



Public

Rev:1

Effective: 05/26/99

Status: Active

Automix™ Channel Bonding and Sidelite Adhesive

Data Sheet

3M Part No.(s) **3M Part Descriptor(s)**
08641

3M Fax on Demand Identification Number:

Description

3M Automix™ Channel Bonding and Sidelite Adhesive is a fast curing flexible adhesive for bonding automotive side glass to metal channels and to rapidly bond stationary side glass into place.

3M Automix™ Channel Bonding and Sidelite Adhesive is to be used in conjunction with P.N. 08197 Mix/Dispense Nozzle and P.N. 08191 Heavy Duty Automix Applicator Gun.

This total mixing and application system will provide precise placement of adhesive with no waste and time savings.

Features, Advantages, Benefits

Features

Advantages

Benefits

Typical Physical Properties

Container	Base	Accelerator
Density lbs/Gallon (Appx.)	9.80	9.86
Color	Milky White	Black
Solids Content (Appx.)	100%	100%
Work Life Through Dispenser Nozzle	4-5 Minutes	

Product Uses

Performance Properties

Handling and Application Information

Directions for Use

Follow the instructions for assembly and use of the Automix Application P.N. 08190 and the Mixing Nozzle P.N. 08197. To obtain the best bonding and durability of assemblies, all of the surfaces need to be thoroughly clean. It is recommended that all glass be cleaned with 3M™ Glass Cleaner P.N. 08968. Metal can be cleaned with a solvent such as 3M™ General Purpose Adhesive Cleaner P.N. 08984*. When bonding channel glass it is recommended that enough adhesive is applied so a small amount of adhesive squeeze-out occurs.

When replacing stationary side/quarter glass check the current Auto Glass Journal-Auto Glass Installation Guide or the current Auto Manufacturer's Body Guide for the model being worked on. Determine the factory method of installation used, i.e. butyl tape and/or urethane sealer/adhesive. If butyl tape was used, follow recommended procedure for installing with butyl tape. If a urethane sealer/adhesive was used follow installation procedure using Automix™ Channel Bonding and Sidelite Adhesive in place of other type adhesives. Make sure glass and metal are clean. Apply adhesive as needed, fit glass and fixture as needed.

Because of the fast cure rate of Automix™ Channel Bonding and Sidelite Adhesive the car can be moved, other work finished i.e., trip/paint or put into service in approximately one (1) hour.

If all of the Automix Channel Bonding and Sidelite Adhesive Duo-Pak was not used for the job, remove nozzle, replace end on duo-pak and save for next job.

Cleanup:

Excess adhesive and equipment may be cleaned prior to curing with a solvent* such as 3M™ General Purpose Adhesive Cleaner*.

*NOTE: When using flammable solvents, extinguish all sources of ignition in the immediate work area and observe proper precautionary measures for handling such materials.

Applications

Stationary side glass that was factory assembled with a urethane adhesive/sealer, that needs to be removed and/or replaced, use Automix Channel Bonding and Sidelite Adhesive to give a cured, serviceable assembly in approximately one (1) hour compared to hours or even days for one-part sealers/adhesives and because of the black color the O.E.M. appearance is maintained.

Storage and Handling

Store at room temperature. Rotate stock on a "first-in-first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

Country

US

This document is public. It may be distributed.

Important Notice to Purchaser

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* If 'Directions for Use' reference P.N.'s 8984, 8986, or 8987, please read below.

Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer

to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

LIMITATION OF REMEDIES AND LIABILITY: If the 3M product is proved to be defective, **THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT.**

3M shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

For Additional Health and Safety Information

See Material Safety Data Sheet (Fax on Demand 1-800-305-0419), or call: **3M Automotive Aftermarket Division** 3M Center, Building 223-6N-01
Phone: 877-MMM-CARS (877-666-2277)

3M Fax on Demand Identification Number

Reference: Goto Ref

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