

3M 08115

3M Panel Bonding Adhesive 08115 Instruction Manual

PRODUCT OVERVIEW

The 3M Panel Bonding Adhesive 08115 is an OEM recommended two-part epoxy designed for bonding automotive body panels. This 200 mL cartridge provides a strong, durable, and permanent bond for non-structural repairs, such as quarter panels, roofs, box sides, van sides, utility vehicle sides, and door skins. It is formulated to bond various materials including steel, aluminum, SMC, and FRP (traditional fiberglass).

- **OEM Recommended:** Trusted by OEMs for non-structural repairs.
- **Strong Multi-Material Bond:** Creates a durable hold on properly prepared steel, aluminum, SMC, and fiberglass (FRP) surfaces.
- **Extended Work Time, Fast Cure:** Offers a 90-minute working time, a 4-hour clamp time, and full cure at room temperature in 24 hours. Cure time can be accelerated with heat.
- **Weld & Rivet Friendly:** Can be weld-bonded or rivet-bonded during its work time.
- **Easy Cartridge Application:** Packaged in a 200 mL dual cartridge for use with a standard applicator gun (not included).



Image: The 3M Panel Bonding Adhesive 08115 in its 200 mL cartridge packaging.

SETUP AND PREPARATION

Required Tools and Materials:

- 3M Panel Bonding Adhesive 08115 cartridge
- Standard two-part adhesive applicator gun (not included)
- Mixing nozzle (included with cartridge)
- Surface cleaning agents (e.g., 3M General Purpose Adhesive Cleaner)
- Abrasive material (e.g., sandpaper, Scotch-Brite pad)
- Clamps or fasteners
- Personal protective equipment (gloves, eye protection)

Surface Preparation:

1. Ensure all surfaces to be bonded are clean, dry, and free of oil, grease, wax, and other contaminants.
2. Mechanically abrade the bonding surfaces using appropriate abrasive materials to ensure proper adhesion.
3. Clean the abraded surfaces thoroughly with a suitable cleaning agent and allow to dry completely.

Cartridge Preparation:

1. Remove the cap from the 3M Panel Bonding Adhesive 08115 cartridge.
2. Attach a mixing nozzle securely to the cartridge.
3. Load the cartridge into a compatible two-part adhesive applicator gun.
4. Dispense a small amount of adhesive onto a scrap surface until both components are flowing evenly and the color is consistent, indicating proper mixing. This purges any unmixed material from the nozzle.



Image: The 3M Panel Bonding Adhesive 08115 cartridge with two mixing nozzles, ready for use with an applicator gun.

Video: Official 3M video demonstrating the application process for 3M Panel Bonding Adhesives.

APPLICATION INSTRUCTIONS

1. Apply the mixed adhesive directly to one of the prepared bonding surfaces. Ensure even coverage across the entire bonding area.
2. Align and join the panels within the 90-minute working time.
3. Secure the bonded panels with clamps or other fasteners for a minimum of 4 hours to maintain proper alignment and contact during the initial cure.
4. The adhesive features integrated glass-bead technology, which acts as a built-in spacer to ensure

optimal bond line thickness and prevent over-clamping.

5. For full strength, allow the adhesive to cure at room temperature for 24 hours. The cure time can be accelerated with the application of heat.
6. The adhesive can be weld-bonded or rivet-bonded during its working time, offering flexibility in repair methods.



Image: Adhesive being applied to a car panel, demonstrating the dispensing process.



Image: Diagram explaining how glass bead technology protects against over-clamping and maintains minimum bond line

thickness.



Image: Illustration indicating that the adhesive bonds door skins, roof skins, quarter panels, box sides, and bumper covers.

MAINTENANCE

Storage:

Store the adhesive cartridge in a cool, dry place away from direct sunlight and extreme temperatures. Ensure the cap is securely replaced after use to prevent contamination and premature curing of the remaining adhesive.

Re-use of Cartridge:

To re-use an opened cartridge, leave the mixing tip attached after initial use. Allow the adhesive within the tip to cure. When ready to use again, remove the cured mixing tip and attach a new, clean mixing tip. Purge a small amount of adhesive as described in the 'Cartridge Preparation' section before applying to your project.

TROUBLESHOOTING

- **Poor Adhesion:** Ensure surfaces are thoroughly cleaned and abraded before application. Contaminants or insufficient surface preparation can lead to weak bonds.
- **Inconsistent Mixing:** Always purge a small amount of adhesive through the mixing nozzle until a consistent color is achieved before applying to the repair area. This ensures both parts of the epoxy are properly mixed.
- **Adhesive Curing Too Slowly:** Verify ambient temperature is within recommended ranges. Curing can be accelerated by applying gentle heat (e.g., with a heat gun) if faster cure times are desired.
- **Over-clamping:** The integrated glass beads help prevent over-clamping. Ensure you are using appropriate clamping pressure to allow the glass beads to maintain the optimal bond line thickness.

PRODUCT SPECIFICATIONS

- **Product Dimensions:** 6.5 x 4.3 x 1.5 inches
- **Item Weight:** 10.6 ounces
- **Item Model Number:** 08115
- **Manufacturer:** 3M
- **Adhesive Type:** Two-part epoxy

- **Work Time:** 90 minutes
- **Clamp Time:** 4 hours
- **Full Cure (Room Temp):** 24 hours

SAFETY INFORMATION

3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and other limitations, and the user must take any action required under any recall, field action, or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, death, or property damage. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.

WARRANTY AND SUPPORT

For specific warranty information regarding the 3M Panel Bonding Adhesive 08115, please refer to the product packaging or contact 3M directly. For technical support, product inquiries, or safety data sheets, please visit the official 3M website or contact their customer service department.

3M Official Website: www.3M.com

Always ensure you are using the product in accordance with all local and national safety regulations and guidelines.