

**LETTRE DE SERVICE**  
 **HONDA**  
**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 Honda'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

| <b>Application: Heavy bodied LASD</b> |                    |             |                     |
|---------------------------------------|--------------------|-------------|---------------------|
| <b>Supplier</b>                       | <b>Part Number</b> | <b>Type</b> | <b>Working Time</b> |
| 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

| <b>Application: Peel and Stick</b> |  |             |                     |
|------------------------------------|--|-------------|---------------------|
| <b>Supplier</b>                    | <b>Part Number</b>                         | <b>Type</b> | <b>Working Time</b> |
| Acura                              | 72846-282-305AH<br>(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                 |

| <b>Application: Aluminum Backed</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                                | KT13306            | N/A         | N/A                 |