

## 3M™ Duramix™ Factory Match Seam Sealer 4223/08323

### Recreating Factory Door Panel Seams with Duramix™ Seam Sealer

#### Application Guide

#### Simple Steps for Successful Repair

Duramix™ Factory Match Seam Sealer #4223/08323 flows slightly and softens on the edges, without tooling, giving a rounded appearance as is applied at the factory. It can be used to duplicate factory doorskin seams as well as various other factory seams.

1. For optimum adhesion and corrosion resistance, prime all metal surfaces prior to applying seam sealer(s). If an acid-etch (self-etching) primer is used, a 2K epoxy or urethane primer must be applied before application of the seam sealer. Never apply acid-etch primers over seam sealers.
2. Apply seam sealer #4223/08323 to the overlapped and crimped area in a continuous bead.
3. To create a ribbon bead, use a Duramix™ Mix Tip Adapter #4926 or #4927. Make sure the tip adapter is put on tight. Do not exceed the mix tip dwell time which can cause the tip adapter to detach from the Duramix™ Mix tip #4902. An optional method of creating a ribbon bead is to mask off both sides to the desired width of the area where the bead is to be applied. Then, apply seam sealer and tool to the desired thickness. For best results when tooling seam sealer #4223/08323, leave a slight build-up of thickness. Do not tool seam sealer #4223/08323 into paper thin layers. After the seam sealer has been spread, peel away the masking tape while the seam sealer is still wet. **Do not use water or thinner to spread the seam sealer.** If you are using 08323, you can use any of the 3M™ Automix™ OEM Seam Sealer tips to duplicate specific OEM bead shapes.
4. After approximately 1 hour, or when tack free, the seam will be ready for painting.

**NOTE:** After the vehicle has been sealed, primed and painted, do not let the temperature exceed 140° F (60° C) when the vehicle is put into a paint booth.

#### Uses and Advantages

- Recreate factory appearance doorskin seams
- Recreate ribbon type seams
- Will not shrink, wrinkle or crack
- Remains flexible
- Will not peel or lift

#### Precautionary Information

Refer to the Product Label and the Material Safety Data Sheet (MSDS) for health and safety information before using the product. For environmental information, refer to the MSDS. Always wear gloves, eye protection, appropriate respiratory protection, and work in a well-ventilated area.

### **For Additional Information**

To request additional product information or to arrange for sales assistance, call toll free 1-888-663-1394. Address correspondence to: 3M Automotive Aftermarket division, 3M Center, building 223-6N-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175.

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This Automotive Aftermarket division product was manufactured under a 3M quality system registered to ISO 9002 standards.

### **3M Automotive Aftermarket Division**

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