



Factory-Match Seam Sealer

08323

Technical Data Sheet

August, 2012

3M Part No.(s)	3M Part Descriptor(s)
08323	3M™ Factory-Match Seam Sealer

Product Description 3M™ Factory-Match Seam Sealer uses two part urethane technology to provide a tough flexible material for the sealing of joints on primed or painted substrates such as steel or aluminum enclosures. This material provides excellent flexibility and elongation properties along with a medium/high viscosity and produces a slight flow-out after application, 3M™ Factory-Match Seam Sealer may be top coated with paints in 45 minutes under normal conditions.

Features

- Two Part Urethane Technology
- 200 mL Dual - Syringe Cartridge
- Metered Static Mixing

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	Urethane
Density lbs/Gallon (Appx.)	8.6 / 8.8
Color	Black / Amber
Viscosity (CPS) Brookfield Viscometer	1,000 - 3,000 cps
Consistency	Paste
Solvent	N/A
Service Temperature - °F	-20°F to 180°F

3M™ Factory-Match Seam Sealer

08323

Product Uses

A two-part seam sealer for sealing of seams on primed or painted substrates such as steel or aluminium enclosures. This material provides excellent flexibility and elongation properties along with a medium/high viscosity and produces a slight flow-out after application. 3M™ Factory-Match Seam Sealer may be top coated with paints in 45 minutes under normal conditions.

Use with the following applicators: PN 08117 (manual), PN 08571(manual), and PN 09930 (pneumatic).

3M™ Mix Nozzle: PN 08193 (6/bag), PN 8194 (50/box).

Typical Performance Properties

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

WORK TIME:

10 minutes

MIX NOZZLE DWELL TIME:

6 minutes

CURE TIME:

4 hours

PAINT TIME:

45 minutes

TENSILE STRENGTH:

2517 PSI

ELONGATION:

390%

Directions for Use

NOTE: 3M Best Practice is that all sealers, unless designated specifically for use on bare metal, be applied to properly prepared automotive paint or primer.

SURFACE PREPARATION:

NOTE: Apply only to surfaces primed with a 2K urethane, 2K epoxy primer, or clean, sanded paint. Acid etch primers should never be in direct contact with seam sealer.

1. Scuff primed surface with a Scotch-Brite™ General Purpose Hand Pad (Ultrafine), (PN 07448).
2. Blow off dust with clean, compressed air and wipe with a clean, dry rag.

PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
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 retaining collar.
5. Dispense a small amount of material and discard.

3M™ Factory-Match Seam Sealer

08323

Directions for Use (continued)

GENERAL REPAIR PROCESS:

1. Extrude sealer onto surface. Allow to cure a minimum of 45 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 WARNINGS:

- Not to be used in direct contact with acid etch primers.

STORAGE:

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

CLEAN-UP:

Prior to curing, 3M™ Factory-Match Seam Sealer may be cleaned from most surfaces using 3M™ General Purpose Adhesive Cleaner or 3M™ Specialty Purpose Adhesive Remover (check for local VOC regulations).

Applications

A two-part seam sealer for sealing of seams on primed or painted substrates such as steel or aluminum enclosures. This sealer is not recommended for the repair of vessels designed to contain liquids or liquids under pressure and is primarily used in the auto body repair industry but may be suitable for some architectural or industrial applications (user assumes responsibility to test for suitability).

Storage and Handling

HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

STORAGE

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months from the date of manufacture. Store in a dry area at 72°F for optimal shelf life. Store away from acids and other oxidizing agents.

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

3M™ Factory-Match Seam Sealer

08323

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

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. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy, and Disclaimer

Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability

Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

For Additional Health and Safety Information



Automotive Aftermarket Division

3M Center, Building 223-6N-01
St. Paul, MN 55144-1000
1-877-666-2277 (1-877-MMM-CARS)
www.3MCollision.com

3M and Scotch-Brite are trademarks of 3M Company.
Printed in U.S.A.
©3M 2012 P.N. 08323 (8/12)

This is the last page