



DUAL-MIX™ HIGH-BUILD SELF LEVELING SEAM SEALER

TECHNICAL DATA SHEET



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

DESCRIPTION

Dual-Mix High-Build Self Leveling Seam Sealer is a two-component, controlled flow epoxy ideal for use on roof seams, drip rails and trunk seams.

FEATURES

- **Dual-Mix** Forever Warranty
- OEM recommended
- Direct to metal on non-flexing roof skins
- Paintable in 15 minutes
- Will not shrink, harden or crack
- Permanently flexible

SUITABLE SUBSTRATES

- Bare metal
- OEM Finish
- Epoxy Primer
- Urethane Primer

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
39777	High-Build Self Leveling Seam Sealer	Gray	7 oz. Cartridge

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

Set Time: 15 minutes @ 70°F (21°C)

Top Coat Time: 15 minutes @ 70°F (21°C)

Cure Time: 1 hour @ 70°F (21°C)

HANDLING AND APPLICATION



PREPARATION:

Note: Prior to applying **High-Build Self Leveling Seam Sealer** vehicle temperature should be 70°F (21°C) for at least one hour. Make certain vehicle is level.

- 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 tack clean to remove lint and dust.



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4. Re-clean with SEM Solve or XXX Universal Surface Cleaner.

High-Build Self Leveling Seam Sealer may be applied directly to bare sanded metal or primed surfaces. However, if the area will be subjected to any flexing or twisting, including roof skins and drip rails, prime the area first with a quality, two-component urethane or epoxy primer such as **World Class™ DTM Primer** before applying **High-Build Self Leveling Seam Sealer**. If in doubt, prime. Primer must be fully cured and sanded before applying **High-Build Self Leveling Seam Sealer**.

Note: High-Build Self Leveling 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.

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. Use masking tape to form a dam at the forward end of the channel to prevent **High-Build Self Leveling Seam Sealer** from running out.
2. Dispense **High-Build Self Leveling Seam Sealer** in the center of the entire length of channel. **High-Build Self Leveling Seam Sealer** will flow out and self-level.

Note: A heat gun can be used immediately after application to remove any air bubbles that become entrapped. With a steady motion and low heat, sweep the heat gun across surface at a distance of 2" – 6".

3. While product is still wet, remove excess by wiping with a small amount of solvent compliant with the VOC regulations in your area.
4. Remove and cut away the tape with a razor knife. If necessary, sand or trim dammed end and contour to maintain required roof channel depth. **USE CAUTION NOT TO SEPARATE HIGH-BUILD SELF LEVELING SEAM SEALER FROM BASE OF CHANNEL.**
5. **High-Build Self Leveling Seam Sealer** should be ready to paint in 15 minutes.



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STORAGE:

High-Build Self Leveling Seam Sealer should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **High-Build Self Leveling 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

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.