In addition, it allows top coating with paints in as soon as 15 minutes under normal conditions. 3M™ OEM Match Epoxy Seam Sealer contains corrosion inhibitors.

Features

- Two-Part Epoxy Chemistry
- 200 mL Dual-Syringe Cartridge
- Adheres to properly prepared bare metal & primed surfaces
- Contains Corrosion Inhibitors
- Used in combination with 3M™ OEM Match Tips to help replicate some robotically applied OEM seam sealers at the factory

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	200 mL Dual-Syringe Cartridge
Base	Epoxy
Density lbs./Gallon (Approx.)	9.4 - 9.9
Color	Beige (08522), White (08524), Gray (08526), Black (08528)
Solids Content (Approx.)	100%
Consistency	Paste
Solvent	N/A
Service Temperature	-20°F to 180°F (-29°C to 82°C)

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Product Uses

3M™ OEM Match Epoxy Seam Sealer is a two-part seam sealer for general purpose automotive sealing needs that cures quickly to a tough, strong bead for lasting seam sealing protection. This includes door skins, floor pans, trunk floors, roof seams, and many other applications. Can be caulked and tooled with 3M™ OEM Match Tips PNs 33995, 33997, 33998 or sprayed with the combination of 3M™ OEM Match Sprayable 2K Tip (PN 33996) and OEM Match Sprayable Air Supply Kit (PN 33999) to create specific seam sealer bead profiles.

3M™ OEM Match Epoxy Seam Sealer will adhere to properly prepared bare steel, galvanized steel, and aluminum, or to surfaces primed with a 2K urethane, 2K epoxy primer, or clean, sanded paint. 3M recommends that all seam sealers, including bare metal seams sealers, should be applied over a 2K Epoxy or 2K Urethane primer. Acid etch primers should never be in direct contact with seam sealer.

3M™ OEM Match Epoxy Seam Sealer must be dispensed through a 3M™ Static Mixing Nozzle (PNs 08194 and 08193). This seam sealer can be used with the following applicators: PN 08117 (manual), PN 08571 (manual), and PN 09930 (pneumatic).

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. The following times have been determined with ambient air temperature and substrate temperature @ 70°F (21°C).

Work Time	6 minutes
Cure Time	1 hour
Paint Time	15 minutes
Tensile Strength	525 psi
Elongation	160%

Directions for Use

SURFACE PREPARATION

NOTE: 3M recommends that all seam sealers, including direct-to-metal seam sealers, should be applied over a 2K primer. 3M™ OEM Match Epoxy Seam Sealer is designed for application over bare steel; galvanized steel; aluminum; 2K urethane primer; 2K Epoxy primer; or to cleaned and prepped OEM finishes. Acid etch primers should never be in direct contact with seam sealer.

1. Clean the surface with an appropriate VOC-compliant product for removal of surface contaminants.
2. Bare metal surfaces should be sanded with an appropriate 3M 50 – 180 grit abrasive. Scuff previously painted and primed surfaces with a Scotch-Brite™ General Purpose Hand Pad.
3. Blow off dust with clean, compressed air and wipe with a clean, dry rag.

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Directions for Use

Continued

PRODUCT PREPARATION

1. Insert cartridge into applicator.
2. Remove retaining collar and plug from end of cartridge. Discard plug, save retaining collar.
3. Extrude a small amount of product until both parts A and B dispense equally.
4. Attach 3M™ Mixing Nozzle (PN 08193) to cartridge and lock in place with a retaining collar.
5. Dispense a small amount of material and discard.

GENERAL REPAIR PROCESS

1. Extrude sealer onto surface, and tool as necessary.
 - a. For applications where the user will take advantage of this product's bare metal capabilities, it is recommended to always spread or tool the sealer in some manner. This will prevent the "bridging" of sand scratches, therefore, ensuring its adhesion to the substrate.

NOTE: 3M™ OEM Match Epoxy Seam Sealer can be used in combination with 3M™ OEM Match Tips (PN 33995, 33996, 33997, 33998 and Sprayable Air Supply Kit PN 33999) to help replicate some robotically applied OEM seam sealers at the factory.

2. Allow to cure a minimum of 15 minutes before beginning the painting process. **NOTE:** If sealer is allowed to cure more than 24 hours, scuff the sealer prior to any painting steps.

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

STORAGE: After initial use, leave mix nozzle in place to seal the cartridge.

CLEAN-UP: Unmixed material may be cleaned from most surfaces with an appropriate VOC compliant product.

Applications

General purpose automotive seams, including door skins, floor pans, trunk floors, roof seams, 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 24 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.

Technical Information

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