3M Science. Applied to Life.™

Leading body shops follow OEM repair procedures.



Help protect yourself, your shop, and your customer by repairing the vehicle the right way, every time.

Setting your shop up for success.

Spend the time upfront to make sure you are repairing the vehicle properly and the shop is being compensated.

Research

Search the original equipment manufacturer's website for the most up-to-date repair procedures, process guides, bulletins and positioning statements important to the repair.

Document the Procedure

Make sure to document the procedure at the time of repair. If a vehicle needs reinspection, the original repair order should include a copy of the OEM repair procedures used, before and after photos, and the detailed report of any scan.

Improve Accuracy

Checking OEM repair procedures before starting a repair can help you write more accurate estimates, order the correct parts, and source the proper products.

Always Validate

Even if you have repaired the same vehicle multiple times, it is important to validate OEM procedures and products as they can change frequently with updated technology and materials.

Select the Right Products

When repairing a vehicle, it's not just how you do it, it's also about using the right solutions to complete the repair in the right way. OEMs call out specific products for use in the repair to achieve the best results.

Get Paid

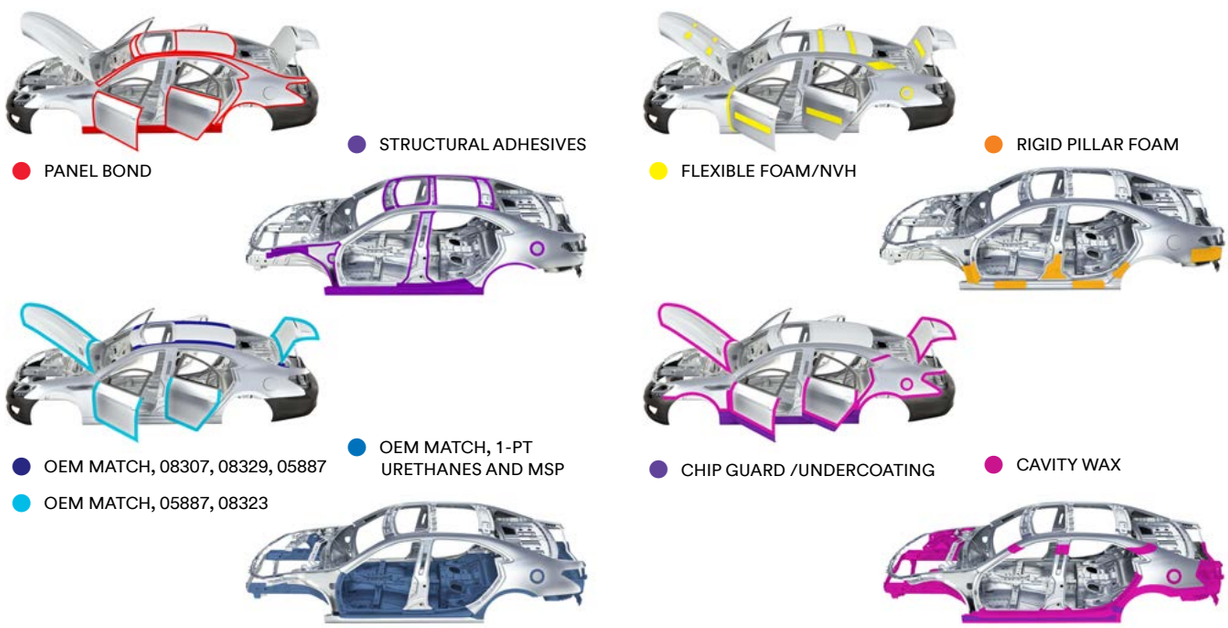
Following OEM repair procedures can help you get paid for the work you do and the materials you use to complete the repair. Build your research and materials into the repair estimate.

Use Trusted Products.

3M has been working with OEMs for decades and is more often referenced in OEM repair procedures for panel bonding and impact resistant structural adhesives than any other adhesive supplier.

Common applications for OEM Repairs.

Always validate and follow OEM procedures.



Unlock more opportunities for profit at your body shop.

3M™ RepairStack™ Performance Solutions

Designed to help advance body shop efficiency, profitability and performance. A fully integrated and automated material management, invoicing, and performance analytics solution to help you track and get paid for the materials you use to complete the repair the right way.



3M™ RepairStack™ Inventory Management

Helps keep your body shop well-organized

- Track usage of 3M and non-3M products
- Automatically reorder supplies
- Stock all necessary materials to improve touch and cycle time

3M™ RepairStack™ Billables Invoicing (formerly CRiMP)

Designed to help get paid for 3M and non-3M materials

- Bill for materials you never knew were recoverable
- Integrate with leading body shop management systems
- Streamline blueprinting and billing processes

3M™ RepairStack™ Performance Analytics Tool

Get valuable insights and help increase profits

- Integrate with leading body shop management systems
- Analyze your business performance
- Monitor KPIs in real-time to identify areas for profitability

3M Solutions for OEM Repair Procedures

When impact resistance matters.

3M™ Impact Resistant Structural Adhesive (IRSA)

3M Impact Resistant Structural Adhesive (IRSA) is formulated for true automotive OEM specified structural bonding applications. A two-part epoxy adhesive delivers extended worktimes—up to 1 hour—and can be rapidly heat cured. The adhesive changes from silver to purple as the adhesive cures.



Adhesives	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ Impact Resistant Structural Adhesive**	00051131073333	07333	200mL	Dispenses ● Silver Cures ● Purple	Epoxy	3/Case	1 hr Work Time; 8 hr Clamp Time; 24 hr Cure Time Meets specific strength requirements for parts such as frame rails, strut towers, rocker panels, pillars and other members where impact resistance is important. Possesses a much greater ability than traditional bonding adhesives to absorb and manage energy under a variety of forces, especially peel and cleavage stresses in extreme temperature conditions. Use in conjunction with rivets, spot welds or mechanical fasteners.
	00076308573331	57333	450mL DMS			2/Case	

Proven and trusted performance.

3M™ Panel Bonding Adhesive

3M Panel Bonding Adhesive is a cost-effective two-part epoxy adhesive for bonding replacement body panels. From its fast, convenient cartridge system the adhesive seals and bonds steel, aluminum, SMC, and FRP securely in a single operation.



Adhesives	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ Panel Bonding Adhesive**	00051135081150	08115	200mL	● Black	Epoxy	6/Case	90 min Work Time* 21.1°C; 4-6 hr Clamp Time; 24 hr Cure Time** Designed to meet specific strength requirements for outer sheet metal panel replacement. Typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.
	00051135081167	08116	200mL				
	00076308581152	58115	450mL DMS			4/Case	

Fast, flexible and easy to sand.

3M™ EZ Sand Multi Purpose Repair Material

3M EZ Sand Multi Purpose Repair Material is a ready-to-use 2-part epoxy finishing adhesive material that dries to a flexible hardness, ideal for repairing plastic parts such as bumper covers and body panels. It applies easily from a 3M applicator gun mixing nozzle, with no pre-mixing or measuring. It is quickly sandable for excellent featheredge, and paintable in as little as 30 minutes.



Plastic Repair	UPC	Part #	Size	Colour	Qty/Case	Description
 **3M™ EZ Sand Multi Purpose Repair Material** Approved as Seam Sealer	00051131042407	35887	50mL	● Grey	6/Case	5 min Work Time; 15 min Sand Time; 24 hr Cure Time Two-part epoxy used to repair most flexible parts. May also be used as a seam sealer where a rounded edge seam is required. This semi-flowable material creates the perfect bead matching many OEM applications.
	00051131058873	05887	200mL			
	00076308558871	55887	600mL DMS		4/Case	

* The above are general descriptions, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.

Bring it all together.

Accessories for IRSA, Panel Bonding Adhesives and EZ Sand Multi-Purpose Repair Material

Accessories	Part No.	Size	Features/Applications
3M™ Static Mixing Nozzle	08193	200mL, 400mL	3/8 in. nozzle
3M™ Static Mixing Nozzle	08194		3/8 in. nozzle, Bulk pack (50)
3M™ Performance Pneumatic Applicator	09930	200mL	Pneumatic (for 200mL product)
3M™ Performance Manual Applicator	08117		Manual (for 200mL product)
3M™ Standard Manual Applicator	08571	200mL	Economy line Applicator with heavy duty contruction
3M™ Dynamic Mixing Nozzles	55847	2:1, 1:1	DMS nozzle for adhesives, sealers and plastic repair products
3M™ Dynamic Mixing Nozzle Extension	58207	50:1, 2:1, 1:1	Use with DMS nozzles to provide a thinner bead and to get into hard to reach areas
3M™ Dynamic Mixing Applicator	05846	All DMS Products	Pneumatic, professional applicator to dispense DMS products

Corrosion protection you can trust for internal cavities in a convenient aerosol can.

3M™ Cavity Wax Plus

3M Cavity Wax Plus is a non-hardening, self-healing corrosion protection coating for internal auto body panels and structural enclosures, as well as new replacement parts. It is designed to cover and seal internal joints, hem flanges and other areas where OEM e-coat may be compromised. It will not chip, peel or crack.



Spray Coatings	UPC	Part #	Size	Qty/Case
 **3M™ Cavity Wax Plus**	00051135088524	08852	18 oz. aerosol	4/Case

Accessories	Part #	Size
3M™ Cavity Wax Plus Applicator Wand Kit	08851	8”, 24” and 34” tubes

DMS **3M™ Dynamic Mixing System (DMS)** Automatically mix and dispense the perfect amount of adhesives, sealers and body filler products. Work/Handling/Cure times may differ for DMS products.

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3M™ Skills Development Center

Learn more about our solutions through technician training program focusing on foundational body repair processes which underpin OEM repair procedures.

Scan or visit Go.3M.com/SDC.

3M Solutions for OEM Repair Procedures

For OEM Seam Sealer replication.

3M OEM Match Family Overview

3M offers professional grade seam sealers, nozzles, tips and applicators to allow technicians of all skill levels to easily replicate OEM seams. The OEM Match family joins the full line of 3M™ Seam Sealers to give shops a full toolset to meet the demands of OEM procedures.

And as an additional benefit for you: All of the nozzles and seam sealers are recoverable items when using the 3M™ RepairStack™ and billable materials invoicing software.

Sealers Applicators	UPC	Part #	Size	Qty/Case	Description
 **3M™ Performance Pneumatic Applicator**	50051131099307	09930	200mL	1/Case	Pneumatic — For 200mL product.
 **3M™ Flexible Package Pneumatic Applicator**	00051135083994	08399	310mL	1/Case	Pneumatic — For smooth application of 310mL foil pack seam sealers. Fully enclosed.

OEM Match Nozzles	Part No.	Colour	Qty/Case	Fitting
 3M™ OEM Match Wing Nozzle 1K Tip	33992	○ White	10 Nozzles/Pack, 5 Packs/Case	1K MSP or Urethane Seam Sealer in Cartridge
 3M™ OEM Match Wide Stream 1K Tip	33993	○ White		
 3M™ OEM Match Ripple 1K Tip	33994	○ White		
 3M™ OEM Match Sprayable 1K Tip	33991	○ White		1K MSP Seam Sealer in Cartridge
3M™ OEM Match Wing Nozzle 2K Tip	33997	○ White		3M™ Static Mixing Nozzles for 2K products (PN 08193, 08194) 3M™ OEM Seam Sealer Tip Adapter for 1K Flexpack Sealers (PN 08206)
3M™ OEM Match Wide Stream 2K Tip	33998	○ White		
3M™ OEM Match Adjustable Ripple Tip 2K	33995	○ White		
 3M™ OEM Match Sprayable 2K Tip	33996	○ White		
 3M™ OEM Match Air Supply Kit	33999	● Black	10 Kits/Case	Fits to all 3M™ Pneumatic Applicators to allow spray application of seam sealers

Adhesives | Sealers Accessories	UPC	Part #	Size	Qty/Case	Description
3M™ Static Mixing Nozzle	00051131081932	08193	200mL, 400mL	36/Case	3/8" nozzle for all 200mL and 400mL products.
	00051135081945	08194	200mL, 400mL	300/Case	
 **3M™ OEM Seam Sealer Tip Adapter**	00051135082065	08206	310mL	36/Case	Use with Urethane Seam Sealers and MSP Seam Sealers.

Two-Part Seam Sealers	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ OEM Match Epoxy Seam Sealer**	00068060060235	08524	200mL	○ White	Two-Part Epoxy	6/Case	• Used in combination with OEM Match tips to help replicate some robotically applied OEM seam sealers at the factory • Caulkable, toolable, brushable, and sprayable • Non-sagging formula designed for easy to manipulate tooling and texture on vertical and horizontal surfaces • Adheres to properly prepared bare metal and primed surfaces • Set and ready to paint after 15 minutes. Fast curing seam sealers reduce potential for rework and allow greater throughput in the body shop
	00068060060228	08526		● Grey			
	00068060060211	08522		● Beige			
	00068060060204	08528		● Black			
 **3M™ Self-Leveling Seam Sealer**	00051131083073	08307	200mL	⊘ Clear	Two-Part Epoxy	6/Case	6 min Work Time; 15 min Paint Time; 60 min Cure Time Two-part epoxy designed for roof ditches (door skin hem flanges) and rear body panels, including tail light areas, wheel well flanges, etc. Quick curing properties enhance automotive body shop productivity.
 **3M™ Factory Match Seam Sealer**	00051135083239	08323	200mL	● Black	Two-Part Urethane	6/Case	10 min Work Time; 45 min Paint Time; 4 hr Cure Time Two-part urethane provides a tough flexible materialv for the sealing of joints on primed or painted substrates such as steel or aluminum enclosures. Flows slightly, softens on edges without tooling (rounded appearance). Use to duplicate factory door skin seams.
 **3M™ Controlled Flow Seam Sealer**	00051135083291	08329	200mL	● Black	Two-Part Urethane	6/Case	3 min Work Time; 40 min Paint Time; 2 hr Cure Time Offers considerable strength, flexes under torsional stress from vibration and withstands extreme weather. Contains no solvents and will not shrink or crack. Ideal choice for automotive applications where motion and exposure to weather are a constant factor. Excellent for sloped areas.

Improve your repair process with 3M™ Multi-Purpose Seam Sealer.

3M™ Multi-Purpose Seam Sealer

Our sealer allows wet on wet painting for faster sealing processing times. It can be sprayed, extruded or brushed.

One-Part Seam Sealers	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ MSP Seam Sealer**	00051135083697	08369	310mL Flexpack	○ White	MSP	6/Case	5 min Work Time* · 0 min Paint Time Solvent · 30 min Paint Time Water One-part formula is ready to use without any mixing. High quality, heavy-bodied, general purpose, moisture-curing seam sealer for interior and exterior body joints. Adheres well to properly prepared primer, paint, and bare metal surfaces. Tack free in 30 minutes and is immediately paintable.
	00051135837030	08370		● Grey			
 **3M™ MSP Sprayable Seam Sealer**	00051135083741	08374	310mL Cartridge	● Grey	MSP	6/Case	5 min Work Time* · 0 min Paint Time Solvent · 30 min Paint Time Water High-performance, general-purpose seam sealer that can be caulked or sprayed. Convenient, easy-to-apply sealer adheres well to all primed surfaces, except acrylic lacquer. It offers the convenience of allowing for painting almost immediately after being applied.

Create tight, long-lasting seals.

3M™ Urethane Seam Sealer

3M™ Urethane Seam Sealer is a high solids seam sealer ideal for sealing automotive and RV seams and joints. It adheres well to bare metal, primed metal and painted surfaces, and if desired can be smoothed to a featheredge and/or brushed.

One-Part Seam Sealers	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ Urethane Seam Sealer**	00051135083628	08362	310mL Cartridge	● Grey	Urethane	12/Case	5 min Work Time · 30 min Paint Time Solvent · 45 min Paint Time Water A high performance seam sealer ideal for sealing interior and exterior automotive and RV seams and joints. Adheres well to properly prepared bare metal, primer and e-coat surfaces. May be welded through using STRSW equipment. Can be smoothed to a featheredge and/or brushed. Reduces the risk of re-dos associated with the use of solvent-based seam sealers.
	00051135083659	08365		● Beige			
	00051135083673	08367		● Black			
	00051135083680	08368		○ White			
	00051131168305	08360	310mL Foil Pack	○ White	Urethane	6/Case	
	00051131168312	08361		● Grey			
	00051135083642	08364		● Beige			

Reduce noise, vibration and harshness in vehicles.

3M™ NVH Dampening Material

3M™ NVH Dampening Material is a flexible urethane adhesive-type material for replacing and re-installing factory NVH sealants and foams. This two-part material can be used to coat existing foams before reinstallation of outer body panels, or to fill thin gaps where foam cannot be used. Great for overhead or vertical surfaces, it cures to a flexible yet firm state and affords a 60-minute worktime.

Sound Deadening Material	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ NVH Dampening Material** (Noise, Vibration, Harshness)	00051131042742	04274	200mL	● Black	Two-Part Urethane	6/Case	1 hr Work Time · 24 hr Cure Time Soft, sturdy, non-shrink formula stops vibration and reduces noise between panels, braces and intrusion beams. This two-part material can be used to coat existing foams before reinstallation of outer body panels, or to fill thin gaps where foam cannot be used. Great for overhead or vertical surfaces.

The extended family.

Additional 3M solutions to help follow OEM Repair Procedures.

Adhesives	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ Composite and Metal Bonding Adhesive** Approved for Direct to Bare Metal	00076308573331	08219	200mL	Green	Urethane	6/Case	35 min Work Time; 90 min Clamp Time; 3 hr Cure Time. Approved for bonding door skins. Two-part urethane adhesive that is used to bond SMC and FRP (traditional fiberglass) body panels to each other and to metal. Designed to bond composite and metal to each other, along with metal to metal applications.

Sound Deadening Material	UPC	Part #	Size	Colour	Chemistry	Qty/Case	Description
 **3M™ Flexible Foam**	00051131084636	08463	200mL	Grey	Two-Part Urethane	6/Case	40 sec Work Time; 1 hr Cure Time. Fast, easy and effective replacement of OEM flexible foams in automotive applications. Material expands to 10 times its liquid volume, creating a closed-cell foam that won't shrink and closely mimics OEM foam properties for insulation, sound-deadening and temperature resistance.

Spray Coatings	UPC	Part #	Size	Colour	Qty/Case	Description
 **3M™ Weld-Thru Coating II**	00051131059177	05917	12.75 oz. aerosol	Grey	6/Case	Aerosol coating designed to prevent corrosion between welded metal surfaces. Featuring a zinc base that draws corrosion away from bare metals, it helps prevent costly comebacks due to corrosion at welds. Spray coating applies fast, resists weld spatter common to some weldable primers and dries in as little as 5 minutes.

* The above are general descriptions, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.

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