

DUAL-MIX™ PATCH PANEL ADHESIVE

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

DESCRIPTION

Dual-Mix™ Patch Panel Adhesive is a two-component adhesive for quickly bonding metal panels without the use of an external primer.

FEATURES

- DUAL-MIX™ Forever Warranty
- OEM recommended
- Acrylic technology
- Superior impact and peel strength
- Non-sag formula
- Quick cure time
- Excellent corrosion resistance

SUITABLE SUBSTRATES

- Steel
- Aluminum

TYPICAL CURED PROPERTIES

| Part: | Product Name: | Color: | Container: |
|--|--|--------------|-----------------|
| 39897 | Patch Panel Adhesive | Opaque Cream | 7 oz. Cartridge |
| Working time: | 10 minutes @ 70°F (21°C) | | |
| Set time: | 20 minutes @ 70°F (21°C) | | |
| Cure time: | 30 minutes @ 70°F (21°C) | | |
| Heat cure time: | 15 minutes @ 120° – 140°F (49° – 60°C) | | |
| Lap shear @ 70°F (21°C) (psi) on steel: | 3000+ ASTM D 1002 | | |
| Coverage: | 115" @ 3/8" diameter bead | | |

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

HANDLING AND APPLICATION

PREPARATION:

Bonding surfaces should be clean, dry and free of contamination.

1. Clean surfaces to be bonded with **SEM Solve** or **XXX Universal Surface Cleaner**.



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

2. Grind each surface with P36 grit grinding disc at low speed to maintain grinding marks.
Do not grind at high speed.
3. Re-clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner** if necessary.

Note:

Always use lint-free towels when cleaning surfaces to avoid lint and particle contamination.

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.

STATIC MIXERS:

| Part: | Product Name: | For: | Container: |
|--------------|-----------------------------------|-----------------|-------------------|
| 70011 | Integral Nut Square Static Mixers | 7 oz. Cartridge | 6 Pack |
| 70012 | Integral Nut Square Static Mixers | 7 oz. Cartridge | 50 Pack |

APPLICATION:

Use enough material to completely fill the joint when parts are clamped. Remove the excess material from the front of the repair. Always follow step-by-step directions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time. Wipe up excess material squeezed out during clamping process. Exposed material left to dry may not fully harden, especially in high humidity conditions.

Note:

Partial panel replacements are not warranted for cosmetics, as they may show a bond line or halo due to techniques in workmanship.

IMPORTANT:

Bonding applications are intended for secondary (cosmetic) panels only. Structural components should never be bonded unless specified by the OEM.

CURING:

Parts should remain undisturbed between the material's working time and set time. After the set time is achieved, the material has reached handling strength. Temperatures below 55°F (13°C) will slow the cure; above 85°F (29°C) will accelerate cure rate. To enhance cure time, heat to 120° – 140°F (49°– 60°C) for 15 minutes. At 77°F (25°C), **Patch Panel Adhesive** sets in 20 minutes and fully cures in 30 minutes.



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

WELDING:

Patch Panel Adhesive is versatile and can be used with traditional welding methods or resistance spot welding techniques while still wet when following OEM recommendations. A 1 inch gap must be left where traditional welding will occur.

Note:

Remove excess adhesive prior to welding.

Note:

Prior to welding apply **Weld-Thru Primer** or **Copperweld™ Primer** on any areas where adhesive will not be present. Allow weld-thru primer to fully dry.

CLEANUP:

It is important to clean up excess adhesive from the work area and application equipment before it cures. Use appropriate cleaning materials compliant with VOC regulations in your area. Keep container tightly closed after use. Remove static mixer after use and replace cap. **Patch Panel Adhesive** is flammable when exposed.

STORAGE:

Patch Panel Adhesive should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Patch Panel Adhesive** is 1 year when stored at 40°–77°F (4°–25°C). Exposure above room temperature will reduce shelf life.

RELATED PRODUCTS:

| Part: | Product Name: | Size: |
|-------|----------------------------------|----------------|
| 38371 | SEM Solve | Gallon |
| 38373 | SEM Solve | 20 oz. Aerosol |
| 38374 | SEM Solve | Quart |
| 38375 | SEM Solve | 5 Gallon |
| 39783 | Weld-Thru Primer | 16 oz. Aerosol |
| 40783 | Copperweld™ Primer | 20 oz. Aerosol |
| 40786 | Brushable Copperweld™ Primer | Half Pint |
| 70011 | Integral Nut Square Static Mixer | 6 Pack |
| 70012 | Integral Nut Square Static Mixer | 50 Pack |
| 70039 | Universal Pneumatic Applicator | Each |
| 71119 | Universal Manual Applicator | Each |
| 77771 | XXX Universal Surface Cleaner | Gallon |
| 77774 | XXX Universal Surface Cleaner | Quart |