



NVH Dampening Material

04274

Technical Data Sheet

May, 2011

3M Part No.(s)	3M Part Descriptor(s)
04274	3M™ NVH Dampening Material

Product Description A heavy bodied, flexible 2-part urethane adhesive to be used for NVH (noise, vibration and harshness) damping applications. Ideally suited for applications requiring long open time and/or non-expanding material.

- Features**
- 200 ml Dual-Syringe Cartridge System
 - Non-expanding
 - Long work time
 - Remains 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.

	Part A	Part B
Container	200 ml Dual-Syringe Cartridge	
Base/Accelerator	Urethane	
Color	Black	Amber / Clear
Solids Content (Appx.)	100%	
Consistency	Thick paste when mixed	
Service Temperature - °F	-20 to 180°F	

Product Uses

NVH applications throughout the vehicle, including, but not limited to:

- Between roof bows and roof skin
- Between door skin and intrusion beam
- Between quarter panel and inner structure
- Between hood and deck lid skins and underlying spider frames

Use with the following applicators: PN 08571 (manual), PN 08117 (manual), and PN 09930 (pneumatic).

3M™ Static Mixing Nozzle: PN 08193 (6/bag), PN 08194 (50/box).

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Typical Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 70°F and are considered typical values.

WORK TIME:

60 minutes

MIX NOZZLE DWELL TIME:

20 minutes

CURE TIME:

24 hours at 77°F

1 hour at 160°F

30 minutes at 210°F

HARDNESS:

45 shore A

Directions for Use

1. Where applicable, clean areas with an appropriate 3M VOC compliant product for removal of surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable VOC compliant product.
2. Dry fit replacement panel to ensure proper fit up prior to applying 3M™ NVH Dampening Material.

PRODUCT PREPARATION:

1. Insert cartridge into applicator gun.
2. Remove retaining collar and plug from end of cartridge. Discard plug, save retaining collar.
3. Extrude a small amount of product until both parts A and B dispense equally. **NOTE:** Parts A and B of this product are very runny prior to mixing. It is recommended that you extrude the material with the dispensing end of the cartridge facing upward, into a paper towel. Continue to hold the cartridge in this position until you have completed the next step (4).
4. Attach 3M™ Static Mixing Nozzle (PN 08193, 08194) to cartridge and lock in place with retaining collar.
5. Dispense a small amount of material through the nozzle and discard.

PRECAUTIONARY INFORMATION:

Before using this product, please reference Product Label and/or Material Safety Data Sheet for Health and Safety Information.

GENERAL REPAIR PROCESS:

1. Apply adhesive to the desired area.
2. Allow to cure 24 hours.

CLEAN-UP:

Remove excess PN04274 prior to complete cure by using an appropriate VOC compliant adhesive remover suitable for most surfaces, such as 3M™ Specialty Adhesive Remover (PN38984 / PN38987).

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Applications May be used as a noise dampening material in the form of a bead, or tooled with a spreader over an area to form a sound dampening pad.

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

After use, leave mix nozzle in place to seal the cartridge.

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.

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For Additional Health and Safety Information



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