



## Automotive Aftermarket Division

### Polyurethane Seam Sealer

**3M 08684 • 08365 • 08694 • 08689**

#### 1) Part Numbers

08684 3M™ Urethane Seam Sealer – Grey  
08365 3M™ Urethane Seam Sealer – Beige  
08694 3M™ Urethane Seam Sealer – Black  
08689 3M™ Urethane Seam Sealer – White

#### 2) Description and end uses

3M™ Urethane Seam Sealer is an excellent choice when sealing seams to help prevent the intrusion of water, dust, and air, aiding in providing corrosion resistance at these locations. 3M™ Urethane Seam Sealers provide excellent gap filling properties and are designed to be used over epoxy, urethane, high build and primed surfaces. They should be top coated when exposed to ultra violet rays.

Use with the following accessories:

- 3M™ Single Component Cartridge Applicator Gun (PN 08990)
- 3M™ Professional Manual Caulking Gun (PN 08013)
- 3M™ Threaded Cartridge Nozzles (PN 08187) 50/box

#### 3) 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	10.5 fl.oz / 310ml Aluminium Cartridge
Base	Moisture-curing urethane
Density	9.8 lb/gal
Colour	08694 (Black), 08694 (Grey), 08689 (White), 08365 (Beige)
Flash Point	92°F (Closed Cup Method)
Solids Content	0.95
Consistency	Heavy Paste
Solvent	Minimal amount of xylene
Service Temperature	-25°F to 180°F



## 4) Directions for Use

NOTE: 3M Best Practice is that all sealers, unless designated specifically for use on bare metal, be applied to properly prepared paint or primer designed for the specific application. Applying over bare metal will not provide adequate corrosion protection. Acid etch primer is not recommended to be used in direct contact with any 3M seam sealer. Residual acid can weaken the bond.

1. Lightly scuff the coated area where the sealer is to be applied using a 3M™ ScotchBrite™ scuff pad (PN 07447).
2. Clean with an appropriate VOC compliant cleaner product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalogue for a suitable VOC compliant product for your area.
3. Perforate the seal at the cartridge outlet and install the nozzle. Use the pull tab to remove the metal seal at the cartridge base. Install the cartridge in a suitable caulking gun (see reference in "Product Uses" section).
4. Cut nozzle to provide desired bead size.
5. Apply seam sealer and tool (if necessary) to desired finished appearance (use water or mild solvent such as a pre-cleaner to tool). Do not tool with any alcohol containing solvents, they will stop the curing process of the seam sealer.
6. Wait at least 30 minutes before painting (1/4" bead at 70°F, 50% humidity), for thicker beads, lower temperatures, or lower humidity, allow additional time before painting.

## 5) Storage

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 12 months. Use in a well-ventilated area.

## 6) Safety

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



# Technical Data Sheet

Effective: 26/4/16    Supersedes: 1/6/13

**3M Urethane Seam Sealer 08684 • 08365 • 08694 • 08689 is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.**

Read full instructions and material safety data sheet before use.

IMPORTANT: This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the material safety data sheet for full handling instructions and personal protection information. These are available via your stockist. The supplier disclaims any liability where the user does not wear the recommended personal protective equipment.

## 7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

## 8) Technical Service Bulletin

3M technical service has tested and approves 3M™ Urethane Seam Sealers (08684, 08365, 08694 and 08689) for use in direct to metal applications and when used in conjunction with squeeze type resistance spot welding (STRSW) operations. Apply 3M™ Seam Sealer (08684, 08365, 08694, and 08689) to clean, dry steel that has been abraded in preparation for welding operations (follow common repair methodology and/or specific OEM information when required). For preparation procedures, always conduct test welds to determine proper welding machine settings. Clean abraded surfaces using a VOC compliant surface cleaner and apply 3M™ Seam Sealer (08684, 08365, 08694, and 08689) covering all bare metal surfaces, fixture the parts together taking care to maintain coverage of the bare metal. Weld as per standard squeeze type resistance spot welding procedures. Remove excess Seam Sealer using VOC compliant cleaner and proceed with the repair as per normal methodology. 3M™ Seam Sealers (08684, 08365, 08694 and 08689) protect against water, dust and air penetration in automotive joints and are compatible with common automotive solvent and water base coatings and protect against corrosion of bare steel\*.

- Test SAE J 2334.



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For Additional Health and Safety Information

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