

September 24, 2024

Version 3

Recommended Sealers and Adhesives for Collision and Body Repairs

Supersedes Job Aid Recommended Sealers and Adhesives for Collision and Body Repairs, dated January 24, 2019, to revise the information highlighted in **yellow**.

REVISION SUMMARY

Under the 2K Seam Sealers and Liquid Applied Sound Deadening tables, the information has been updated.

RECOMMENDED SEALERS AND ADHESIVES

- Always follow Acura's applicable body repair manual information for location of adhesives, sealers, foams and corrosion protection materials.
- Always follow the product manufacturer's recommendations for application of adhesives, sealers, foams and corrosion protection materials.

Definition

Work Time/Speed for Metal Bonding Adhesives	
Fast	5-10 min
Medium	10-60 min
Slow	60+ min

Seam Sealer Terminology	
Self Leveling	Will flow and level significantly (e.g., Thin Viscosity)
Controlled Flow	Will hold shape but "edges" smooth off
Non-Sag	Will hold shape (single bead) in all positions

Type	
A	Acrylic or Methacrylate
E	Epoxy
E/U	Epoxy/Urethane
M	MSP or Modified Silane Polymer
S	STP or Silane Terminated Polymer
U	Urethane
R	Rubber

CLIENT INFORMATION: The information in this bulletin is intended for use only by skilled technicians who have the proper tools, equipment, and training to correctly and safely maintain your vehicle. These procedures should not be attempted by "do-it-yourselfers," and you should not assume this bulletin applies to your vehicle, or that your vehicle has the condition described. To determine whether this information applies, contact an authorized Acura automobile dealer.

Panel Adhesive

Application: Standard Panel Adhesive (slow and medium)

Supplier	Part Number	Type	Working Time
3M	08115	E	90 min
	08116	E	90 min
Fusor	208B	E	90 min
	112B	A	75 min
	108B	A	45 min
SEM	39747	E	90 min
	39537	A	60 min
Kent	P12638	E	90 min
	KT12577	A	45 min
	P10638	E	45 min

Application: Door Skin Adhesive (medium)

Supplier	Part Number	Type	Working Time
3M	08115	E	90 min
	08229	E	60 min
Fusor	108B	A	45 min
SEM	39337	E	30 min
Kent	P10581	E	60 min

Application: Impact Resistant Structural Adhesive (slow)

Supplier	Part Number	Type	Working Time
3M	07333	E	60 min
Fusor	2098	E	90 min
SEM	39757	E	60 min
Kent	1523691	E	60 min

General Purpose Adhesives

Application: 20 Second			
Supplier	Part Number	Type	Working Time
3M	04247	U	20 sec
Fusor	N/A	N/A	N/A
SEM	40207	U	20 sec
Kent	KT13632	U	20 sec
	KT13629	U	20 sec

Application: 50 Second			
Supplier	Part Number	Type	Working Time
3M	04240	U	1 min
Fusor	132	U	1 min
	141	U	1.5 min
	142	U	1.5 min
	152	U	3 min
	SEM	40507	U
Kent	KT13630	U	50 sec

Application: 3 Minute			
Supplier	Part Number	Type	Working Time
3M	08223	U	3 min
Fusor	147	U	5 min
SEM	41807	U	3 min
Kent	P10635	E	3 min

1K Seam Sealers (Bead)

Color: White			
Supplier	Part Number	Type	Working Time
3M	08368	U	N/A
Fusor	N/A	N/A	N/A
SEM	29362	S	N/A
Kent	KT15176	M	N/A

Color: Beige			
Supplier	Part Number	Type	Working Time
3M	08365	U	N/A
Fusor	800DTM	S	N/A
SEM	29382	S	N/A
Kent	P10552	U	N/A
	KT13977	M	N/A

Color: Grey			
Supplier	Part Number	Type	Working Time
3M	08362	U	N/A
Fusor	N/A	N/A	N/A
SEM	29372	S	N/A
Kent	KT13978	M	N/A

Color: Black			
Supplier	Part Number	Type	Working Time
3M	08367	U	N/A
Fusor	803DTM	S	N/A
SEM	29392	S	N/A
Kent	P10556	U	N/A
	KT13979	M	N/A

Color: Clear			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A

Color: Clear			
Supplier	Part Number	Type	Working Time
Fusor	N/A	N/A	N/A
SEM	N/A	N/A	N/A
Kent	KT10200	R	N/A
	P10195	R	N/A

1k Seam Sealers (Sprayable)

Color: White			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	802HD	S	N/A
SEM	29362	M	N/A
Kent	N/A	N/A	N/A

Color: Beige			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	806HD	S	N/A
SEM	29382	M	N/A
Kent	KT14093	M	N/A
	1232170	M	N/A

Color: Grey			
Supplier	Part Number	Type	Working Time
3M	08374	M	N/A
Fusor	804HD	S	N/A
SEM	29372	M	N/A
Kent	P13746	M	N/A
	1232171	M	N/A

Color: Black			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	805HD	S	N/A

Color: Black			
SEM	29392	M	N/A
Kent	KT12592	M	N/A
	1232172	M	N/A

2K Seam Sealers

Color: White			
Supplier	Part Number	Type	Working Time
3M	08524	E	6 min
Fusor	123	U	3-5 min
	123SL	U	45 min
SEM	40477	E	10 min
Kent	N/A	N/A	N/A

Color: Beige			
Supplier	Part Number	Type	Working Time
3M	08522	E	6 min
Fusor	019	A	6 min
	129	E	5 min
SEM	39477	E	10 min
Kent	P10491	E	8 min

Color: Rose			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	N/A	N/A	N/A
SEM	N/A	N/A	N/A
Kent	KT12400	E	8 min

Color: Grey			
Supplier	Part Number	Type	Working Time
3M	08526	E	6 min
	05887	E	5 min
Fusor	N/A	N/A	N/A
SEM	39377	E	10 min

Color: Grey			
Kent	N/A	N/A	N/A

Color: Black			
Supplier	Part Number	Type	Working Time
3M	08528	E	6 min
Fusor	N/A	N/A	N/A
SEM	40377	E	10 min
Kent	KT14999	E	12 min

Color: Blue			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	122EZ	E	8 min
	123EZ	E	10 min
SEM	N/A	N/A	N/A
Kent	N/A	N/A	N/A

Self-Leveling Seam Sealer

Application: Thin Viscosity (self-leveling)			
Supplier	Part Number	Type	Working Time
3M	08307	E	8 min
Fusor	122EZ	E	8 min
SEM	39387	E	10 min
Kent	P10486	E	10 min

Application: Thick Viscosity (controlled flow)			
Supplier	Part Number	Type	Working Time
3M	08329	U	3 min
	08323	U	10 min
Fusor	129	E	5 min
SEM	39777	E	10 min
	39477	E	10 min
Kent	KT12401	E	10 min

Plastic Repair

Application: Cosmetic Plastic Repair			
Supplier	Part Number	Type	Working Time
3M	05887	E	5 min
Fusor	114	N/A	1 min
	132	N/A	1 min
SEM	39847	E	7 min
Kent	1429183	E	7 min

Application: Structural Plastic Repair - All			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	132	N/A	1 min
	142	N/A	1.5 min
	152	N/A	3 min
SEM	N/A	N/A	N/A
Kent	N/A	N/A	N/A

Application: Structural Plastic Repair - Semi Rigid			
Supplier	Part Number	Type	Working Time
3M	04240	U	50 sec
Fusor	132	N/A	1 min
	142	N/A	1.5 min
	152	N/A	3 min
SEM	39847	E	7 min
Kent	P10615	E	7 min
	1429183	E	7 min

Application: Structural Plastic Repair - Rigid			
Supplier	Part Number	Type	Working Time
3M	05885	E	8 min

Application: Structural Plastic Repair - Rigid			
Fusor	132	N/A	1 min
	142	N/A	1.5 min
	152	N/A	3 min
SEM	N/A	N/A	N/A
Kent	P10611	E	45 min
	KT13968	E	15 min

Application: Plastic Tab Repair			
Supplier	Part Number	Type	Working Time
3M	04247	U	20 sec
Fusor	132	N/A	1 min
	142	N/A	1.5 min
	152	N/A	3 min
	141	N/A	1.5 min
SEM	N/A	N/A	N/A
Kent	KT13139	E	3 min
	KT13140	E	3 min

Application: Structural Plastic Repair - Flexible			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	N/A	N/A	N/A
SEM	N/A	N/A	N/A
Kent	P10531	E	7 min

Corrosion Protection

Application: Weld-Through Primer			
Supplier	Part Number	Type	Working Time
3M	05917	N/A	N/A
Fusor	S-G 076607-82781	N/A	N/A
SEM	40773	N/A	N/A
Kent	KT13402	N/A	N/A
	KT13821	N/A	N/A
	P60295	N/A	N/A

Application: Cavity Wax			
Supplier	Part Number	Type	Working Time
3M	08852	N/A	N/A
Fusor	S-G 636425-06425	N/A	N/A
SEM	39573	N/A	N/A
Kent	P60305	N/A	N/A

Application: Cavity Wax Wand Kit			
Supplier	Part Number	Type	Working Time
3M	08851	N/A	N/A
Fusor	S-G 636425-06426	N/A	N/A
SEM	N/A	N/A	N/A
Kent	KT14725	N/A	N/A

Sound Dampening

Application: NVH, Panel Vibration for Replacement

Supplier	Part Number	Type	Working Time
3M	08463	U	40 sec
Fusor	121	U	10 sec
	231	U	60 min
SEM	39977	E/U	60 min
Kent	KT13523	E/U	60 min

Application: NVH, Panel Vibration for Reattachment

Supplier	Part Number	Type	Working Time
3M	04274	U	1 min
Fusor	121	U	10 sec
	231	U	60 min
SEM	39977	E/U	60 min
Kent	KT13523	E/U	60 min

Application: Flexible Foam

Supplier	Part Number	Type	Working Time
3M	08463	U	40 sec
Fusor	121	U	10 sec
SEM	39357	U	15 sec
Kent	P10601	U	30 sec
	P10630	U	30 sec

Application: Rigid Foam

Supplier	Part Number	Type	Working Time
3M	08458	U	1 min
Fusor	130	U	10 sec
SEM	39997	U	45 sec
Kent	P10612	U	30 sec
	KT13672	U	60 sec

Liquid Applied Sound Deadening

Application: Heavy bodied LASD			
Supplier	Part Number	Type	Working Time
3M	08528	E	6 min
Fusor	231	U	60 min
SEM	40977	E/U	10 min
Kent	N/A	N/A	N/A

Sound Dampening Pads

Application: Peel and Stick			
Supplier	Part Number	Type	Working Time
Acura	72846-282-305AH (available from dealer)	N/A	N/A
3M	08840	N/A	N/A
Fusor	N/A	N/A	N/A
SEM	N/A	N/A	N/A
Kent	P32947	N/A	N/A

Application: Aluminum Backed			
Supplier	Part Number	Type	Working Time
3M	N/A	N/A	N/A
Fusor	N/A	N/A	N/A
SEM	N/A	N/A	N/A
Kent	KT13306	N/A	N/A