



# DUAL-MIX™ WELD-BOND ADHESIVE

## TECHNICAL DATA SHEET

### DESCRIPTION

**Dual-Mix Weld-Bond Adhesive** is a non-sag, two-component acrylic adhesive system formulated to bond metal surfaces without the use of an external primer.

### FEATURES

- **Dual-Mix** Forever Warranty
- OEM recommended
- Superior impact and peel strength
- Spacer beads for consistent bond line thickness
- Excellent environmental resistance
- Extended one-hour working time.

### SUITABLE SUBSTRATES

- Steel
- Aluminum

### TYPICAL CURED PROPERTIES

Part:	Product Name:	Color:	Container:
39537	Dual-Mix Weld-Bond Adhesive	Opaque Cream	7 oz. Cartridge
Working time:		60 minutes @ 70°F (21°C)	
Set time:		3 hours @ 70°F (21°C)	
Cure time:		24 hours @ 70°F (21°C)	
Heat cure time:		1 hour @ 120°– 140°F (49°– 60°C)	
Lap shear @ 70°F (21°C) (psi) on steel:		3500+ 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**.
2. Grind each surface with a 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.



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**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 from the OEM and the instructions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesive's working time. Wipe away excess material squeezed out during clamping process. Do not over clamp. Exposed material left to dry may not fully harden, especially in high humidity conditions.

**Note:**

**Dual-Mix Weld-Bond Adhesive** is intended for full panel replacement only. Partial panel replacements may show a bond line or halo due to techniques in workmanship and are not warranted.

**IMPORTANT:**

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

**DAMPENING MATERIAL:**

When replacing door skins, roof skins or quarter panels, **Dual-Mix Flexible Urethane Foam**, **Dual-Mix Rigid Urethane Foam** and **Dual-Mix Panel Vibration Control Material** can be used to replace the OEM dampening material found between the panels and the structural members. Refer to product information for proper selection.



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## 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 1 hour. At 77°F (25°C), **Dual-Mix Weld-Bond Adhesive** sets in 3 hours and fully cures in 24 hours.

## WELDING:

**Dual-Mix Weld-Bond Adhesive** is versatile and can be used with traditional welding methods or resistance spot welding techniques while still wet when following OEM recommendations.

### Note:

Remove excess adhesive prior to welding.

### Note:

Prior to welding apply **Weld-Thru Primer** or **Copperweld™ Primer** on any area where adhesive will not be present. Allow 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. **Dual-Mix Weld-Bond Adhesive** is flammable when exposed.

## STORAGE:

**Dual-Mix Weld-Bond Adhesive** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Dual-Mix Weld-Bond 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
39357	Dual-Mix™ Flexible Urethane Foam	7 oz. Cartridge
39783	Weld-Thru Primer	16 oz. Aerosol
39977	Dual-Mix Panel Vibration Control Material	7 oz. Cartridge
39997	Dual-Mix Rigid Urethane Foam	7 oz. Cartridge
40783	Copperweld™ Primer	20 oz. Aerosol



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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

### 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 is secondary to the OEM repair guidelines. Instructions 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.