



NVH Dampening Material

04274

Technical Data

February 2020

3M Part Numbers	3M Part Descriptor
04274	3M™ NVH Dampening Material

Product Description 3M™NVH (noise, vibration and harshness) Dampening Material is a heavy bodied two – part urethane primarily used to reduce noise or vibration resulting in unwanted noise associated with metallic assemblies such as automotive bodies. Commonly applied between outer sheet metal skins and inner structure, or inside floor pans as a single sided application. This material may be applied to bare metal and welded through with squeeze type resistance spot welding equipment (prior to work time expiration).

- Features**
- Designed for professional aftermarket collision repair use
 - Replaces OEM NVH Material
 - 60-minute Work Time
 - Direct to Metal Application

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.

Container	200mL Duo Syringe Cartridge	
Base	Urethane	Curative
Color	Black	Amber
Flash Point	290°F (143°C)	
Solids Content (Approx.)	98%	
Consistency	Viscous paste (mixed)	
Service Temperature	-20°F to 180°F (-20°C to 82°C)	

Typical Performance Properties The following times have been determined with ambient air temperature and substrate temperature @ 73°F (23°C) and are considered typical values.

WORK TIME:
60 minutes

CLAMP TIME:
N/A

CURE TIME:
24 hours
1 hour @ 160°F

3M™ NVH Dampening Material

04274

Product Uses

Generally used between automotive body panel skins and inner structure members such as, door skin/intrusion beam. 3M™ NVH Dampening Material may also be used as a sealant when weld sealing is desired using STRSW equipment. 3M™ NVH Dampening Material may be applied to properly prepared bare metal or primer/E-coat/paint coated surfaces. 3M™ NVH Dampening Material may be painted with automotive type coatings.

Use with the following accessories:

- 3M™ Manual Applicator (PN 08571 or PN 08117)
- 3M™ Pneumatic Applicator (PN 09930)
- 3M™ Static Mix Nozzle (PN 08193, 6-bag)
- 3M™ Static Mix Nozzle (PN 08194, 50-box)

For Industrial/Occupational Use Only. Not for Consumer Sale or Use.

Performance Properties

The following times have been determined with ambient air temperature and substrate temperature @ 73°F (23°C) and are considered typical values.

WORK TIME:

60 minutes

CLAMP TIME:

N/A

SAND TIME:

N/A

CURE TIME:

24 hours

Directions for Use

CARTRIDGE PREPARATION

1. Insert the cartridge into the applicator and remove the collar and plug. Discard a small amount of material to a disposable surface and reinstall the nozzle and collar.
2. Dispense a small amount of material through the mixing nozzle on to a disposable surface, preparation is now complete.

3M™ NVH Dampening Material

04274

Directions for Use, cont.

WELD THROUGH

NOTE: For weld through operations (prior to welding the panel(s) make test welds on scrap parts to assure proper welding machine settings).

1. Remove surface contamination on all sides of weld flanges using an abrasive (bare metal must be exposed).
2. Apply NVH material to all bare metal between weld flanges (brush or spread to cover all bare metal).
3. Apply a ¼ inch (6mm) bead to one side of the joint to ensure “squeeze out”.
4. Mate parts together and clamp in place.
5. Be sure to use a shunt clamp and start welds near the clamp.
6. Begin squeeze type resistance spot welding process immediately and complete prior to work time expiration.

TRUNK FLOOR (LASD REPLACEMENT) OR SOUND DEADENING PAD

1. Remove all loose/damaged original material.
2. Blow off and clean the surface with a VOC compliant surface cleaner to ensure proper adhesion.
3. If required mask the outline of the original application to produce a good quality appearance of the repair.
4. Apply the NVH material to the prepared area tool as necessary using a spreader, or notched spreader to match the original appearance.
5. Remove the masking tape and allow to cure for 24 hours before placing into service.

STANDARD SOUND DEADENER APPLICATION

1. When possible keep OEM NVH material in place to maintain proper spacing between panel structure and skin.
2. Apply NVH material to previous OEM locations prior to final installation of outer sheet metal, consider the 60-minute working time of. (Note) 3M™ NVH Dampening Material during your repair planning prior to application.

3M™ NVH Dampening Material

04274

Applications Sound deadening and vibration reduction material for sheet metal application such as automotive body repairs, such as door skins to intrusion beam, trunk floors, roof bow to skin.

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

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.

Technical Information The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and 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. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy and Disclaimer Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



Automotive Aftermarket Division
3M Center, Building 0223-6-S-07
St. Paul, MN 55144-1000
1-877-666-2277 (1-877-MMM-CARS)
3MCollision.com

3M is a trademarks of 3M Company.
Printed in U.S.A. © 3M 2020 All rights reserved (02/2020)