



DUAL-MIX™ REPAIR MATERIAL GUIDE

ADHESIVES	PRODUCT	DESCRIPTION	PROPERTIES
	MULTI-PURPOSE PANEL ADHESIVE 39747	Two-component epoxy for panel bonding of steel, aluminum, SMC and fiberglass.	Working Time: 90 Min Set Time: 4 Hr Cure Time: 24 Hr Heat Cure Time: 1 Hr Resin Base: Epoxy
	DOOR SKIN & SMC ADHESIVE 39337	Two-component epoxy that quickly bonds any combination of steel, aluminum, fiberglass, and SMC.	Working Time: 30 Min Set Time: 2 Hr Cure Time: 24 Hr Heat Cure Time: 1 Hr Resin Base: Epoxy
	STRUCTURAL IMPACT RESISTANT ADHESIVE (SIRA) 39757	Two-component, epoxy-based adhesive for bonding structural and non-structural components where specified by the vehicle manufacturer.	Working Time: 1 Hr Set Time: 8 Hr Cure Time: 48 Hr Resin Base: Epoxy <i>Additional heat options are available on the Technical Data Sheet</i>
	WELD-BOND ADHESIVE 39537	Non-sag, two-component, acrylic adhesive system formulated to bond metal surfaces without the use of an external primer.	Working Time: 1 Hr Set Time: 3 Hr Cure Time: 24 Hr Heat Cure Time: 1 Hr Resin Base: Acrylic
	PATCH PANEL ADHESIVE 39897	Two-component, acrylic adhesive for quickly bonding metal panels without the use of an external primer.	Working Time: 10 Min Set Time: 20 Min Cure Time: 30 Min Heat Cure Time: 15 Min Resin Base: Acrylic
	QUICK SET 20 40207 (7 oz.) 40202 (1.7 oz.)	Very fast, two-component, opaque, urethane adhesive designed for bumper tab repair and bonding most small plastic, steel and aluminum parts.	Working Time: 15 Sec Set Time: 20 Sec Cure Time: 15 Min Resin Base: Urethane
	QUICK SET 50 40507 – Black (7 oz.) 40502 – Black (1.7 oz.) 40517 – Clear (7 oz.)	Two-component, general purpose, urethane adhesive with a 50 second set time designed for repair and bonding of most plastic, steel, aluminum, glass, SMC and fiberglass parts.	Working Time: 45 Sec Set Time: 50 Sec Cure Time: 15 Min Resin Base: Urethane
	QUICK SET 180 41807	Two-component, general purpose, urethane adhesive with a three minute working time designed for repairing and bonding most small to medium plastic, steel, aluminum, glass, SMC and fiberglass parts.	Working Time: 3 Min Set Time: 30 Min Cure Time: 24 Hr Resin Base: Urethane

PLASTIC REPAIR	PRODUCT	DESCRIPTION	PROPERTIES
	MULTI-PLASTIC REPAIR MATERIAL 39847	Two-component epoxy for fast repairs on virtually all plastic bumper covers.	Working Time: 7 Min Sand Time Air Dry: 15 Min Cure Time: 1 Hr
	PROBLEM PLASTIC REPAIR MATERIAL 39767	Two-component, epoxy-based filler for repairing olefin-based plastics and similar rigid and semi-rigid substrates.	Working Time: 5 Min Sand Time Air Dry: 15 Min Cure Time: 1 Hr
	RIGID PLASTIC REPAIR MATERIAL 40887	Two-component, fiber-enriched epoxy used for bonding and cosmetic repair of carbon fiber, SMC, Metton®, fiberglass and other rigid plastics. <small>*Metton is a registered trademark of Metton America, Inc.</small>	Working Time: 35 Min Set Time: 3 Hr Sand Time Air Dry: 3 Hr <i>Additional heat options are available on the Technical Data Sheet</i>

SEALERS	PRODUCT	DESCRIPTION	PROPERTIES
	MEDIUM BODIED SEAM SEALER 39377 – Gray 39477 – Beige	Medium viscosity, two-component, epoxy sealer for sealing interior or exterior seams, joints and voids. <i>SHFT Tip and 2K adapter included with Dual-Mix Medium Bodied Seam Sealer 39377 & 39477</i>	Working Time: 10 Min Set Time: 15 Min Top Coat Time: 0 Min* Cure Time: 1 Hr <small>* Paintable immediately with most solvent-based paint systems</small>
	HEAVY BODIED SEAM SEALER 40177 – Gray 40277 – Beige 40377 – Black 40477 – White	High viscosity, two-component epoxy for use on interior or exterior seams, joints and voids. <i>ORBIT Tip and 2K adapter included with Dual-Mix Heavy Bodied Seam Sealer 40177, 40277, 40377 & 40477</i>	Working Time: 10 Min Set Time: 15 Min Top Coat Time: 0 Min* Cure Time: 1 Hr <small>* Paintable immediately with most solvent-based paint systems</small>
	SELF LEVELING SEAM SEALER 39387	Two-component epoxy for drip rails, roof and trunk seams.	Working Time: 10 Min Set Time: 15 Min Top Coat Time: 15 Min Cure Time: 1 Hr
	HIGH-BUILD SELF LEVELING SEAM SEALER 39777	Two-component, controlled flow epoxy ideal for use on roof seams, drip rails and trunk seams.	Working Time: 10 Min Set Time: 15 Min Top Coat Time: 15 Min Cure Time: 1 Hr

SOUND DAMPENING	PRODUCT	DESCRIPTION	PROPERTIES
	PANEL VIBRATION CONTROL MATERIAL 39977	Two-component, epoxy and urethane blend for reducing noise and vibration on roof skins and intrusion beams.	Working Time: 1 Hr Set Time: 1 Hr Cure Time: 1 Hr
	FLEXIBLE URETHANE FOAM 39357	Two-component, urethane, expanding flexible foam that stops vibration and dampens sound in most voids.	Working Time: 15 Sec Set Time: 2 Min Top Coat Time: 15 Min
	RIGID URETHANE FOAM 39997	Two-component, urethane, expanding rigid foam for filling pillars, posts, and box sections.	Working Time: 45 Sec Set Time: 5 Min Top Coat Time: 15 Min
	SOUND & SEAL SPRAYABLE COATING 40977	Two-component, sprayable, epoxy and urethane blend for replacing OEM coatings under rocker panels, in trunks, and on floor sections and frame rails.	Working Time: 10 Min Set Time: 15 Min Top Coat Time: 30 Min Cure Time: 1 Hr

APPLICATORS

Universal Manual Applicator 71119

- Ensures proper mix ratio
- Ideal gear ratio for smooth dispersion
- Release button for precision

Universal Pneumatic Applicator 70039

- Decreases fatigue
- Increases efficiency
- Smooth, even dispensing
- Adjustable flow rate
- Use with Quick Spray System

Quick Spray System Starter Kit 70100

Everything you need to start spraying 2K sealers and sound dampening materials.

Quick Spray System Starter Kit Includes:

- 70101 Round Air Assembly (pictured below)
- 70102 Flat Air Assembly (pictured below)
- 70103 Static Mixer 6-Pack (pictured below)
- 70104 Adapter Assembly
- 70106 Air Baffle 5-Pack

NOTE: 70039 Universal Pneumatic Applicator is not included in the Quick Spray System Starter Kit. Only use the Quick Spray System with specified SEM products.

TIPS

ORBIT™ Tip PATENT PENDING
OE Ripple Bead Installation Tip

Duplicates OE seam sealer ripple beads commonly found on strut towers, trunk pans and rear body pans of most vehicles. Works with SEM 1K and 2K seam sealers. Packaged with Dual-Mix Heavy Bodied Seam Sealer. Contact your SEM Representative for more information.

SHFT™ Tip
SEM Hem Flange Tip

Duplicates OE hem flange seam sealer beads commonly found on doors, hoods and deck lids of most vehicles. Packaged with Dual-Mix Medium Bodied Seam Sealer. Contact your SEM Representative for more information.

Door Skin Nozzle 29312 (6 PACK)

Specialty flanged tip that quickly duplicates the appearance of offset door skin seam sealer beads. Requires 2K Adapter for use with 2K cartridges.

Extrusion Nozzle 29322 (6 PACK)

Specialty tip for creating various beads and offsets. Requires 2K Adapter for use with 2K cartridges.

Versa-Tip 70070 (6 PACK)

Customizable tips, graduated and notched for easy trimming to duplicate .5", .75", 1", 1.25", and 1.5" flat ribbon beads out of 7 oz. two-component cartridges.

Integral Nut Square Static Mixers 70011 (6 PACK) 70012 (50 PACK)

Mixing tips for use with 7 oz. two-component cartridge products.

Quick Spray System Static Mixers 70103 (6 PACK)

Extended mixing tips for use when spraying seam sealers and sound dampening materials.

Round Air Assembly 70101

Flat Air Assembly 70102

Learn more about Dual-Mix at:
semproducts.com/dual-mix

SOPs, videos and literature. Get all the info you need to do the job right.
semproducts.com/sop



DUAL-MIX PARTS & LABOR WARRANTY

When used according to product instructions, SEM guarantees to the purchaser that all DUAL-MIX products will perform to specifications for the life of the vehicle. This warranty covers reasonable costs for labor, loss of use of the vehicle, parts and materials only, and excludes consequential or incidental damages. When applicable, OEM repair procedures must be followed.

TECH SUPPORT

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