

DURAMIX FLEXIBLE PLASTIC REPAIR MATERIAL



DESCRIPTION

For bonding, repairing or surfacing urethane and TPO bumpers, filler panels and most flexible plastic parts.

TYPICAL USES

Flexible plastic repair materials are designed to repair flexible and semi flexible plastic parts.

FEATURES

- Sands and featheredges easily
- Permanently flexible
- Can be used with most automotive plastics

SUBSTRATES

- TPO
- PP
- TSOP
- PUR
- Urethane

*Polyethylene cannot be repaired with Duramix Flexible Plastic Repair Material, even when used with Seymour Universal Plastic Adhesion Promoter.

SUBSTRATE PREPARATION

1. 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.
3. Allow the surface to dry completely.
4. Sand the plastic 3-4" past the repair area at slow speed with P80 grit sandpaper making sure that all paint has been removed from the repair area. (It is important to use slow speed to not create too much heat while sanding. Too much heat will melt the plastic, and this will lead to adhesion failure. Stopping frequently while sanding is the best way to keep heat from building up.)
5. If the damage goes all the way through the plastic and a backside structural repair is necessary (i.e. a tear or hole), follow steps 1-4 on the backside, then continue to step 7 on the backside. (Skip step 6 on the backside)
6. "Dish" out the repair area using a 36-grit grinding disk at slow speed. This creates more surface area for the repair material to adhere to. (Do not "V" out the repair area.)
7. Blow off the repair area with clean, dry compressed air.
8. Reclean with Seymour Universal Plastic Cleaner. Allow to dry completely.
9. Apply one even wet coat of Seymour Universal Plastic Adhesion Promoter over the prepared repair areas where the plastic repair material is to be applied. Allow the plastic adhesion promoter to dry for approximately 15 minutes.

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

Steps 1-5 are only needed if doing a backside structural repair.

1. If the damage goes all the way through the plastic and a backside structural repair is necessary (i.e. a tear or hole), apply masking tape to the frontside of the panel over the tear or hole to hold the Duramix Flexible Repair Material temporarily in place.
2. On a backside structural repair, apply a thin coat of Duramix Flexible Repair Material and place nylon repair tape over the tear or hole. Pushing the tape firmly into the repair material with a spreader.
3. Apply another layer of Duramix Flexible Plastic Repair Material to repair area.
4. Allow to dry for approximately 15 minutes.
5. Turn the panel over and carefully remove the masking tape. Do not damage the backside repair.
6. Apply Duramix Flexible Plastic Repair Material to the repair area. Leaving the repair material a little high to allow for sanding.
7. Allow to dry for approximately 15 minutes.
8. Sand with P80 grit sandpaper and finish with P180 at slow speed.
9. Re-apply Duramix Flexible Plastic Repair Material and allow to dry.*
10. Sand with P180 grit sandpaper and finish with P320 grit sandpaper.
11. Prime with Seymour 3 N 1 Primer or use a urethane primer following manufacturer's recommendations.

*A flexible polyester finishing glaze may be used for step 9, if desired.

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	5-10 Minutes
Handling Time	10-15 Minutes
Sandable	10-20 Minutes
Paintable	10-20 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
1430	Duramix Flexible Plastic Repair Material	Cartridge
	Seymour 3-N-1 Primer	Aerosol
20-1685	Seymour PBE Professional Paint Gun And Equipment Cleaner	Aerosol

CAUTION

For professional use only.

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

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