SEM®

39747
MULTI-PURPOSE PANEL ADHESIVE

- Versatile – bonds steel, aluminum, SMC & FRP
- May be welded through using resistance welder
- Excellent corrosion protection
- Extended working time up to 90 minutes
- Long shelf-life – 2 years







DUAL-MIX™ FOREVER WARRANTY

When used according to directions, **SEM** guarantees to the purchaser that all **DUAL-MIX™** products will perform to specifications forever. This warranty covers reasonable costs for labor, loss of use of vehicle, parts and materials only, and excludes consequential or incidental damages.

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39747 MULTI-PURPOSE PANEL ADHESIVE

39747 MULTI-PURPOSE PANEL ADHESIVE is a non-sag, two component epoxy adhesive system formulated to bond steel, aluminum, SMC and fiberglass panels without the use of an external primer. **39747** provides long working times (up to 90 minutes) allowing body shops to correctly position parts for proper alignment. This adhesive contains glass beads to insure adequate bond line control. **39747** is an easy to use 2:1 adhesive that forms resilient bonds and maintains its strength over a wide range of temperatures. **39747** is suitable for bonding a variety of substrates, especially automotive grade cold rolled steel.

PREPARATION



Bonding surfaces should be clean, dry and free of contamination. Clean surfaces to be bonded with **38373 SEM SOLVE** or compliant cleaner. Abrade each surface with 24-36 grit grinding disc at lower speed to maintain grinding marks. Do not grind at high speed.

MIXING



It is highly recommended that adhesives be dispensed through a static mixer. Once mixed, **39747** should achieve a uniform color. ***This is important!*** Heat build-up during and after mixing is normal.

Place cartridge into **71119 UNIVERSAL MANUAL APPLICATOR** or **70039 UNIVERSAL PNEUMATIC APPLICATOR**. Remove retaining nut and red insert. To maintain product quality, replace after use. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired application size. Extrude a 2" - 3" of material to avoid marbeling.

Use Static Mixers: **70011 INTEGRAL NUT SQUARE STATIC MIXERS** (6 pack) or **70012 INTEGRAL NUT SQUARE STATIC MIXERS** (50 pack)

APPLICATION



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

NOTE
39747 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.

CURING
Parts should remain undisturbed during the interval of time between the material's working time and set time. After the set time is achieved, the material has reached handling strength. 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 77°F (25°C), 39747 sets in 4 hours and fully cures in 24 hours.

For additional information, refer to the **MULTI-PURPOSE PANEL ADHESIVE TECHNICAL DATA SHEET** or contact us at **www.semproducts.com.**

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The Right Choice

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