



DESCRIPTION

A flexible direct to metal seam sealer used to replicate OEM beads and textures. Also, can be used as a sprayable seam sealer for applications such as sound dampening pads.

TYPICAL USES

1K seam sealers are ideal for duplicating the seam sealer seen on door skins, hoods, and trunks. These flange beads can easily be replicated by using tape or a door skin nozzle to achieve a softened or rolled edge. It can be used to duplicate OEM sprayed undercarriage seam sealer.

FEATURES

- Direct to metal
- Paintable immediately
- Can be used as a sprayable seam sealer
- Fast dry times for maximum productivity
- Easily duplicates OEM seam sealer appearance
- Isocyanate free
- Can be used with resistance welding (STRSW)
- Color matched with OEM and Duramix 2K seam sealers
- Permanently flexible without shrinking

SUBSTRATES

- Bare metal
- Primed metal
- OEM e-coat
- Aluminum
- SMC
- FRP
- Fiberglass

SUBSTRATE PREPARATION

1. Surface must be clean and free of dirt, grease, oil, rust, and any other contaminants. Use Seymour Universal Surface Cleaner to clean the surface.
2. Sand
 - a. Bare metal surfaces with P80 grit sandpaper.
 - b. Primed surfaces with P400 grit sandpaper or scuff with a gray scuff pad.
 - c. SMC, FRP and fiberglass with P80-180 grit sandpaper.
3. Reclean with Seymour Universal Surface Cleaner. Do not saturate any exposed fibers with any surface cleaner.
4. For optimal results and to align with OEM repair procedures, prime bare metal and aluminum with a 2K epoxy primer. Allow primer to cure according to manufacturer's recommendations before applying Duramix 2-in-1 1K Seam Sealer.

Note: Do not use directly over an acid-etch primer or apply etch primer over Duramix 2-in-1 1K Seam Sealer.

APPLICATION

1. Apply Duramix 2-in-1 1K Seam Sealer into the joint or seam.
2. Smooth out if desired with tool, brush or finger to obtain desired appearance.
3. Apply topcoat within 48 hours. After 48 hours, scuff with a medium scuff pad prior to priming or painting.

Note: Before applying any primer or topcoat, test for compatibility.

SPRAYABLE APPLICATION

1. Mask for overspray.
2. Cut the tip of the threaded neck off and puncture the foil seal.
3. Use a manual caulking gun to dispense some product to dislodge the piston in back of tube. (The piston cannot be dislodged by the air used in the sprayable applicator gun.)
4. Install tube in the 1K Sprayable Seam Sealer Applicator Gun.
5. Screw on applicator barrel until fully tightened.
6. Adjust air inlet pressure to achieve desired product volume (40-60 PSI).
7. Adjust atomizing air (side knob) until desired texture is achieved.
8. Remove any masking tape adjacent to seam sealer while the product is still wet.

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	N/A
Work Time	20 Minutes
Handling Time	2 Hours
Paintable	Immediately with solvent based coatings
	15 minutes with waterborne basecoat
Full Cure	Up to 48 hours depending on thickness

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
1490	Duramix 2-in-1 1K Seam Sealer - White	Cartridge
1510	Duramix 2-in-1 1K Seam Sealer - Gray	Cartridge
1520	Duramix 2-in-1 1K Seam Sealer - Beige	Cartridge
1530	Duramix 2-in-1 1K Seam Sealer - Black	Cartridge
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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