



# HEAVY BODIED BLACK SEAM SEALER

## TECHNICAL DATA SHEET



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

### DESCRIPTION

**Heavy Bodied Black Seam Sealer** is a high viscosity, two component epoxy for use on interior or exterior seams, joints and voids.

### FEATURES

- **Dual-Mix™** Forever Warranty
- OEM recommended
- wDirect to metal
- Paintable immediately with most solvent-based coatings
- Holds tooling marks throughout working time
- Non-sag formula
- Black color matches many OEM sealers
- Remains flexible without shrinking or cracking
- Sprayable for additional versatility

### SUITABLE SUBSTRATES

- Bare Metal
- OEM Finish
- Epoxy Primer
- DTM Urethane Primer

### TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
40377	Heavy Bodied Black Seam Sealer	Black	7 oz. Cartridge

**Working time:** 10 minutes @ 70°F (21°C)

**Set time:** 15 minutes @ 70°F (21°C)

**Top Coat time** with most solvent-based coatings: 0 minutes @ 70°F (21°C)

**Top Coat time** with most waterborne coatings: 15 minutes @ 70°F (21°C)

**Cure time:** 1 hour @ 70°F (21°C)

### HANDLING AND APPLICATION

#### PREPARATION:

##### Note:

Prior to applying **Heavy Bodied Black Seam Sealer** vehicle temperature should be 70°F (21°C) for at least one hour.



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- 1.** Clean joints and seams thoroughly with **SEM Solve** or **XXX Universal Surface Cleaner**.
- 2.** Sand primed surface with 400 grit sand paper or scuff with a gray scuff pad. Sand bare metal surface with 80 grit sand paper.
- 3.** Blow off and tack clean to remove lint and dust.
- 4.** Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

**Heavy Bodied Black Seam Sealer** may be applied directly to properly prepped bare metal or primed surfaces. However; if the area will be subjected to any flexing or twisting, including certain vehicle manufacturers roof skins, prime the area first with a quality, two-component urethane or epoxy primer such as **World Class™ DTM Primer** before applying **Heavy Bodied Black Seam Sealer**. If in doubt, prime. Allow primer to fully cure before applying **Heavy Bodied Black Seam Sealer**.

**Note:**

**Heavy Bodied Black Seam Sealer** should not be used directly over acid based self-etching primers or vice versa. This application procedure can cause cracking and blistering of the undercoat and top coat.

**Heavy Bodied Black Seam Sealer** is paintable immediately with most solvent-based coatings, however, always test for compatibility.

**MIXING:**

- 1.** Place cartridge into **Universal Manual Applicator** or **Universal Pneumatic Applicator**.
- 2.** Remove cap by inserting a flat head screwdriver into slot and prying upward.
- 3.** Equalize cartridge by dispensing product until both parts flow equally.
- 4.** Install **Static Mixer**. Cut tip to desired application size.

**Note:**

For cap replacement, match circles and squares, then snap back into place.

**STATIC MIXERS:**

<b>Part:</b>	<b>Product Name:</b>	<b>For:</b>	<b>Container:</b>
70011	Integral Nut Square Static Mixers	7 oz. cartridge	6 pack
70012	Integral Nut Square Static Mixers	7 oz. cartridge	50 pack

**APPLICATION:**

- 1.** Apply **Heavy Bodied Black Seam Sealer** into joint or seam. Work in or finish with finger, putty knife, acid brush or spreader.
- 2.** While product is still wet, remove excess by wiping with a small amount of solvent compliant with the VOC regulations in your area.
- 3.** **Heavy Bodied Black Seam Sealer** can be painted immediately with most solvent-based coatings, or up to 24 hours without scuffing. If in doubt, scuff with a gray pad prior to painting.



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## SPRAYING:

The **Quick Spray System** easily attaches to the **Universal Pneumatic Applicator** and allows users to duplicate OEM seam sealer textures while utilizing the two-component technology of **SEM** seam sealers.

Also available are **Versa-Tips**. **Versa-Tips** snap onto the end of the **Static Mixer** and allow the user to easily duplicate OEM seam sealer ribbons. **Versa-Tips** contain six tips that may be cut to 1/2", 3/4", 1", 1.25" and 1.5" ribbon tips.

## STORAGE:

**Heavy Bodied Black Seam Sealer** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Heavy Bodied Black Seam Sealer** is 2 years when stored under normal conditions.

## 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
50121	World Class™ DTM Primer	Gallon
50124	World Class™ DTM Primer	Quart
50134	World Class™ DTM Primer Activator	Quart
50136	World Class™ DTM Primer Activator	Half Pint
70011	Integral Nut Static Mixers	6 Pack
70012	Integral Nut Static Mixers	50 Pack
70039	Universal Pneumatic Applicator	Each
70070	Versa-Tip	6 Pack
70100	Quick Spray System Starter Kit	Each
71119	Universal Manual Applicator	Each
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart