



Flexiclear™ Body Seam Sealer

08405

Technical Data Sheet

June, 2011

3M Part No.(s)	3M Part Descriptor(s)
08405	3M™ Flexiclear™ Body Seam Sealer

Product Description A medium-bodied, clear sealer with adhesion to primed and painted metal, glass, and aluminum. Typical applications may be edge sealing of vinyl roof tops, window sealing such as opera windows or any painted seam. This is a low-modulus, caulkable sealer.

Features

- Clear, non-yellowing
- Standard “caulk” dispensing system
- Fast drying

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	1/10th gallon cartridge
Base	Synthetic Rubber
Density lbs/Gallon (Appx.)	8.0
Color	Clear
Flash Point - °F	40°F
Solids Content (Appx.)	64%
Consistency	Buttery Paste
Solvent	Toluene / Xylene
Service Temperature - °F	-20 to 180°F

Product Uses A medium-bodied, clear sealer with adhesion to primed and painted metal, glass, and aluminum. Typical applications may be edge sealing of vinyl roof tops, window sealing such as opera windows or any painted seam. This is a low-modulus, caulkable sealer.

3M™ Flexiclear™ Body Seam Sealer

08405

Typical Performance Properties

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

1. Solids	61 +/- 1%
2. Sag, 30 Minutes	
1/4 inch bead	Approximately 0 inch
3/8 inch bead	0 inch
3. Tack Free Time	45-50 Minutes
4. Adhesion to:	
Glass	Good
Painted Metal	Very Good
Aluminum	Good
5. QUV 150°F/500 Hours	No effect on clarity or elastomeric properties
6. Flexibility (60 mil spread)	Flexible over a 2 inch Mandrel @ -20°F
7. Hardness, Tex	45

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. Applying over bare metal will not provide adequate corrosion protection. Flexiclear body seam sealer may be applied to clean unsanded paint.

Acid etch primer is not recommended to be used in direct contact with any 3M seam sealer. Residual acid can weaken the bond.

1. If applying Flexiclear body seam sealer over paint, skip step one and begin with step 2, otherwise, lightly scuff the area where the sealer is to be applied.
2. Wash surface with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate 3M VOC compliant product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.
3. Cut nozzle tip to provide 1/4" diameter bead. Puncture foil seal in base of spout. Knock out end seal at the bottom of the tube.
4. Place in 3M Professional Caulking Gun, PN 08993 and engage ratcheting mechanism.
5. Apply desired bead width and tool to final appearance, if necessary. When sealing is complete, disengage ratchet to stop flow.
6. Wait to dry before applying paint over the sealer (if painting is desired). Thicker beads of seam sealer will take longer to cure before painting.

Applications

- Adhesion to scuffed primer, clean paint, glass, and aluminum.
- Sealing edges of vinyl roof tops.
- Sealing opera-style windows.
- Sealing headlight/taillight seams.
- Sealing exterior RV seams.
- Sealing any other visible seam that will not be painted afterwards.

3M™ Flexclear™ Body Seam Sealer

08405

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 24 months. Use in a well-ventilated area.

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

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.

Warranty, Limited Remedy, and Disclaimer Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

For Additional Health and Safety Information



Automotive Aftermarket Division

3M Center, Building 223-6N-01
St. Paul, MN 55144-1000
1-877-666-2277 (1-877-MMM-CARS)
www.3MCollision.com

3M and Flexclear are trademarks of
3M Company.
Printed in U.S.A.
©3M 2011 P.N. 08405 (6/11)

This is the last page