



Super Fast Plastic Repair Adhesive

04247

Technical Data Sheet

3M Part No.(s)	3M Part Descriptor(s)
04247	3M™ Super Fast Plastic Repair Adhesive

Product Description 3M™ Super Fast Plastic Repair Adhesive is a two part urethane formulated to be used on most plastic substrates as a fast cure bonding adhesive with excellent gap filling capabilities. 3M™ Super Fast Plastic Repair Adhesive also functions for replacing and repairing broken or missing mounting tabs on plastic parts.

- Features**
- Excellent gap-filling capabilities
 - Bond created in 60 seconds
 - 200 ml Dual-Syringe Cartridge System

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.)	9.2 / 8.5
Color	Clear / Clear
Flash Point - °F	290°F
Viscosity (CPS) Brookfield Viscometer	1100 / 2100
Solids Content (Appx.)	100%
Consistency	Viscous liquid
Service Temperature - °F	-40°F to 250°F

Product Uses 3M™ Super Fast Plastic Repair Adhesive works well to bond and repair mounting brackets on parts such as tail lamps, head lamps, mirrors, and other automotive exterior and interior trim parts. May also be used on industrial and architectural surfaces needing minor repairs. For best results use in conjunction with **3M™ Polyolefin Adhesion Promoter (PN 05907)** when repairing Polyolefin type plastics.

For professional use only. Not intended for retail sale.

Note: Do not apply polyester body filler directly over this product.

Use with the following: 3M™ Applicators (PN 08117, PN 08571).

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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:

20 seconds

MIX NOZZLE DWELL TIME:

15 seconds

SAND TIME:

5 minutes

CLAMP TIME:

1 Minute

PAINT TIME:

30 minutes

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Lap Shear, TPO:	440 PSI	ASTM D1002 / 2" per minute
Lap Shear, PP:	190 PSI	ASTM D1002 / 2" per minute
Lap Shear, TEO:	180 PSI	ASTM D1002 / 2" per minute

Overlap shear test method: Over lap shear test for adhesion determined in accordance with ASTM D1002. Sample dimensions 1" x 4" x .0111" with an overlap area of 1/2" x 1". Plastics cleaned with 3M General Purpose Adhesive Cleaner PN 08984 and DA sanded with P80 abrasive. Thermopolyolefin and Polypropylene plastics coated with 3M Polyolefin Adhesion Promoter PN 05907.

Directions for Use

SURFACE PREPARATION:

1. Wash surface with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate VOC compliant product for removal of surface contaminants.
2. Sand the surface with a grade 80 or 180 abrasive.
3. Remove dust from surface using clean, un-oiled compressed air and a clean dry rag.
4. **Apply 3M™ Polyolefin Adhesion Promoter (PN 05907) following label directions.**

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.

NOTE: Parts A and B of this product are very runny prior to mixing. It is recommended that you extrude the material with the dispensing end of the cartridge facing upward, into a paper towel. Continue to hold the cartridge in this position until you have completed the next step (4).

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Directions for Use (continued)

4. Attach 3M™ Mixing Nozzle (PN 08193, 08194) to cartridge and lock in place with retaining collar.

CAUTION: Before proceeding with next step have all parts accessible and ready for repair.

5. Dispense a small amount of material and discard.

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 (VOC's) 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.

GENERAL REPAIR PROCESS:

1. Apply adhesive to one of the parts and assemble the parts **immediately**.
2. Hold parts together for 30 to 45 seconds. **NOTE:** Allow to cure 1 hour before putting repaired part into service.

APPLICATION WARNINGS:

Do not apply polyester fillers or putties over this product.

CLEAN-UP:

Unmixed material may be cleaned from most surfaces with an appropriate VOC compliant product.

Applications

General bonding repairs of many plastic substrates also for use on architectural substrates as a general-purpose bonder when short working and bonding times are required. For best results use in conjunction with **3M™ Polyolefin Adhesion Promoter (PN 05907)** when repairing Polyolefin type plastics.

Storage and Handling

HANDLING

Avoid eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining. Do not breathe vapors. Avoid prolonged or repeated skin contact. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Avoid contact with water to prevent potentially violent reaction or fire.

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 away from acids. Keep container in well-ventilated area.

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

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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.

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