



Fiberglass Matting Adhesive

08277

Technical Data Sheet

June, 2011

3M Part No.(s)	3M Part Descriptor(s)
08277	3M™ Fiberglass Matting Adhesive

Product Description 3M™ Fiberglass Matting Adhesive, PN 08277, is a low viscosity, two part urethane used to saturate fiberglass cloth or mat when performing backside reinforcement repairs on Sheet Molded Compound (SMC), Fiber Reinforced Polyester (FRP) i.e. Fiberglass, and Metton®.

- Features**
- Meets OEM strengths specifications
 - Freightliner; Standard No. 49-00093 Revision C
 - PACCAR; Specification No. CMT0038
 - Excellent absorption into fiberglass mat or cloth
 - Low viscosity
 - 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.

	Part A	Part B
Container	400 ml Dual Cartridge	
Base	Urethane	Curative
Density lbs/Gallon (Appx.)	11	11
Color	Green	White
Solids Content (Appx.)	100%	100%
Consistency	Flowable Liquid	Flowable Liquid
Service Temperature - °F	-40 to 180°F	-40 to 180°F

Product Uses

3M™ Fiberglass Matting Adhesive is used to saturate fiberglass cloth and/or mat when creating backup patches for Sheet Molded Compound (SMC), Fiber Reinforced Polyester (FRP) i.e. Fiberglass and Metton® panels. If bonding reinforcement patches to flexible plastics or Metton® use 3M™ Polyolefin Adhesion Promoter, PN 05907 before applying the patch.

Use with the following applicators; PN 08280 or PN 08284.

Use with the following 3M™ Mixing Nozzles; PN 08193 or PN 08194.

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Typical Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 73°F (23°C) and are considered typical values.

MIX NOZZLE DWELL TIME:

9.5 minutes

WORK TIME:

10 minutes

SAND TIME:

45 minutes

CURE TIME:

24 hours

PAINT TIME:

N/A

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

Overlap Shear Strength, tested @ 73°F (23°C)

1" x 4" coupon, with 1" overlap. 30 mil bond thickness.

Lap Shear, SMC	828 PSI	ASTM D3163
Tensile Strength	2760 PSI	ASTM D638-10
Elongation	63%	ASTM D638-10

Directions for Use

SURFACE PREPARATION

1. Wash the surface with soap and water to remove water soluble contaminants. Clean with an appropriate 3M VOC compliant product to remove remaining surface contaminants. Reference the 3M Automotive Aftermarket catalog for a suitable VOC compliant product.
2. Sand the bonding surfaces with a P80 grit 3M abrasive.
3. Remove dust from surface using clean, compressed air and a clean rag.
4. SMC and fiberglass DO NOT require an adhesion promoter. If repairing Metton®, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter, PN 05907, to the repair area. Allow promoter to dry for 5 minutes before applying the patch.

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Directions for Use (continued)

PRODUCT PREPARATION

1. Insert the cartridge into the applicator gun.
2. Remove the retaining collar and plug from the end of the cartridge. Discard the plug. Save the retaining collar.
3. Equalize the cartridge by extruding a small amount of product until both parts A and B dispense equally.
4. Attach the 3M™ Mixing Nozzle, PN 08193 or 08194 to the cartridge and lock it in place with the retaining collar.
5. Dispense a small amount of material out of the nozzle and discard.

GENERAL REPAIR PROCESS

1. Cut a piece of 3M™ Fiberglass Cloth, PN 05838, or 3M™ Fiberglass Mat, PN 05837, with a footprint 1-1/2" bigger than the repair area. Use PN 08277 adhesive and a spreader to saturate fiberglass cloth or fiberglass mat.
2. Apply a "tight coat" of PN 08277 to the surface of the repair. Use a 3M™ Spreader, PN 05842 or PN 05844 to work a small amount of adhesive across the repair area.
3. Apply the patch to the repair area.
4. Repeat Step 2 with additional PN 08277 adhesive and fiberglass cloth or fiberglass mat until the desired repair thickness is reached.
5. Use a plastic spreader and additional PN 08277 (if needed) to shape repair area.
Note: Be sure that the fiberglass cloth or fiberglass mat is completely covered with adhesive. No edges or loose strands should be visible.
6. Let dry for 45 minutes at 73°F and then proceed to the front side repair.

APPLICATION WARNINGS

1. DO NOT use a two part polyester body filler or putty over PN 08277. Bubbling may result.
2. If bonding reinforcement patches to flexible plastics apply a light, consistent coat of the 3M™ Polyolefin Adhesion Promoter, PN 05907, to the bonding surface as the last surface preparation step. Allow the promoter to dry for 5 minutes before applying the patch.

CLEAN-UP

1. Remove excess PN08277 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 the full line of suitable VOC compliant products.

Applications

See "Product Uses" on page 1.

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Storage and Handling When stored at the recommended conditions in original, unopened containers, this product has a shelf life of at least 24 months from the date of manufacture. Store at room temperature. Rotate stock on a “first-in-first-out” basis. After use, leave the mix nozzle in place to seal the cartridge.

Precautionary Information Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. MSDS Doc# 09-5342-2.

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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For Additional Health and Safety Information



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