



DESCRIPTION

A high viscosity direct to metal seam sealer designed for sealing horizontal and vertical voids, joints and seams.

TYPICAL USES

Heavy bodied seam sealers are ideal for duplicating beads typically seen on door skins, hoods, and trunks. These beads can easily be replicated by using tape or a door skin nozzle. It is, also, excellent for duplicating ripple beads and tooled seam sealer beads on vertical and horizontal surfaces.

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

SUBSTRATES

- Bare metal
- Primed metal
- 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 Heavy Bodied Seam Sealer.

Note: Do not use directly over an acid-etch primer or apply etch primer over Duramix Heavy Bodied Seam Sealer.

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

1. Apply Duramix Heavy Bodied Seam Sealer into the joint or seam.
2. Smooth out if desired with tool, brush or finger to obtain desired appearance. If desired, the seam sealer can be sanded with P320 sandpaper in 45 to 60 minutes.
3. If Duramix Heavy Bodied Seam Sealer is left to dry for more than 8 hours, scuff prior to priming or painting.

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

SPRAYABLE APPLICATION

Follow steps 1- 7 on the **Duramix 2K Cartridge Gun Set-Up**, then:

1. Mask for overspray.
2. Attach the atomizing air valve adapter to the pneumatic applicator gun air inlet and close the valve.
3. Follow steps 1- 7 on the Duramix 2K Cartridge Gun Set-Up, then:
4. After the cartridge is equalized (Step 7), install a sprayable static mixer.
5. Attach the flexible tube (from the atomizing air valve adapter) by pushing it onto the atomizer head on the sprayable static mixer.
6. Pump material through the static mixer before applying atomizing air. Discard the first 3 inches of product.
7. Open the atomizing air valve.
8. Start with very low atomizing air pressure and then adjust the pressure on the regulator/valve to fine-tune the spray pattern.
9. Immediately after application, remove the tape adjacent to the product.

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	10-15 Minutes
Handling Time	30-45 Minutes
Paintable	Immediately with solvent based coatings 15 minutes with waterborne basecoat
Sandable	45-60 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
1570	Duramix 2K Cartridge Gun (manual)	Applicator Gun
1580	Duramix 2K Pneumatic Applicator Gun	Applicator Gun
1600	Duramix Sprayable Regulator Assembly	Applicator Gun
1540	Static Mixer	10pk
1370	Duramix Heavy Bodied Seam Sealer - Beige	Cartridge
1380	Duramix Heavy Bodied Seam Sealer - White	Cartridge
1390	Duramix Heavy Bodied Seam Sealer - Gray	Cartridge
1410	Duramix Heavy Bodied Seam Sealer - Black	Cartridge

CAUTION

For professional use only.

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

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