

DESCRIPTION

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

FEATURES

- **Dual-Mix** Forever Warranty
- OEM recommended
- Direct to metal
- Paintable immediately with most solvent-based coatings
- Correct color minimizes post-inspection liability
- Non-sag formula holds tooling marks
- Fast cure increases production
- Remains flexible without shrinking or cracking
- Sprayable for additional versatility
- Ideal for use with **NEW ORBiT™** to duplicate OE ripple bead (see pg. 3)

SUITABLE SUBSTRATES

PROPERLY PREPPED (SEE PREPARATION SECTION)

- Bare metal
- OEM finish
- Primed surfaces

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
40177	Dual-Mix Heavy Bodied Seam Sealer	Gray	7 oz. Cartridge
40277	Dual-Mix Heavy Bodied Seam Sealer	Beige	7 oz. Cartridge
40377	Dual-Mix Heavy Bodied Seam Sealer	Black	7 oz. Cartridge
40477	Dual-Mix Heavy Bodied Seam Sealer	White	7 oz. Cartridge

Working time: 10 minutes @ 70°F (21°C)

Set time: 15 minutes @ 70°F (21°C)

Topcoat time with most solvent-based coatings: 0 minutes @ 70°F (21°C)

Topcoat time with most waterborne coatings: 15 minutes @ 70°F (21°C)

Cure time: 1 hour @ 70°F (21°C)

Always consult local regulatory for VOC compliance.



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

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



HANDLING AND APPLICATION

PREPARATION:

Note: Prior to applying **Dual-Mix™ Heavy Bodied 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 Heavy Bodied 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 manufacturers' 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 Heavy Bodied Seam Sealer**. If in doubt, prime. Allow primer to fully cure before applying **Dual-Mix Heavy Bodied Seam Sealer**.

Note: **Dual-Mix Heavy Bodied 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 Heavy Bodied 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



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APPLICATION:

BEADING:

1. Apply **Dual-Mix™ Heavy Bodied Seam Sealer** into joint or seam. Work in or finish with gloved finger, putty knife, acid brush 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 Heavy Bodied 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.

Note: SEM provides multiple customized tips and nozzles to easily duplicate specialty OE seam sealer beads.

ORBIT™, the OE Ripple Bead Installation Tip, comes with a 2K adapter and presses onto the end of the **Static Mixer**, allowing the user to easily duplicate OE seam sealer ripple beads. **ORBIT** is optimized for use with **Dual-Mix Heavy Bodied Seam Sealer** over primed surfaces.

Note: For maximum corrosion protection on a direct to metal application, apply the ripple bead over a wetbed of **Dual-Mix Heavy Bodied Seam Sealer**. This can be done with a "wet-on-wet" application or by creating the ripple bead on a flat surface by using boxing tape. After the ripple bead is dry, it can be removed from the boxing tape, scuffed with a red scuff pad and applied to the wetbed of **Dual-Mix Heavy Bodied Seam Sealer**.

Doorskin Nozzles connect to 2K cartridges using the **ORBIT** 2K adapter and are designed with a flanged tip to quickly replicate the appearance of offset door skin seam sealer beads.

Extrusion Nozzles connect to 2K cartridges using the **ORBIT** 2K adapter and are designed to create various beads and offsets.

Versa-Tips press onto the end of the **Static Mixer** and allow the user to easily duplicate flat OEM seam sealer ribbons. **Versa-Tips** are graduated and notched for easy trimming to cut into 0.5", 0.75", 1", 1.25" and 1.5" ribbon tips.

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.



STORAGE:

Dual-Mix Heavy Bodied 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 Heavy Bodied Seam Sealer** is 2 years when stored under



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normal conditions.

RELATED PRODUCTS:

Part:	Product Name:	Size:
29312	Doorskin Nozzles	6 pack
29322	Extrusion Nozzles	6 pack
29412	ORBiT OE Ripple Bead Installation Tip	6 pack
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

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.