



Technical Data Sheet

3M™ Scotch-Seal™ Industrial Sealant 800



[Product Details](#)



[Regulatory Info/SDS](#)

Product Description

3M™ Scotch-Seal™ Industrial Sealant 800 is a reddish brown, brushable sealant that air dries to a flexible seal that resists water, oils and fuel and adheres to many metallic surfaces and has a useful temperature range of -65° to 200°F (-54 to 93°C).

Technical Information Note

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

Typical Uncured Physical Properties

Attribute Name	Value
Base	Nitrile
Net Weight	8.4 to 8.8 lb/gal
Consistency	Heavy Syrup

Typical Mixed Physical Properties

Attribute Name	Value
Tack Free Time	5 to 10 min

Typical Physical Properties

Attribute Name	Temperature	Value
Color		Reddish brown
Solids Content by Weight		50 to 59 %
Viscosity	22 °C (72 °F)	25,000-45,000 cP ¹
Dry Time		1,440 to 4,320 min ²
Solvent Resistance		Methyl Ethyl Ketone, Methyl Isobutyl Ketone
Coverage		375 LF/gal ³
Coverage		1,500 LF/gal ⁴
Flash Point		-6.7 °C (20 °F)
Weather Resistance		After 500 hrs. exposure in an accelerated weathering unit (Weatherometer), sealant remained flexible and rubbery.

¹ Brookfield Viscometer, RVF #6 sp. @ 20 rpm

² Dry time will depend on ambient temperature, humidity and coverage applied.

³ 1/4 inch diameter wet bead

⁴ 1/8 inch diameter wet bead

Typical Performance Characteristics

Dwell Time: 1 week

Attribute Name	Test Method	Temperature	Value
Elongation	ASTM 412	22 °C (72 °F)	1,040 %
Elongation	ASTM 412	71 °C (160 °F)	1,200 %
Tensile Strength	ASTM D412	22 °C (72 °F)	0.69 MPa (100 lb/in ²)
Tensile Strength	ASTM D412	71 °C (160 °F)	0.9 MPa (130 lb/in ²)

Handling/Application Information

Directions for Use

Surface Preparation: Best results are obtained on clean, dry surfaces. Oil, grease and other contaminants may be removed by wiping with solvent such as isopropyl alcohol, MEK, acetone, or other locally compliant solvent.*

Application: Production dispensing is best achieved with pressure flow equipment. A minimum 5:1 ratio pump with follower plate is suitable. A hand caulking gun or brush may also be used.

Drying Time: Surface dries tack free in approximately 5 minutes after application. Complete drying, depending upon temperature and air movement, is obtained in approximately 1-3 days.

Cleanup: Equipment and excess sealer may be cleaned with a solvent such as isopropyl alcohol, MEK, acetone, or other locally compliant solvent.*

Coverage: Approximately 1500 lineal ft./gal. for a 1/8 in diameter bead. Approximately 375 lineal ft./gal. for a 1/4 in diameter bead.

*Note: When using solvents, extinguish all ignition sources and be sure to follow the manufacturer's precautions and directions for use when handling such materials.

Application Equipment

Note: Appropriate application equipment can enhance adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

Pump - 5 to 1 ratio, double acting, ball type check valves, divorced design. Approximately 6 cubic in per cycle with 3 in air motor.

5 Gallon Pail Dispensing System: Primer - Disc type follower plate.

55 Gallon Drum Dispensing System:

Primer - Single post elevator with disc type follower plate.

Flow Gun - Tip seal type.

Pressure Filling Caulking Guns - Same equipment as listed above.

Manual Caulking Gun Filling: Kenmar Model 4T caulking gun filler, Semco Model 330 Vaculoader, Graco Model 225-975 caulking gun filler.

Hose - Nylon lined hose, 500 psi working pressure.

Reference Information:

Material Temperature: 40°F (4°C) Flow Gun: 1/4 in diameter Tip

Hose Assembly:	Material Pressure psi	Output Lb./Min.	Material Pressure psi	Output Lb./Min.
Ten Foot Length 3/4 I.D. Hose	270	4.0	270	4.0
Twenty Foot Length 3/4 I.D. Hose	360	4.0	270	2.3
Twenty Foot Length 3/4 I.D. Hose +				
Ten Foot Length 1/2 I.D. Hose	630	5.2	270	1.3
Twenty Foot Length 1/2 I.D. Hose	585	3.8	270	1.2
Ten Foot Length 1/2 I.D. Hose	450	4.7	270	1.6

Note: Material Pressure = Operating Air Pressure x Pump Ratio

Note: The solvent in this material attacks most materials except nylon, polysulfide, or PTFE.

Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first-out” basis. When stored in the original, unopened container at the storage conditions suggested this product has a shelf life of 15 months from date of manufacture.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

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