



# Universal Adhesive Clear

## 08107

**Technical Data**

**July, 2011**

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**Product Description**

A clear, fast-curing, high-strength epoxy. Will bond a variety of materials including plastics, metal, rubber, and glass.

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**Features**

- Clear
- Fast curing
- 50 ml Duo-Syringe Cartridge System

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**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>	1.6 oz. dual-syringe cartridge system
<b>Base</b>	Epoxy
<b>Color</b>	Clear
<b>Solids Content (Approx.)</b>	100%
<b>Consistency</b>	Thin Syrup

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**Product Uses**

Will bond a variety of automotive materials including plastics, metal, rubber, and glass.

**Use with the following applicator: PN 08190 (manual)**

**3M™ Mixing Nozzle: (PN 38191 and 38193)**

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08107

## Typical Performance Properties

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

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:

2 minutes

### CLAMP TIME

30 minutes

### CURE TIME

1 hour

### HANDLING STRENGTH

20 minutes @ 75°F

### Overlap Shear

Overlap shear strengths were measured in pounds per square inch. Test samples were conditioned 24 hours before testing. Test samples were tested on an Instron Tester at a separation rate of 0.1" per minute for metal, 2" per minute for plastic and 20" per minute for rubber.

Substrate	Overlap Shear Strength (psi)
Steel/Steel	1100
SBR Rubber/Steel	36
Neoprene/Steel	30
ABS/ABS	490
PVC/PVC	400

### T-Peel

T-Peel strengths were measured on 1" wide bonds. The bond thickness was 0.004". The jaw separation rate was 20 inches per minute.

Substrate	T-Peel Pounds Per Inch Width
Aluminum/Aluminum	2
Steel/Steel	2

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08107

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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 the 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.

### PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
2. Remove plug from end of cartridge.
3. Extrude a small amount of product until both parts A and B dispense equally.
4. Attach 3M™ Mixing Nozzle (PN 38193) 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.

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## Applications

See “Product Uses” above.

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## Storage and Handling

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 24 months from the date of manufacture. Store in a dry area at 72°F for optimal shelf life. Store away from acids and other oxidizing agents. Rotate stock on a “first-in-first-out” basis. Store away from acids and other oxidizing agents.

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

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08107

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<b>Precautionary Information</b>	Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.
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