



# DUAL-MIX™ SEAM SEALER

## TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

### DESCRIPTION

Dual-Mix Seam Sealer is a medium viscosity, two-component epoxy sealer for use on interior or exterior seams, joints and voids.

### FEATURES

- Dual-Mix™ Forever Warranty
- OEM recommended
- Direct to metal
- Paintable immediately\*
- Will not shrink, harden or crack
- Non-sag formula duplicates OEM sealers
- Optimized viscosity for softened or rolled edges
- Fast cure increases production
- Sprayable for additional versatility

### SUITABLE SUBSTRATES

- Bare Metal
- OEM Finish
- Epoxy Primer
- DTM Urethane Primer

### TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
39377	Dual-Mix Seam Sealer	Gray	7 oz. Cartridge
39477	Dual-Mix Seam Sealer	Beige	7 oz. Cartridge

<b>Working time:</b>	10 minutes @ 70°F (21°C)
<b>Set time:</b>	15 minutes @ 70°F (21°C)
<b>Top Coat time</b> with most solvent-based coatings:	0 minutes @ 70°F (21°C)
<b>Top Coat time</b> with most waterborne coatings:	15 minutes @ 70°F (21°C)
<b>Cure time:</b>	1 hour @ 70°F (21°C)

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Always wear OSHA required (PPE) Personal Protection Equipment as outlined on the SDS and product label to ensure your safety.



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## HANDLING AND APPLICATION

### PREPARATION:

**Note:** Prior to applying **Dual-Mix™ Seam Sealer** vehicle temperature should be 70°F (21°C) for at least one hour.

1. Clean joints and seams thoroughly with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Sand primed surface with P400 grit sandpaper or scuff with a gray scuff pad. Sand bare metal surface with P80 grit sandpaper.
3. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.
4. Tack clean to remove lint and dust.

**Dual-Mix Seam Sealer** may be applied directly to properly prepped bare metal or primed surfaces. However; if the area will be subjected to any flexing or twisting, including certain vehicle manufacturer's roof skins, prime the area first with a quality, two-component urethane or epoxy primer such as **World Class™ DTM Primer** before applying **Dual-Mix Seam Sealer**. If in doubt, prime. Allow primer to fully cure before applying **Dual-Mix Seam Sealer**.

**Note:** **Dual-Mix Seam Sealer** should not be used directly over acid based self-etching primers or vice versa. This application procedure can cause cracking and blistering of the undercoat and top coat.

**Dual-Mix Seam Sealer** is paintable immediately with most solvent-based coatings, however, always test for compatibility.

### MIXING:

Place cartridge into the **Universal Manual Applicator** or **Universal Pneumatic Applicator**. To remove cap, insert flat head screwdriver into slot and pry upward.

**Note:** Prior to installing **Static Mixer**, equalize cartridge by dispensing product until both parts flow equally. Install **Static Mixer**. Cut tip to desired application size. Hold applicator upright until product is dispensed into mixer. Dispense a test bead to ensure proper mix. For cap replacement, match circles and squares, then snap back into place.



### STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixers	7 oz. cartridge	6 pack
70012	Integral Nut Square Static Mixers	7 oz. cartridge	50 pack

### APPLICATION:

1. Apply **Dual-Mix Seam Sealer** into joint or seam. Work in or finish with gloved finger, putty knife or spreader.
2. While product is still wet, remove excess by wiping with a small amount of solvent compliant with the VOC regulations in your area.
3. **Dual-Mix Seam Sealer** can be painted immediately with most solvent-based coatings, or up to 24 hours without scuffing. If in doubt, scuff with a gray pad prior to painting.



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## SPRAYING:

The **Quick Spray System** easily attaches to the **Universal Pneumatic Applicator** and allows users to duplicate OEM seam sealer textures while utilizing the two-component technology of **SEM** seam sealers.

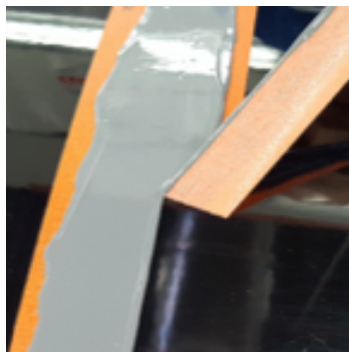
**Versa-Tips** snap onto the end of the **Static Mixer** and allow the user to easily duplicate OEM seam sealer ribbons. **Versa-Tips** contain six tips that may be cut to 0.5", 0.75", 1", 1.25" and 1.5" ribbon tip.

## DUPLICATING SOFTENED OR ROLLED EDGES:

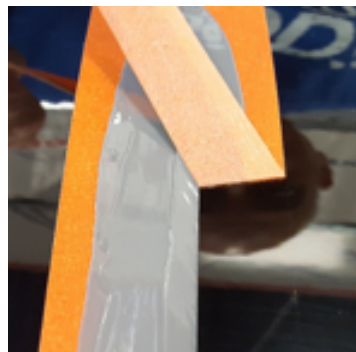
**Dual-Mix Seam Sealer** can be used to duplicate the OEM rolled or softened edge sometimes seen on door skins and other seams of a vehicle. Product and vehicle temperature must be at room temperature prior to application.

Use masking tape to tape off the desired channel width prior to dispensing Dual-Mix Seam Sealer. pull tape away from the seam at a 45 – 90° angle immediately after dispensing to allow seam sealer to roll or soften the edge.

**Note:** Angle and direction of masking tape pull will provide varying edges. Pulling away from the seam sealer produces a rolled or softened edge, while pulling toward the seamer creates a beveled edge. Pull tape directly back onto itself creates a squared edge. (See images below.)



45° Pull Away



45° Pull Towards



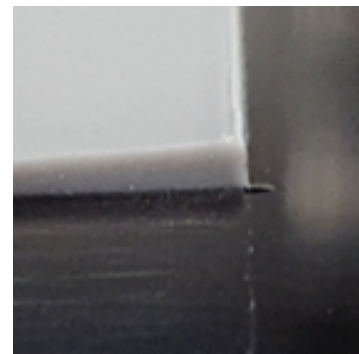
Pull Onto Itself



Rolled or softened



Beveled



Squared



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## STORAGE:

**Dual-Mix™ Seam Sealer** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Dual-Mix Seam Sealer** is 2 years when stored under normal conditions.

## RELATED PRODUCTS:

Part:	Product Name:	Size:
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
50121	World Class™ DTM Primer	Gallon
50124	World Class DTM Primer	Quart
50134	World Class DTM Primer Activator	Cone Quart
50136	World Class DTM Primer Activator	Half Pint
70011	Integral Nut Static Mixers	6 Pack
70012	Integral Nut Static Mixers	50 Pack
70039	Universal Pneumatic Applicator	Each
70070	Versa-Tip	6 Pack
70100	Quick Spray System Starter Kit	Each
71119	Universal Manual Applicator	Each
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



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### **Technical Consultation Service**

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

#### **Disclaimer:**

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.