



DUAL-MIX™ DOOR SKIN & SMC ADHESIVE

TECHNICAL DATA SHEET

DESCRIPTION

Dual-Mix Door Skin & SMC Adhesive is a two-component epoxy that quickly bonds any combination of steel, aluminum, fiberglass and SMC.

FEATURES

- **Dual-Mix™** Forever Warranty
- OEM recommended
- Non-sag formulation
- Excellent corrosion protection
- Bonds multiple substrates
- Extended two-year shelf life.

SUITABLE SUBSTRATES

- Steel
- Aluminum
- Fiberglass
- SMC

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
39337	Dual-Mix Door Skin & SMC Adhesive	Black	7 oz. cartridge
Working time:	30 minutes @ 70°F (21°C)		
Set time:	2 hours @ 70°F (21°C)		
Cure time:	24 hours @ 70°F (21°C)		
Heat cure time:	1 hour @ 120° – 140°F (49°-60°C)		
Lap shear @ 70°F (21°C) (psi) on steel:	2300+ ASTM D 1002		
Coverage:	115" @ 3/8" diameter bead		

Check local VOC regulations to ensure compliance of all products in your area. Always reference OEM recommended procedures prior to starting any repair.

HANDLING AND APPLICATION



PREPARATION:

Bonding surfaces should be clean, dry and free of contamination. Dry-fit all panels before applying adhesive to ensure proper alignment and clearance.



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STEEL AND ALUMINUM:

1. Clean surfaces to be bonded with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Grind each surface with P36 grit grinding disc at low speed to maintain grinding marks.
Do not grind at high speed.
3. Blow off and re-clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner**, if necessary.

Note: Always use lint-free towels when cleaning surfaces to avoid lint and particle contamination.

SMC AND FIBERGLASS:

1. Clean surfaces to be bonded with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Grind each bonding surface with P36 grit grinding disc at lower speed to maintain grinding marks.
Do not grind at high speed.
3. Blow off and re-clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner**, if necessary. Panel must be completely dry before applying adhesive. Do not saturate exposed fibers.

Note: Always use lint-free towels when cleaning surfaces to avoid lint and particle contamination.

E-COATED DOOR SKINS:

1. Clean e-coat with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Scuff e-coated surface with gray scuff pad.
3. Blow off and re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

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 square, 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



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



APPLICATION:

Apply product to both bonding surfaces and tool with a spreader or acid brush, covering all exposed bare metal. Use enough material to completely fill the joint when parts are clamped. Always follow step by step directions from the OEM and the instructions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time.

Note: **Dual-Mix Door Skin & SMC Adhesive** is intended for full panel replacement only. Partial panel replacements may show a bond line or halo due to techniques in workmanship and are not warranted.

IMPORTANT:

Bonding applications are intended for secondary (cosmetic) panels only. Structural components should never be bonded unless specified by the OEM.

DAMPENING MATERIAL:

When replacing door skins, **Dual-Mix™ Flexible Urethane Foam** and **Panel Vibration Control Material** can be used to replace the OEM dampening material found between the panels and the intrusion beam(s). Refer to product information for proper selection.

CURING:

Parts should remain undisturbed between the material's working time and set time. Temperatures below 55°F (13°C) will slow the cure; above 85°F (29°C) will accelerate cure rate. To enhance cure time, heat to 120 – 140°F (49 – 60°C) for 1 hour. At 70°F (21°C), **Door Skin & SMC Adhesive** sets in 2 hours and fully cures in 24 hours. Clamps can be removed after 2 hours at 70°F (21°C). Do not over clamp.

WELDING:

Prior to welding, apply **Weld-Thru Primer** or **Copperweld™ Primer** on any areas where adhesive will not be present. Allow primer to fully dry.



CLEAN UP:

It is important to clean up excess adhesive from the work area and application equipment before it cures. Use appropriate cleaning materials compliant with VOC regulations in your area. Keep containers tightly closed after use. **Dual-Mix Door Skin & SMC Adhesive** is flammable when exposed.



STORAGE:

Dual-Mix Door Skin & SMC Adhesive should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Dual-Mix Door Skin & SMC Adhesive** is 2 years when stored at 40 – 77°F (4 – 25°C). Exposure above room temperature will reduce shelf life.



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

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
39357	Dual-Mix™ Flexible Urethane Foam	7 oz .Cartridge
39783	Weld-Thru Primer	16 oz. Aerosol
39977	Dual-Mix™ Panel Vibration Control Material	7 oz. Cartridge
40783	Copperweld™ Primer	20 oz. Aerosol
40786	Brushable Copperweld™ Primer	Half Pint
70011	Integral Nut Square Static Mixer	6 Pack
70012	Integral Nut Square Static Mixer	50 Pack
70039	Universal Pneumatic Applicator	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 is secondary to the OEM repair guidelines. 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.