



OEM Match Sprayable Tip 1K

33991

Technical Data

July 2024

3M Part Number	3M Part Descriptor
33991	3M™ OEM Match Sprayable Tip 1K

Product Description 3M™ OEM Match Sprayable Tip 1K is the solution for 3M™ 1-Part cartridge MSP seam sealer products to help replicate the original look and appearance of some sprayed seam sealers applied at the factory.

Features

- Easy attachment to 3M™ Aluminum 1K Cartridges
- Works with 3M™ 1K cartridge MSP Sealers
- Recoverable item when using 3M™ RepairStack™ and Billables Invoicing Software

Typical Physical / Performance Properties 3M™ OEM Match Sprayable Tip 1K is comprised of 2 parts that rotate independently from each other. Do not attempt to disassemble the tip as this may affect the performance. Both parts are made of Polypropylene.

Product Uses 3M™ OEM Match Sprayable Tip 1K is designed to help technicians replicate some robotically applied seam sealers from the factory. Typical areas these beads can be found will include, but are not limited to, trunk floors, rear body panels, rear frame rails, floor pans, quarter panels, strut towers, front frame rails and more.

The tip is designed to work with 3M™ 1-Part Cartridge Seam Sealers along with 3M™ OEM Match Sprayable Air Supply Kit PN 39999. All seam sealers, including bare metal seams sealers, should be applied over a 2K Epoxy or 2K Urethane primer. Using seam sealers other than the recommended seam sealers could result in performance issues in both replication appearance and product performance.

When using the 3M™ OEM Match Sprayable Tip 1K, make sure it is applied to a properly prepared and equalized cartridge. Not doing so could lead to product failure.

When using 3M™ OEM Match Sprayable Tip 1K, make sure it is firmly applied to a 3M™ Cartridge. Improper threading or loose fit could lead to leaking, poor performance, and excess material waste.

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Product Uses Continued

3M™ OEM Match Sprayable Tip 1K is designed as a one-time use item. Do not attempt to reuse tip as remnants left behind could cause problems for the tip, the material, the cartridge, or applicator when attempting to reuse.

3M™ OEM Match Sprayable Tip 1K is recommended to be used with 3M™ Pneumatic Applicators designed for aluminum cartridges. Manual applicators will not work with the 3M™ OEM Match Sprayable Tip 1K.

Directions for Use

PRODUCT PREPARATION:

1. Do not use damaged cartridges.
2. Remove seal from bottom of cartridge.
3. Puncture the seal at the outlet side of cartridge. Do not damage threads on cartridge.
4. Extrude a small amount of product to break the seal on plunger.
5. Install cartridge into applicator following applicator instructions for cartridge installation.
6. Install 3M™ OEM Match Sprayable Tip 1K to the cartridge until its firmly attached.
7. Install 3M™ OEM Match Sprayable Air Supply Kit to the applicator air fitting.
8. Install end of the air supply hose to the 3M™ OEM Match Sprayable Nozzle air inlet on the nozzle.
9. Adjust pattern and texture on a disposable sheet by adjusting regulator on applicator for fluid control, and valve on air supply attachment for fan pattern. Note the settings. Close valve on air supply attachment.

GENERAL REPAIR PROCESS (On vehicle):

1. Apply 2K epoxy or 2K urethane primer to all bare metal surfaces and allow to cure following TDS for products being used.
2. Follow steps for **Product Preparation**.
3. With the valve on air supply attachment closed, apply seam sealer to vehicle and panels requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
4. On a disposable sheet or panel, open the valve on air supply attachment to the previous noted position and test the pattern to ensure it meets replication pattern desired.
5. After testing the nozzle pattern, install seam sealer using the 3M™ OEM Match Sprayable Tip 1K to repair areas requiring OEM replication.
6. Once complete, close valve on air supply attachment and disconnect supplied air.

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Directions for Use Continued

7. Once the application is complete, finish by completing any tooling required to replicate the original look and appearance in the repair area. Make sure any gaps or voids are filled to prevent dirt or moisture from infiltrating the seal sealer.
8. For difficult applications such as overhead, vertical, or tight corners, and curves, and tight spaces that don't allow access with the applicator, refer to "Off vehicle application" directions to replicate desired finish.
9. Leave the 3M™ OEM Match Sprayable Tip 1K installed on the cartridge to store it. If removal is necessary, install 3M™ Nozzle PN 8187 and dispense material to prevent material from curing in cartridge. Leave nozzle on cartridge.
10. Discard 3M™ OEM Match Sprayable Tip 1K in proper waste stream in accordance with local regulations.
11. Follow recommendations on material TDS or cartridge label for paint times before top coating.

GENERAL REPAIR PROCESS (Off vehicle)

1. Apply 2K epoxy or 2K urethane primer to all bare metal surfaces and allow to cure following TDS for products being used.
2. On a flat bench top lay out strips of packaging tape.
3. Follow steps for **Product Preparation**.
4. On a disposable mixing sheet or panel, open the air supply attachment valve while dispensing material until desired pattern or texture is achieved. Adjust as needed.
5. With desired replication achieved, apply beads onto clean packaging tape free of any dirt or debris. If the final application requires tight curves or transitions, lay material out in these forms on the packaging tape.
6. Leave the 3M™ OEM Match Sprayable Tip 1K on the cartridge to store it. If removal is necessary, install 3M™ Nozzle PN 8187 and dispense material to prevent material from curing in cartridge. Leave nozzle on cartridge.
7. Discard 3M™ OEM Match Sprayable Tip 1K in proper waste stream in accordance with local regulations.
8. Allow material to cure. Do not remove beads from tape until you are ready to install on the vehicle.
9. Prior to installing beads onto vehicle, remove from packaging tape and dry fit in the locations to be applied. Trim beads if necessary. Lay on clean surface with the backside of bead facing up.

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Directions for Use Continued

10. When ready to install premade beads onto the vehicle, prepare a cartridge of the same material following the **Product Preparation** steps. Apply seam sealer to the panels on the vehicle requiring seam sealer, and tool with a brush or other tools to seal any gaps or voids. Wet out the entire back side of the premade beads with the same material the bead was made from using a brush or other tool.
11. With both sides wet, install bead onto vehicle and press firmly into place to ensure wet material on the vehicle side and wet material on the beads side is free of gaps and voids. In some cases, beads will need to be held in place until material begins to cure.
12. After the material is cured, check for any large gaps or voids. If any exist, apply material and tool to fill the areas with gaps or voids.
13. After applying the bead, finish by tooling material to replicate any brush or tooling marks in the repair area and allow to cure following the product recommendations.
14. Follow recommendations on material TDS or cartridge label for paint times before top coating.

Materials and Accessories

3M™ Pneumatic Applicators

- 39000 3M™ Single Component Applicator with Regulator
- 38373 3M™ Single Component Applicator with Regulator

3M™ 1K Products

- 08374 3M™ MSP Sprayable Seam Sealer

3M™ Accessories

- 33999 3M™ OEM Match Air Supply Kit

Storage and Handling

Store in packaging until ready to use.

Product does not have an expiration date.

Product is NOT reusable.

Precautionary Information

Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOCs) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area.

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