TECHNICAL DATA SHEET

DURAMIX DOOR SKIN AND SMC ADHESIVE

DESCRIPTION

An epoxy that quickly bonds steel, aluminum, fiberglass and SMC.

TYPICAL USES

Door skin and SMC adhesives are used for non-structural panel attachment to a variety of metal and composite substrates. Not for use on structural applications. Can be used in lower temperatures for panel bonding applications.

FEATURES

- High strength bond
- Provides corrosion protection
- Bonds and seals simultaneously
- Compatible with MIG welding or STRSW (squeeze-type resistance spot welding)

SUBSTRATES

- Steel
- Aluminum
- SMC
- FRP
- Fiberglass

SUBSTRATE PREPARATION

Always follow applicable OEM recommendations.

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. Grind at low speed* *(all coatings must be removed from the bonding surfaces)*
   a. **Door skins only,** scuff e-coated surfaces with a coarse scuff pad.
   b. Steel with P36 grit sandpaper.
   c. Aluminum with P36-P80 grit sandpaper.
   d. SMC, FRP and fiberglass with P36 grit sandpaper.
3. Reclean with Seymour Universal Surface Cleaner. Do not saturate any exposed fibers with any surface cleaner. Allow to dry completely.
4. Straighten all metal bonding surfaces and dry fit panels for proper alignment.

*Grinding at low speed results in deeper/heavier grinding marks which will enhance adhesion.

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.)

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DURAMIX DOOR SKIN AND SMC ADHESIVE

APPLICATION

Always follow applicable manufacturers recommendations.

1. Apply Duramix Door Skin and SMC Adhesive to all bonding surfaces (vehicle and replacement panel). Using a plastic spreader or acid brush, spread the adhesive evenly covering all bonding surfaces and bare metal areas to create a base coat for an additional adhesive bead.
2. Apply a bead of Duramix Door Skin and SMC Adhesive ¼" from the edge of the replacement panel.
3. Clamp the replacement panel securely into the correct position. Do not over clamp. Panels must be clamped during the entire stated clamp time. Make sure not to remove any adhesive from the bonding surface during installation. If the panel needs to be repositioned do not lift the panel, slide the panel into the correct position.
4. Tool any squeezed-out adhesive with a plastic spreader filling all gaps or voids and to seal all seams.
5. Clamps may be removed in approx. 2 hours. Panel may need to remain clamped if temperature is below 72°F or if there is any tension on the panel. Cure time is 6-8 hours. De-clamping time and cure time can be accelerated by applying heat with a heat gun or heat lamps. Be careful not to overheat. Do not exceed 180° F.

DAMPENING MATERIAL

When replacing door skins, Duramix NVH Dampening Material can be used to replace the OEM dampening material (foam) found between the panels and the intrusion beams.

WELDING

Duramix Door Skin and SMC Adhesive can be used with MIG welding or STRSW while the adhesive is still within the stated work time.

Caution: Adhesives are combustible. Keep any MIG welding a minimum of two inches from the adhesive. As with any welding operation, keep the appropriate fire extinguisher within reach, and be alert to any smoke or flame that may be present.

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	45-60 Minutes
De-Clamp Time	120 Minutes
Full Cure	24 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
1540	Static Mixer	10pk
1330	Duramix Door Skin and SMC Adhesive	Cartridge
1450	Duramix NVH Dampening Material	Cartridge
20-1685	Seymour PBE Professional 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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