



OEM Match Adjustable Ripple Tip

33995

Technical Data

February 2022

| 3M Part Number | 3M Part Descriptor |
|----------------|-------------------------------------|
| 33995 | 3M™ OEM Match Adjustable Ripple Tip |

Product Description 3M™ OEM Match Adjustable Ripple Tip is the solution for 3M™ 2-Part heavy bodied products to help replicate the original look and appearance of seam sealer applied at the factory.

Features

- Nozzle rotation enables variable width bead patterns
- Recommended for use with 3M™ Heavy-Bodied Seam Sealer
- Easy attachment to 3M™ Static Mixing Nozzles (PN08193, PN08194)

Typical physical / performance Properties 3M™ OEM Match Adjustable Ripple Tip 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 ABS Plastic.

Product Uses 3M™ OEM Match Adjustable Ripple Tip is designed to help technicians replicate robotically applied seam sealers at the factory. Typical areas these beads can be found, but are not limited to, trunk floors, rear body panels, rear frame rails, strut towers, front frame rails and more.

The tip is designed to work with 3M™ Heavy-Bodied Seam Sealer and 3M™ Bare Metal Seam Sealer. 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 Adjustable Ripple Tip 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 Adjustable Ripple Tip make sure it is firmly applied to 3M™ Static Mixing Nozzle. Use of static mixing nozzles other than 3M™ could lead to poor performance and excess material waste.

3M™ OEM Match Adjustable Ripple Tip is designed as a one-time use. 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.

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Product uses cont.

3M™ OEM Match Adjustable Ripple Tip is recommended to be used with 3M™ Performance Pneumatic Applicator (PN09930). 3M™ Performance Manual Applicator (PN08117) could be used however the pneumatic applicator will provide better final appearance with less effort and time to replicate the OEM appearance desired.

Directions for use**PRODUCT PREPARATION:**

1. Insert cartridge into applicator chosen.
2. Remove retaining collar and plug from end of cartridge. Discard plug save retaining collar.
3. Extrude a small amount of product until both parts A and B dispense equally.
4. Attach 3M™ Mixing Nozzle (PN 08193 or 08194) to cartridge and lock in place with retaining collar.
5. Dispense a 2"- 4" bead of material and discard.

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. Apply Seam Sealer to vehicle and panels requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
3. Remove static mixing nozzle and equalize cartridge, install new static nozzle (follow Product Preparation found in first section of directions for use) and dispense 2"-4" bead of material. Install 3M™ OEM Match Adjustable Ripple Tip onto static mixing nozzle and dispense material onto disposable mixing sheet.
4. When material is flowing rotate tip to adjust until the desired bead for the application require. Keep tip indicator on front cap facing up, this ensures that the open slot is parallel to the surface material is being applied to. To rotate applicator in a comfortable position while dispensing loosen retaining ring on static mixing nozzle. Rotate static mixing nozzle until the tip indicator is facing up and the applicator is in desired position for application, tighten retaining ring and continue. Other adjustments could include adjusting air pressure on applicator, angle applicator is being held and speed you are moving while applying. Always test off vehicle before applying directly to vehicle to achieve desired end appearance.
5. Once tip is set to desired appearance apply to vehicle over previously tooled seam sealer. For difficult applications such as overhead, vertical, or tight corners and curves refer to "Off vehicle application" directions to replicate desired finish.
6. Once 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.

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Directions for use cont.

7. Remove 3M™ OEM Match Adjustable Ripple Nozzle from static mixing nozzle once application is complete. If material cure prior to removing the tip use a cutting tool to remove the tip to avoid damaging retaining ring on next use.
8. Discard 3M™ OEM Match Adjustable Ripple Tip in proper waste stream in accordance with local regulations.
9. 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. Install new static nozzle (follow Product Preparation found in first section of directions for use) on the cartridge and dispense 2"-4" bead of material. Install 3M™ OEM Match Adjustable Ripple Tip onto static mixing nozzle and dispense material onto disposable mixing sheet.
4. When material is flowing rotate tip to adjust until the desired bead for the application require. Keep tip indicator on front cap facing up, perpendicular to surface material is being applied. To rotate applicator in a comfortable position while dispensing loosen retaining ring on static mixing nozzle. Rotate static mixing nozzle until the tip indicator is facing up, tighten retaining ring and continue. Other adjustments could include adjusting air pressure on applicator, angle applicator is being held and speed you are moving while applying. Always test before building beads to be applied to the vehicle later.
5. With desired replication achieved apply beads onto clean packaging tape free of any dirt or debris. If final application requires tight curves or transitions lay material out in these forms on the packaging tape.
6. Remove 3M™ OEM Match Adjustable Ripple Tip from static mixing nozzle once application is complete. If material cure prior to removing the tip use a cutting tool to remove the tip to avoid damaging retaining ring on next use.
7. Allow material to cure. Do not remove beads from tape until you are ready to install on the vehicle.
8. 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 backside of bead facing up.
9. When ready to install premade beads onto the vehicle, equalize a cartridge of the same material and install new static mixing nozzle. Apply seam sealer to panels on the vehicle requiring seam sealer and tool with a brush or other tool to seal any gaps or voids.
10. Wet out the back side of the premade beads with the same material the bead was made from using a brush or spreader.

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- Directions for use cont.**
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 material is cure 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.

Accessories

- 3M™ Performance Pneumatic Applicator PN09930
- 3M™ Performance Applicator PN08117
- 3M™ Static Mixing Nozzle PN08194, 50 Nozzles/Carton
- 3M™ Static Mixing Nozzle PN08193, 6 Nozzles/Bag

Storage and Handling

Store in packaging until ready to use. Product does not have an expiration date.

After use, Remove the tip from the static mixing nozzle, leave the static mix nozzle in place to seal the cartridge.

- ONLY use 3M Static Mix Nozzles with 3M™ cartridges.
- Keep static mix nozzles stored in their original container away from dust, debris and other contaminates.

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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