



# Universal Adhesive Black

## 08223

Technical Data Sheet

June, 2011

3M Part No.(s)	3M Part Descriptor(s)
08223	3M™ Universal Adhesive Black

**Product Description** 3M™ Universal Adhesive Black is a urethane adhesive designed to bond metal, glass and plastic substrates to each other and themselves. This two-part, high-viscosity adhesive provides excellent gap filling and works on many substrates. 3M™ Universal Adhesive Black provides a three minute working time for medium to large sized repairs.

- Features**
- Two-part urethane technology
  - 200 ml dual-syringe cartridge
  - Metered static mixing

**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.**

<b>Container</b>	200 ml dual-syringe cartridge
<b>Base</b>	Urethane
<b>Density lbs/Gallon (Appx.)</b>	10.2 / 10.7
<b>Color</b>	Black / White
<b>Flash Point - °F</b>	>200°F
<b>Viscosity (CPS) Brookfield Viscometer</b>	12,000 - 20,000
<b>Solids Content (Appx.)</b>	100%
<b>Consistency</b>	Paste
<b>Service Temperature - °F</b>	-20°F to 180°F

**Product Uses**

3M™ Universal Adhesive Black may be used on multiple substrates and 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. **Note:** Do not apply polyester body filler directly over this product.

**Use with the following applicators: PN 08571 (manual), PN 08117 (manual), and PN 09930 (pneumatic).**

**3M™ Static Mixing Nozzle: PN 08193 (6/bag), PN 08194 (50/box).**

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## Typical Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 70°F and are considered typical values.

### WORK TIME:

3 minutes

### MIX NOZZLE DWELL TIME:

60 seconds

### CLAMP TIME:

30 minutes

### CURE TIME:

4 hours

**Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Lap Shear, SMC	1185 PSI	ASTM D1002 / 2" per minute
Lap Shear, FRP	71 PSI	ASTM D1002 / 2" per minute
Lap Shear, TPO	262 PSI	ASTM D1002 / 2" per minute
Lap Shear, PP	232 PSI	ASTM D1002 / 2" per minute
Lap Shear, TEO	190 PSI	ASTM D1002 / 2" per minute

Overlap shear test method: Overlap 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.

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## 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 3M VOC compliant product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.
2. Prime clean, abraded metal surfaces with a two part primer (epoxy or urethane, NOT acid-etch).
3. Sand plastic surfaces with a grade P80 abrasive. Primed metal surfaces should be scuffed with a Scotch-Brite™ General Purpose Hand Pad (Ultrafine), ( PN 07448).
4. Remove dust from surface using clean, un-oiled compressed air and a clean, dry rag.

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### Directions for Use (continued)

#### 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.
4. Attach 3M™ Mixing Nozzle (PN 08193) 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.

#### GENERAL REPAIR PROCESS:

1. Apply adhesive to one of the parts and assemble the parts within 3 minutes.
2. Clamp parts together for 30 minutes.

**NOTE:** Allow to cure 1 hour before putting repaired part into service.

#### CLEAN-UP:

Remove excess PN08223 prior to complete cure by using an appropriate VOC compliant adhesive remover suitable for most surfaces, such as 3M™ Specialty Adhesive Remover (PN38984 / PN38987). Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.

### Applications

3M™ Universal Adhesive Black is a two part urethane adhesive designed to bond and seal plastics, primed metals, and glass. 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.

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### Storage and Handling

#### HANDLING

Avoid eye contact with vapors, mists, or spray. Avoid breathing of dust created by cutting, sanding, grinding or machining. Avoid breathing of vapors, mists or spray. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Contents may be under pressure, open carefully. 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. Keep container tightly closed. Store away from acids. Store away from heat. Store out of direct sunlight. Keep container in well ventilated area.

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

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## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. Hazardous polymerization may occur. May cause allergic skin reaction. May cause allergic respiratory reaction. Contains a chemical or chemicals which can cause cancer.

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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.

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## 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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## For Additional Health and Safety Information



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