



OEM Match Wing Nozzle Tip 2K

33997

Technical Data

July 2024

3M Part Number	3M Part Descriptor
33997	3M™ OEM Match Wing Nozzle Tip 2K

Product Description 3M™ OEM Match Wing Nozzle 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 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, 1K MSP Sealers and Urethane Sealers in sachets
 - Recoverable item when using 3M™ RepairStack™ and Billables Invoicing Software

Typical Physical / Performance Properties 3M™ OEM Match Wing Nozzle Tip 2K is comprised of 1 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 Wing Nozzle 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, doors, hoods, decklids/trunk lids, tailgates, trunk gutter/troughs, and more.

The tip is designed to work with 3M™ 2-Part Seam Sealers, 3M™ 1-Part Sachet 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 Wing Nozzle 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 Wing Nozzle Tip 2K

33997

Product Uses Continued When using 3M™ OEM Match Wing Nozzle Tip 2K, make sure it is firmly applied to 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 Wing Nozzle 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, or applicator when attempting to reuse.

3M™ OEM Match Wing Nozzle Tip 2K is recommended to be used with 3M™ Performance Pneumatic Applicator. Manual applicators, although could be used, will not provide a consistent appearance with the 3M™ OEM Match Wing Nozzle Tip 2K when applied both on and off the vehicle.

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 retaining ring and tighten in place.
5. Dispense a small amount of material onto a disposable sheet or panel.
6. When ready to apply, install 3M™ OEM Match Wing Nozzle Tip 2K to the sachet nozzle until its fully pressed on.
7. Adjust bead width and height by trimming the nozzle, adjusting air pressure and speed of travel while applying.

PRODUCT PREPARATION: *(2-Part Seam Sealers)*

1. Do not use damaged or leaking cartridges.
2. Install cartridge into appropriate applicator for application.
3. Remove cartridge plug or used static mix nozzle and equalize cartridge upright into a disposable towel. Attach new static mix nozzle.
4. Dispense a bead (2"-4") of material onto a disposable mixing sheet or panel.
5. When ready to apply, install the 3M™ OEM Match Wing Nozzle Tip 2K onto the static mix nozzle making sure its fully seated.
6. 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**.

3M™ OEM Match Wing Nozzle Tip 2K

33997

Directions for Use Continued

3. Before applying material to the vehicle or panel, hold the 3M™ OEM Match Wing Nozzle Tip 2K up to the area to be sealed. Trim the wing guide to allow the nozzle to travel over the center of the seam being sealed.
4. While comparing 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.
5. Using a 2-part static mix nozzle (3M™ PN08193/08194) or 1-part standard nozzle (3M™ PN08206), apply seam sealer to vehicle and panels requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
6. Install 3M™ OEM Match Wing Nozzle Tip 2K to the nozzle. On a disposable sheet or panel, test material to ensure 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.
7. After testing the nozzle pattern, install seam sealer using the 3M™ OEM Match Wing Nozzle Tip 2K to repair areas requiring OEM replication.
8. When complete, disconnect supplied air.
9. 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.
10. 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.
11. Remove the 3M™ OEM Match Wing Nozzle 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.
12. Discard 3M™ OEM Match Wing Nozzle Tip 2K in proper waste stream in accordance with local regulations.
13. 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 Wing Nozzle Tip 2K up to the area to be sealed. Trim the wing guide to allow the nozzle to travel over the center of the seam being sealed.

3M™ OEM Match Wing Nozzle Tip 2K

33997

Directions for Use Continued

5. While comparing 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.
6. When trimming is complete, install tip to properly prepared nozzle.
7. On a disposable mixing sheet or panel, adjust 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.
8. 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.
9. Remove the 3M™ OEM Match Wing Nozzle 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 Wing Nozzle Tip 2K in proper waste stream in accordance with local regulations.
11. Allow material to cure. Do not remove beads from tape until you are ready to install on the vehicle.
12. 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.
13. 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.
14. 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.
15. 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.
16. 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.
17. Follow recommendations on material TDS or cartridge label for paint times before top coating.

3M™ OEM Match Wing Nozzle Tip 2K

33997

Materials and Accessories

3M™ Pneumatic Applicators

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

3M™ Nozzles

- 08194 3M™ Static Mix Nozzle
- 08193 3M™ Static Mix Nozzle
- 08206 3M™ OEM Seam Sealer Tip Adapter (use with 1K sachets)

3M™ 1K Products (Sachets)

- 08360 3M™ Urethane Seam Sealer White
- 08361 3M™ Urethane Seam Sealer Gray
- 08364 3M™ Urethane Seam Sealer Beige
- 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
- 08323 3M™ Factory Match Seam Sealer
- 05887 3M™ EZ Sand Multipurpose Repair Material
- 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

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.

Technical Information

The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third-party intellectual property rights is granted or implied with this information.

3M™ OEM Match Wing Nozzle Tip 2K

33997

Product Selection and 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. 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 in accordance with all applicable instructions and with appropriate safety equipment, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy and Disclaimer Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 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, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement or repair of the 3M product or refund of the purchase price. Warranty claims must be made within one (1) year from the date of 3M's shipment.

Limitation of Liability Except for the limited remedy stated above, and except to the extent prohibited by applicable law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and other limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, death, or property damage. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.^[1]



Automotive Aftermarket Division
3M Center, Building 0223-4-S-04
St. Paul, MN 55144-1000
1-877-666-2277 (1-877-MMM-CARS)
3MCollision.com

3M and RepairStack are trademarks of 3M.
Printed in U.S.A. © 3M 2024 All rights reserved (07/24)