



DUAL-MIX™ MULTI-PLASTIC REPAIR MATERIAL



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Dual-Mix Multi-Plastic Repair Material is a two-component epoxy for fast repairs on virtually all plastic bumper covers.

FEATURES

- Dual-Mix™ Forever Warranty
- OEM recommended
- No adhesion promoter necessary
- Exceptional sanding and featheredge
- Remains flexible
- Does not shrink or pinhole
- Excellent leveling and sag resistance

SUITABLE SUBSTRATES

- Flexible plastics
- Semi-rigid plastics

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
39847	Multi-Plastic Repair Material	Gray	7 oz. Cartridge

Working Time:	7 minutes @ 70°F (21°C)
Sand Time:	15 minutes @ 70°F (21°C)
Top Coat Time:	20 minutes @ 70°F (21°C)
Cure Time:	1 hour @ 70°F (21°C)

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HANDLING AND APPLICATION

PREPARATION:



1. Clean areas to be repaired with Scuff & Clean and a gray scuff pad. Rinse with water and dry or wipe with a clean, damp cloth until removed.
2. Next, clean with Plastic & Leather Prep, SEM Solve or XXX Universal Surface Cleaner. Apply and remove per directions.
3. Sand front side of repair with P80 grit paper 2–3 inches around the damaged area.

Note: If the OEM paint has good adhesion, it is not necessary to strip the paint to the raw plastic.



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4. "Dish" out the front side of damaged area with a P24 or 36 grit disc. Grind slowly. Excess heat may seal the pores of the plastic making adhesion difficult.
5. Grind back side of repair with P24 or 36 grit at low RPM or by hand to minimize melting of the plastic.
6. Blow-off with clean, dry, compressed air.
7. Re-clean with Plastic & Leather Prep, **SEM Solve** or **XXX Universal Surface Cleaner**, if necessary.
Note: Give adequate time for cleaner to flash off before proceeding to next steps.
8. **Optional:** Apply adhesion promoter to all prepped surfaces. An application of XXX Adhesion Promoter or Plastic Adhesion Promoter will improve adhesion and featheredge sanding of the repair material. Follow instructions on the adhesion promoters label or Technical Data Sheet for proper use.

Note: If the use of adhesion promoter is omitted during the repair process, great care must be taken when sanding or grinding any raw plastic. Grinding or sanding too quickly will melt the plastic, leaving a shiny, smooth surface that will not bond with the adhesive.

MIXING:

Place cartridge into the **Universal Manual Applicator** or **Universal Pneumatic Applicator**. To remove cap, insert flat head screwdriver into slot and pry upward.

Note: Prior to installing Static Mixer, equalize cartridge by dispensing product until both parts flow equally. Install Static Mixer. Cut tip to desired application size. Hold applicator upright until product is dispensed into mixer. Dispense a test bead to ensure proper mix. For cap replacement, match circles and square, then snap back into place.

USE STATIC MIXERS:



Part:	Product Name:	Size:
70011	Integral Nut Square Static Mixers	6 Pack
70012	Integral Nut Square Static Mixers	50 Pack

APPLICATION:

1. Reinforce large holes and damaged areas from the back side with Plastic Repair Reinforcing Tape or **Plastic Repair Contouring Tape**. Use enough of the tape to overlap the repair. Apply **Multi-Plastic Repair Material** over the tape and spread firmly with a spreader.
2. After repair material has set, apply **Multi-Plastic Repair Material** to the front side of repair area. Press firmly to eliminate air pockets. Apply higher than surrounding area to allow for sanding.
3. After **Multi-Plastic Repair Material** has cured for 15 minutes, sand first with P80 grit, then finish with P180 grit paper.
4. For slight imperfections, reapply a skim coat of **Multi-Plastic Repair Material** or use **Bumper Bite Flexible Glaze**.
5. To fill sand scratches and prepare surface for painting, apply **Flexible Primer Surfer**, **High-Build Primer Surfer** or **World Class™ Waterborne Flexible Primer**.





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STORAGE:

Multi-Plastic Repair Material should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Multi-Plastic Repair Material** is 2 years when stored under normal conditions.

RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
39131	Flexible Primer Surfacer	Gallon
39133	Flexible Primer Surfacer	16 oz. Aerosol
39134	Flexible Primer Surfacer	Quart
40482	Bumper Bite™ Flexible Glaze	16 oz. Tube
42003	High-Build Primer Surfacer - Black	20 oz. Aerosol
42013	High-Build Primer Surfacer - Gray	20 oz. Aerosol
42023	High-Build Primer Surfacer - Beige	20 oz. Aerosol
42033	High-Build Primer Surfacer - Rose	20 oz. Aerosol
42043	High-Build Primer Surfacer - White	20 oz. Aerosol
50184	World Class™ Waterborne Flexible Primer	Quart
68422	Mini-Max™ Bumper Repair	1 oz. Cartridge
70006	Plastic Repair Reinforcing Tape	36' Roll
70007	Plastic Repair Contouring Tape	15' Roll
70011	Integral Nut Static Mixers	6 Pack
70012	Integral Nut Static Mixers	50 Pack
70039	Universal Pneumatic Applicator	Each
71119	Universal Manual Applicator	Each
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



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Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.

