



# Control-Flow Seam Sealer

08329

Technical Data Sheet

August, 2012

3M Part No.(s)	3M Part Descriptor(s)
08329	3M™ Control-Flow Seam Sealer

**Product Description** 3M™ Control-Flow Seam Sealer uses two part urethane technology to provide a tough flexible material for the sealing of joints on primed or painted substrates such as steel or aluminum enclosures. 3M™ Control-Flow Seam Sealer works particularly well in areas where a flowable self-leveling type seam sealer is required, it is designed to flow one to two inches then begins to cure preventing further flow out of the material, this feature allows the user to control application preventing excessive waste while maintaining a uniform film thickness even on surfaces that are not level.

- 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>	8.5 / 8.7
<b>Color</b>	Black / Amber
<b>Viscosity (CPS) Brookfield Viscometer</b>	Base 1,100 - 2,400 cps
<b>Consistency</b>	Paste
<b>Solvent</b>	N/A
<b>Service Temperature - °F</b>	-20°F to 180°F

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**Product Uses** Typical product uses include automotive “roof ditch” applications where a flow grade sealer is required.

3M™ Control-Flow Seam Sealer flows one to two inches then begins to cure, this feature allows the user to control application preventing excessive waste while maintaining a uniform film thickness even on surfaces that are not level.

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

**3M™ Mix Nozzle: PN 08193 (6/bag), PN 8194 (50/box).**

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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:**

3 minutes

**MIX NOZZLE DWELL TIME:**

1 minute

**CURE TIME:**

2 hours

**PAINT TIME:**

40 minutes

**TENSILE STRENGTH:**

2492 PSI

**ELONGATION:**

407%

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**Directions for Use** **NOTE:** 3M Best Practice is that all sealers, unless designated specifically for use on bare metal, be applied to properly prepared automotive paint or primer.

**SURFACE PREPARATION:**

**NOTE:** Apply only to surfaces primed with a 2K urethane, 2K epoxy primer, or clean, sanded paint. Acid etch primers should never be in direct contact with seam sealer.

1. Scuff primed surface with a Scotch-Brite™ General Purpose Hand Pad (Ultrafine), (PN 07448).
2. Blow off dust with clean, compressed air and wipe with a clean, dry rag.

**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.
5. Dispense a small amount of material and discard.

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### Directions for Use (continued)

#### GENERAL REPAIR PROCESS:

1. Extrude sealer onto surface. Allow to cure a minimum of 15 minutes before beginning the painting process.

**NOTE:** If sealer is allowed to cure more than 24 hours, scuff the sealer prior to any painting steps.

#### APPLICATION WARNINGS:

- Not to be used in direct contact with acid etch primers.

#### STORAGE:

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

#### CLEAN-UP:

Prior to curing, 3M™ Control-Flow Seam Sealer may be cleaned from most surfaces using 3M™ General Purpose Adhesive Cleaner or 3M™ Specialty Purpose Adhesive Remover (check for local VOC regulations).

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### Applications

Typical applications include automotive “roof ditch” and some “trunk rain gutter” seams where the use of a standard “self leveling” sealer is unacceptable due to flow characteristics.

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### Storage and Handling

#### HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Keep out of the reach of children. Keep container closed when not in use. Avoid breathing of dust created by cutting, sanding, grinding or machining. For industrial or professional use only. Avoid eye contact with dust or airborne particles.

#### 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 in a dry area at 72°F for optimal shelf life. Store away from acids and other oxidizing agents.

**After use, leave mix 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.

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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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