



**DESCRIPTION**

A black 40 second semi-flexible epoxy adhesive designed for quick repairs on metal, SMC, FRP, fiberglass and most plastic surfaces.

**TYPICAL USES**

Fast Set 40 is used for bumper tab repairs, quick interior panel repairs, clip retainers and small brackets.

**FEATURES**

- Bonds a variety of substrates
- Sandable
- Paintable
- Can be used on flexible and semi-flexible substrates
- Fast set times for maximum productivity

**SUBSTRATES**

- |                               |                            |
|-------------------------------|----------------------------|
| • Bare metal                  | • SMC                      |
| • Primed and painted surfaces | • FRP                      |
| • OEM e-coat                  | • Fiberglass               |
| • Aluminum                    | • Most automotive plastics |

\*Polyethylene cannot be repaired with Duramix Fast Set 40, even when used with Seymour Universal Plastic Adhesion Promoter.

**SUBSTRATE PREPARATION**

1. For thermal plastics only, clean with a scuffing paste and a gray scuff pad. Rinse thoroughly with clean water to remove all residue and dry with a clean lint free cloth.
2. Clean with Seymour Universal Plastic Cleaner and wipe with a clean lint free cloth. (On fiberglass, SMC and FRP do not saturate the fibers.)
3. Allow the surface to dry completely.
4. Grind at low speed\* (*all coatings must be removed from the bonding surfaces*)
  - a. Bare metal surfaces with P80 grit sandpaper.
  - b. Primed/painted surfaces with P320 grit sandpaper.
  - c. SMC, FRP and fiberglass with P80-180 grit sandpaper.
  - d. Thermal plastic substrates (TPO, PP, and TSOP, etc.) with P80 grit sandpaper.
5. Blow off the repair area with clean, dry compressed air.
6. Reclean with Seymour Universal Plastic Cleaner. Do not saturate any exposed fibers with any surface cleaner.
7. Apply one even wet coat of Seymour Universal Plastic Adhesion Promoter over the exposed bare plastic area. Allow the plastic adhesion promoter to dry for approximately 15 minutes. The use of Seymour Universal Plastic Adhesion Promoter is not recommended on fiberglass, SMC, FRP, steel and aluminum.

**DURAMIX 2K  
 CARTRIDGE GUN  
 SET-UP**

1. Press release lever and pull plunger rods all the way back.
2. Place back end of the twin cartridge onto the plungers first.
3. Bring down the front of the cartridge and seat into the gun.
4. To remove cap, insert flat head of screwdriver into slot and pry upward.
5. Remove cap completely from cartridge.
6. Cap can be re-inserted to seal a partially used cartridge. To avoid cross contamination, match up the circle and square on the cap and top of the cartridge body.
7. Tilting the gun back, press the lever until the product flows equally from both chambers. This procedure equalizes the chambers to ensure an equal mix. Wipe the excess material from both sides before installing the static mixer. This is a very important step.
8. Install the static mixer on the end of the nosepiece and tighten in a clockwise direction until securely fastened.
9. Pump material through the static mixer. Discard the first 3 inches of product, then proceed with application.
10. To retain unused product, remove the static mixer and install the cap into the appropriate sides of the cartridge after use. (The static mixer may be left on the cartridge instead of reinserting the cap, except on foams.)

**APPLICATION**

**Always follow applicable manufacturers recommendations.**

1. Dry fit the parts to ensure proper fit.
2. Apply Duramix Fast Set 40 to the area being repaired.
3. Hold, clamp or tape the pieces in place for at least one minute.
4. Allow to dry for approx. 30 minutes before sanding.
5. Allow 8 hours for full cure.

**CLEAN UP**

Unmixed or uncured material can be cleaned from most surfaces with Seymour PBE Professional Paint Gun And Equipment Cleaner or an appropriate VOC compliant product for your area.

**STORAGE**

Should be stored in a cool, dry location at a temperature between 50°F to 86°F (10°C to 30°C).

**SPECIFICATIONS**

Mixing Ratio	1:1
Work Time	40-50 Seconds
Handling Time	5-10 Minutes
Sandable	15-30 Minutes
Paintable	15-30 Minutes
Full Cure	6-8 Hours

All times stated are approximate depending on temperature, humidity and thickness of the product applied.  
 All times are based on 70°F to 75°F at 50% relative humidity.

**PRODUCTS**

Part Number	Part	
	Seymour Universal Surface Cleaner	Aerosol
	Seymour Universal Plastic Adhesion Promoter	Aerosol
1570	Duramix 2K Cartridge Gun (manual)	Applicator Gun
1580	Duramix 2K Pneumatic Applicator Gun	Applicator Gun
1540	Static Mixer	10pk
1460	Duramix Fast Set 40	Cartridge

**CAUTION**

**For professional use only.**

Refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

*Disclaimer: The information provided in this document is intended for guidance only and should not be interpreted as a warranty. All implied warranties are expressly disclaimed. Users are responsible for ensuring that the materials are suitable for their specific needs, environment, and application. Seymour reserves the right to modify the data as deemed necessary. Users should consult the Safety Data Sheet (SDS) and product label for information on potential health risks, necessary engineering controls, and safety precautions when using the material. SDS and product label copies are available upon request.*