



Fast N Firm™ Seam Sealer

08505

Technical Data

January 2017

3M Part Numbers	3M Part Descriptor
08505	3M™ Fast N Firm™ Seam Sealer

Product Description 3M™ Fast N Firm™ Seam Sealer is a one-part solvent based automotive seam sealer designed for application to exterior body seams. 3M™ Fast N Firm™ Seam Sealer should be applied to properly prepared primer or paint coated surfaces and may be painted with common automotive type paint systems.

- Features**
- 1/10 Gallon Cartridge
 - Solvent based
 - Flexible

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.

Container	1/10 Gallon (378 mL) Cartridge
Base	Synthetic Rubber
Density lbs./Gallon (Approx.)	7.85 (940 g/liter)
Color	Tan
Flash Point	40°F (4°C)
Solids Content (Approx.)	64%
Consistency	Paste
Service Temperature	-20°F to 180°F (-29°C to 82°C)
Solvent	Toluene, Mineral Oil

Product Uses General sealing of exterior automotive seams including floor pans, hem flanges, frame rails, rear body panels and aprons.

Use with the following accessories:

- 3M™ Professional Caulking Gun (PN 08993)

For professional use only. Not intended for retail sale.

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Performance Properties

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

Cold Temperature Resistance at -20°F (-29°C)	Remains flexible .060 2" Mandrel
Heat Resistance: 500 hours at 150°F (65°C)	Remains flexible .060 2" Mandrel
Adhesion: Primed Metal: Excellent	Cohesive failure
Sag Resistance: 3/8" (10mm) bead	Zero sag after 30 min.

Directions for Use

1. Clean the primer, E-coat, or painted surface with a VOC compliant surface cleaner to remove any contaminants.
2. Scuff the surface using a Scotch-Brite™ Scuff Pad or grade P180 to P320 abrasive.
3. Blow off and re-clean the surface to ensure proper adhesion.
4. Cut the nozzle tip to the desired size and puncture the foil seal at the cartridge outlet. Press or knock out the center plug at the base of the cartridge.
5. Install the cartridge into a 3M™ Professional Caulking Gun (PN 08993).
6. Apply seam sealer and tool (if necessary) to desired finished appearance. A mild VOC compliant solvent may be used to smooth the sealer during the tooling process.
7. Allow 30 minutes before painting, after 24 hours scuff with a Scotch-Brite™ Scuff Pad.

NOTE: 3M does not recommend using this seam sealer in interior passenger compartment or trunk compartment applications. An objectionable residual solvent odor lasting up to a month has been reported by customers using the product. For seam sealers without this issue, choose 3M™ Urethane (PN 08360/08361/08364) or 3M™ MSP (PN 08369/08370).

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Applications	General purpose automotive seams, including door skins, rocker panels, rear body panels, trunk seams, floor pans, etc.
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. Use in a well-ventilated area.
Precautionary Information	Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOCs) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area.
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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