



Duramix™ Super Fast Adhesive

04247

This procedure is recommended for the back side of a two-sided or structural plastic part repair:

1. Clean the work piece with soap and water, followed by 3M™ General Purpose Adhesive Cleaner (PN 08984, 08987).*
2. Abrade the damaged area of the back side (non-cosmetic side) of the plastic piece with the 3M™ Roloc™ Abrasive (Grade 50) on a pistol grip grinder set at a low speed.
3. Continue to sand the back side with a 3M™ Abrasive DA Disc (Grade 80) where the repair materials will be applied.
4. Use clean, unooled, compressed air to remove any dust from the work surface.
5. Apply a light coat of 3M™ Automix™ Polyolefin Adhesion Promoter (PN 05907) to the sanded area (front and back). Allow to dry for 5 minutes.
6. Use Scotch® Auto Body Repair Tape (PN 06930) on the front side of the repair piece, tenting in the middle, to keep the repair material from the back side from flowing through to the front.
7. Cut a piece of 3M™ Duramix™ Reinforcement Patch (PN 04904) 1 1/2" larger than the damage, remove the liner from the mesh and place the mesh aside (to be used in the next steps).
8. Prepare 3M™ Duramix™ Super Fast Adhesive (PN 04247) by removing the collar and plug from the cartridge. Insert the cartridge into the 3M dispenser (PN 08571 or 08117) and extrude a small amount of adhesive, be sure that both parts of the adhesive are extruded prior to attaching the mixing nozzle. Attach PN 08193 mixing nozzle.
9. Apply adhesive to the abraded area use a 3M spreader with firm pressure and spread a tight coat of adhesive to insure good contact with the plastic. Position the reinforcement mesh on the damage and continue to build thin, wet coats until the repair adhesive is slightly higher than the surrounding plastic. Multiple layers of 3M™ Duramix™ Reinforcement Patch (PN 04904) may be used to increase strength. **Work quickly as this adhesive has a 20 second work time at 70°F.**
10. Allow the adhesive to cure for 15 minutes.
11. Remove the Scotch® Auto Body Repair Tape (PN 06930) and follow directions for use contained in the preferred product for front side (cosmetic) repair, 3M™ Automix™ Flexible Repair Material (PN 05887).

Caution: Do not apply polyester fillers or putties over this product.

* Consult your local, state and federal air quality regulations before using 3M™ General Purpose Adhesive Cleaner (PN 08984 or 08987) to prepare the surface.



This procedure is recommended for the repair of mounting tabs on plastic parts:

1. Clean the work piece with soap and water, followed by 3M™ General Purpose Adhesive Cleaner (PN 08984, 08987).*
2. Carefully abrade both sides of the damaged area of the plastic piece with the 3M™ Roloc™ Abrasive (Grade 50) on a pistol grip grinder set at a low speed, it is important to create a bevel that proceeds 1/2" back from the edge of the damage.
3. Continue by sanding with a 3M™ Abrasive DA Disc (Grade 80) where the repair materials will be applied.
4. Drill 1/8" holes 1/4" from the edge of the damage within the bevel. Holes should be located approximately 1/4" - 1/2" apart.
5. Apply a light coat of 3M™ Automix™ Adhesion Promoter (PN 05907) allow to dry 10 minutes.
6. Prepare 3M™ Duramix™ Super Fast Adhesive (PN 04247) by removing the collar and plug from the cartridge. Insert the cartridge into the 3M™ dispenser (PN 08571, or 08117) and extrude a small amount of adhesive, be sure that both parts of the adhesive are extruded prior to attaching the mixing nozzle. Attach PN 08193 mixing nozzle.
7. Cut a piece of Duramix™ contouring sheet (PN04903) 2 1/2 times the length of the tab to be rebuilt.
8. Apply a sufficient amount of 04247 on the contouring sheet.
 - Caution: Do not build up, but build out to a maximum of 1/4" thickness
 - Caution: Duramix™ can generate high temperatures in mass.
9. Immediately place Duramix™ and contour sheet on prepared plastic surface, forcing the adhesive into the drilled holes and forming the rough shape of the tab. **Work quickly as this adhesive has a 20 second work time at 70°F.**
10. Allow to cure for 15 minutes and remove contour sheet.
11. Carefully grind rough shape using a 3M™ Roloc™ Abrasive (Grade 50). Sand to finished shape using grades 80–180.
12. Drill appropriate size and location attachment hole through new tab.
13. If a smoother (cosmetic) repair is desired, we suggest 3M™ Automix™ Flexible Repair Material PN 05887 as a final skin coat over Duramix™ 04247. Follow appropriate directions for use.

Caution: Do not apply polyester fillers or putties over this product.

* Consult your local, state and federal air quality regulations before using 3M™ General Purpose Adhesive Cleaner (PN 08984, 08987) to prepare the surface.

For Additional Information: To request additional product information or to arrange for sales assistance, call toll free 1-888-663-1394. Address correspondence to: 3M Automotive Aftermarket Division, 3M Center, Building 223-6N-01, St. Paul, MN 55144-1000. Or fax number is 651-733-9175.

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ISO 9002 • ISO 14001

This Automotive Aftermarket Division product was manufactured under a 3M system registered to both the ISO 9002 quality management system standard and to the ISO 14001 environmental management system standard.

3M Automotive Aftermarket Division

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U.S. Patent No. 4,677,157; 4,869,400; 5,166,301. Canadian Patent No. 1,316,507. European Patent No. 0,374,202.
Other U.S. and Foreign Patents Pending.

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Spec # 38-9019-4713-5
Structure: 8.5 x 11
Inks: Black
Date: 06/19/07

SCALE:  **1 Inch**