



OEM Match Wide Stream Tip 1K

33993

Technical Data

July 2024

| 3M Part Number | 3M Part Descriptor |
|----------------|----------------------------------|
| 33993 | 3M™ OEM Match Wide Stream Tip 1K |

Product Description 3M™ OEM Match Wide Stream Tip 1K is the solution for 3M™ 1-Part cartridge seam sealer products to help replicate the original look and appearance of some seam sealers applied at the factory.

- Features**
- Easy attachment to 3M™ Aluminum 1K Cartridges
 - Works with 3M™ 1K cartridge MSP Sealers and Urethane Sealers
 - Recoverable item when using 3M™ RepairStack™ and Billables Invoicing Software

Typical Physical / Performance Properties 3M™ OEM Match Wide Stream Tip 1K is comprised of High-Density Polyethylene. The design is ambidextrous so it can be used right-handed or left-handed. Do not use if any damage is visible as this may affect the performance or damage the applicator and cartridge.

Product Uses 3M™ OEM Match Wide Stream Tip 1K 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, Roof Ditches/Gutters, Trunk Gutter/Troughs, Floor Panels, Rear Body Panels and more.

The tip is designed to work with 3M™ 1-Part Cartridge Seam Sealers. 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 Wide Stream Tip 1K, make sure it is applied to a properly prepared and equalized cartridge. Not doing so could lead to product failure.

When using 3M™ OEM Match Wide Stream Tip 1K, make sure it is firmly applied to 3M™ Cartridge. Improper threading or loose fit could lead to leaking, poor performance, and excess material waste.

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Product Uses Continued

3M™ OEM Match Wide Stream Tip 1K 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, or applicator when attempting to reuse.

3M™ OEM Match Wide Stream Tip 1K is recommended to be used with 3M™ Pneumatic Applicators designed for aluminum cartridges, or cordless caulking applicators designed for aluminum cartridges. Manual applicators, although could be used, will not provide a consistent appearance with the 3M™ OEM Match Wide Stream Tip 1K when applied both on and off the vehicle.

Directions for Use

PRODUCT PREPARATION:

1. Do not use damaged cartridges.
2. Remove seal from bottom of cartridge.
3. Puncture the seal at the outlet side of cartridge. Do not damage threads on cartridge.
4. Extrude a small amount of product to break the seal on plunger.
5. Install Cartridge into applicator following applicator instructions for cartridge installation.
6. When ready to apply, install 3M™ OEM Match Wide Stream Tip 1K to the cartridge until its firmly attached.
7. Adjust bead width and height by trimming the nozzle, adjusting air pressure and speed of travel while applying.

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. Before applying material to the vehicle or panel, hold the 3M™ OEM Match Wide Stream Tip 1K up to the area to be sealed compare the original bead, or similar bead on an adjacent panel, trim the nozzle back from the outlet to the desired bead width to be applied.
4. Using a standard nozzle (3M™ PN8187), apply seam sealer to vehicle and panels requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
5. Install 3M™ OEM Match Wide Stream Tip 1K onto the cartridge. On a disposable sheet or panel, Adjust the regulator until desired appearance or pattern is achieved. This will be controlled by the speed of travel as well as the amount of material being dispensed by the regulator, or plunger drive control.
6. After testing the nozzle pattern, install seam sealer using the 3M™ OEM Match Wide Stream Tip 1K to repair areas requiring OEM replication.

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Directions for Use Continued

7. When complete, disconnect supplied air.
8. Finish by completing any tooling required to replicate the original look and appearance in the repair area, or to remove excess material. Make sure any gaps or voids are filled to prevent dirt or moisture from infiltrating the seam sealer.
9. For difficult applications such as overhead, vertical, tight corners, curves, or tight spaces that don't allow access with the applicator, refer to "Off vehicle application" directions to replicate desired finish.
10. Leave the 3M™ OEM Match Wide Stream Tip 1K installed on the cartridge to store it. If removal is necessary, install 3M™ Nozzle PN 8187 and dispense material to prevent material from curing in cartridge. Leave nozzle on cartridge for storage.
11. Discard 3M™ OEM Match Wide Stream Tip 1K in proper waste stream in accordance with local regulations.
12. 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.
3. Follow steps for **Product Preparation**.
4. Before applying material to the vehicle or panel, hold the 3M™ OEM Match Wide Stream Tip 1K up to the area to be sealed compare the original bead, or similar bead on an adjacent panel, trim the nozzle back from the outlet to the desired bead width to be applied. When trimming is complete, install tip to properly prepared nozzle.
5. On a disposable mixing sheet or panel, bead height and width by adjusting regulator on applicator as well as the speed at which you move. This will change the appearance while applying.
6. 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.
7. Leave the 3M™ OEM Match Wide Stream Tip 1K on the cartridge to store it. If removal is necessary, install 3M™ Nozzle PN 8187 and dispense material to prevent material from curing in cartridge. Leave nozzle on cartridge.
8. Discard 3M™ OEM Match Wide Stream Tip 1K in proper waste stream in accordance with local regulations.
9. Allow material to cure. Do not remove beads from tape until you are ready to install on the vehicle.

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Directions for Use Continued

10. 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.
11. 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.
12. 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.
13. 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.
14. 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.
15. Follow recommendations on material TDS or cartridge label for paint times before top coating.

Materials and Accessories

3M™ Pneumatic Applicators

- 39000 3M™ Single Component Applicator with Regulator
- 38373 3M™ Single Component Applicator with Regulator

3M™ 1-Part Products

- 08362 3M™ Urethane Seam Sealer - Gray
- 08365 3M™ Urethane Seam Sealer - Beige
- 08367 3M™ Urethane Seam Sealer - Black
- 08368 3M™ Urethane Seam Sealer - White
- 08374 3M™ MSP Sprayable Seam Sealer - Gray

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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