



**LETTRE DE SERVICE  
SERVICE LETTER**

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**RECOMMENDED SEALERS AND ADHESIVES FOR COLLISION AND BODY REPAIRS**

This Service Letter provides information of recommended sealers and adhesives to be used for collision and body repairs.

**NOTE:**

- 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.
- Parts should be ordered directly from vendors.

**Definition**

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

<b>Seam Sealer Terminology</b>	
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

<b>Type</b>	
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

**Panel Adhesive**

<b>Application: Standard Panel Adhesive (slow and medium)</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8115	E	90 min
	8116	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

<b>Application: Door Skin Adhesive (medium)</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8115	E	90 min
	8229	E	60 min
Fusor	108B	A	45 min
SEM	39337	E	30 min
Kent	P10581	E	60 min

<b>Application: Impact Resistant Structural Adhesive (slow)</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	7333	E	60 min
Fusor	2098	E	90 min
SEM	39757	E	60 min
Kent	1523691	E	60 min

## General Purpose Adhesives

<b>Application: 20 Second</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	4247	U	20 sec
Fusor	N/A	N/A	N/A
SEM	40207	U	20 sec
Kent	KT13632	U	20 sec
	KT13629	U	20 sec

<b>Application: 50 Second</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	4240	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	50 sec
Kent	KT13630	U	50 sec

<b>Application: 3 Minute</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8223	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	8368	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	8365	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	8362	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	8367	U	N/A
Fusor	803DTM	S	N/A
SEM	29392	S	N/A
Kent	P10556	U	N/A
	KT13979	M	N/A

<b>Color: Clear</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	N/A	N/A	N/A
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 (Spray-able)

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

<b>Color: Beige</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
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

<b>Color: Grey</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8374	M	N/A
Fusor	804HD	S	N/A
SEM	29372	M	N/A
Kent	P13746	M	N/A
	1232171	M	N/A

<b>Color: Black</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	N/A	N/A	N/A
Fusor	805HD	S	N/A
SEM	29392	M	N/A
Kent	KT12592	M	N/A
	1232172	M	N/A

**2K Seam Sealers**

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

<b>Color: Beige</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8310	E	N/A
Fusor	019	A	6 min
	129	E	5 min
SEM	39477	E	10 min
Kent	P10491	E	8 min

<b>Color: Rose</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
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

<b>Color: Grey</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	5887	E	N/A
Fusor	N/A	N/A	N/A
SEM	39377	E	10 min
Kent	N/A	N/A	N/A

<b>Color: Black</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8305	E	N/A
Fusor	N/A	N/A	N/A
SEM	40377	E	10 min
Kent	KT14999	E	12 min

<b>Color: Blue</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
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**

<b>Application: Thin Viscosity (self-leveling)</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8307	E	8 min
Fusor	122EZ	E	8 min
SEM	39387	E	10 min
Kent	P10486	E	10 min

<b>Application: Thick Viscosity (controlled flow)</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8329	U	3 min
	8323	U	10 min
Fusor	129	E	5 min
SEM	39777	E	10 min
	39477	E	10 min
Kent	KT12401	E	10 min

### **Plastic Repair**

<b>Application: Cosmetic Plastic Repair</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	5887	E	5 min
Fusor	114	N/A	1 min
	132	N/A	1 min
SEM	39847	E	7 min
Kent	1429183	E	7 min

<b>Application: Structural Plastic Repair - All</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
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



<b>Application: Structural Plastic Repair - Semi Rigid</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	4240	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

<b>Application: Structural Plastic Repair - Rigid</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	5885	E	8 min
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

<b>Application: Plastic Tab Repair</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	4247	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

<b>Application: Structural Plastic Repair - Flexible</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
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**

<b>Application: Weld-Through Primer</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	5917	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

<b>Application: Cavity Wax</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8852	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

<b>Application: Cavity Wax Wand Kit</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8851	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

<b>Application: NVH, Panel Vibration for Replacement</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8463	U	40 sec
Fusor	121	U	10 sec
	231	U	60 min
SEM	39977	E/U	60 min
Kent	KT13523	E/U	60 min

<b>Application: NVH, Panel Vibration for Reattachment</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	4274	U	60 min
Fusor	121	U	10 sec
	231	U	60 min
SEM	39977	E/U	60 min
Kent	KT13523	E/U	60 min

<b>Application: Flexible Foam</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8463	U	40 sec
Fusor	121	U	10 sec
SEM	39357	U	15 sec
Kent	P10601	U	30 sec
	P10630	U	30 sec

<b>Application: Rigid Foam</b>			
<b>Supplier</b>	<b>Part Number</b>	<b>Type</b>	<b>Working Time</b>
3M	8458	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	8308	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	8840	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