DUAL-MIX™ SEAM SEALER
TECHNICAL DATA SHEET

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

SUITSABLE SUBSTRATES

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

TYPICAL PROPERTIES

<table>
<thead>
<tr>
<th>Part:</th>
<th>Product Name:</th>
<th>Color:</th>
<th>Container:</th>
</tr>
</thead>
<tbody>
<tr>
<td>39377</td>
<td>Dual-Mix Seam Sealer</td>
<td>Gray</td>
<td>7 oz. Cartridge</td>
</tr>
<tr>
<td>39477</td>
<td>Dual-Mix Seam Sealer</td>
<td>Beige</td>
<td>7 oz. Cartridge</td>
</tr>
</tbody>
</table>

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

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™ 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:

<table>
<thead>
<tr>
<th>Part</th>
<th>Product Name:</th>
<th>For:</th>
<th>Container:</th>
</tr>
</thead>
<tbody>
<tr>
<td>70011</td>
<td>Integral Nut Square Static Mixers</td>
<td>7 oz. cartridge</td>
<td>6 pack</td>
</tr>
<tr>
<td>70012</td>
<td>Integral Nut Square Static Mixers</td>
<td>7 oz. cartridge</td>
<td>50 pack</td>
</tr>
</tbody>
</table>

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.
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.)

![Images showing different edge effects](image1.png)

- **45° Pull Away**
- **45° Pull Towards**
- **Pull Onto Itself**

![Images showing different edge effects](image2.png)

- **Rolled or softened**
- **Beveled**
- **Squared**
Check local VOC regulations to ensure compliance of all products in your area.

**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:**

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