

# DUAL-MIX™

## RIGID PLASTIC REPAIR MATERIAL



PARTS & LABOR  
**WARRANTY\***  
FOR LIFE

*A two-component, fiber-enriched epoxy used for bonding and/or cosmetic repair of composite plastics such as SMC, fiberglass, carbon fiber, Metton® and other rigid plastics*



- OEM recommended
- Outstanding sanding and feather edging
- Air cure, booth cure or curing lamp
- Fiber-enriched formula
- Exceptional bonding strength

**WORKING TIME:** 35 Min  
**SET TIME:** 3 Hr  
**SAND TIME:** Air dry: 3 Hr  
 Paint booth: 30 Min  
 Curing lamp: 10 Min

Part No.	Product	Size
40887	Dual-Mix Rigid Plastic Repair Material	7 oz. Cartridge

\*Visit [semproducts.com/warranty](http://semproducts.com/warranty) for complete Dual-Mix Warranty Information.

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**! IMPORTANT:** When repairing rigid plastics, numerous factors including, but not limited to, substrate material, age, and thickness, can affect the final appearance and result in swelling or halos. All users are responsible for assuring that **Dual-Mix Rigid Plastic Repair Material** is suitable for their needs, environment, and use.

## PREP

### FOR REPAIRING

Use masking tape to mask any exposed fibers prior to cleaning.

Clean surfaces with **Plastic & Leather Prep**, **SEM Solve** or **XXX Universal Surface Cleaner**. Do not saturate exposed fibers.

### FOR BONDING

Clean surfaces with **Plastic & Leather Prep**, **SEM Solve** or **XXX Universal Surface Cleaner**.

Sand with P80 grit sandpaper and blow off to remove dust.

Re-clean with **Plastic & Leather Prep**, **SEM Solve** or **XXX Universal Surface Cleaner**, only if necessary. Do not saturate exposed fibers.

## MIXING

It is recommended that **Dual-Mix Rigid Plastic Repair Material** be dispensed through a **Static Mixer**. It can also be dispensed onto a mixing board and mixed thoroughly by hand. When mixed properly, **Dual-Mix Rigid Plastic Repair Material** should achieve a uniform color. Heat build-up during and after mixing is normal.

## CURING

Parts should remain undisturbed during the interval of time between the material's working time and set time. Temperatures below 55°F (13°C) will slow the cure rate; above 85°F (29°C) will accelerate cure rate. At 70°F (21°C), **Dual-Mix Rigid Plastic Repair Material** sets in 3 hours and can be sanded in 3 – 4 hours. To accelerate cure time, heat set the repair for either 30 minutes @ 140°F (60°C) or 10 minutes @ 180°F (82°C).

## BACK SIDE REPAIR/REINFORCEMENT

Prep as outlined above for repairing.

Cover front side of damaged area with masking tape prior to back side repair.

1. Reinforce large holes and damaged areas from the back side with **Fiberglass Cloth**. Sand with P36 – P80 grit sandpaper or disc 3 – 4 inches around damaged area. Blow off dust with clean, dry, compressed air.
2. Create a patch using a layer of **Fiberglass Cloth** sandwiched between two layers of **Dual-Mix Rigid Plastic Repair Material**.
3. Apply enough material to the back side repair to completely cover the repair area when spread with a plastic spreader.
4. Cut a piece of **Fiberglass Cloth** large enough to cover repair with at least 1 inch of overlap onto non-damaged surface. Attach **Fiberglass Cloth** onto the backside of the repair using a plastic spreader and enough pressure to "seat" the cloth into the adhesive.
5. Apply enough material to the back side repair to completely cover the **Fiberglass Cloth**. Spread with a plastic spreader.
6. Allow **Dual-Mix Rigid Plastic Repair Material** to set by either allowing to air dry, or heat set with a curing lamp or heated paint booth.

## BONDING

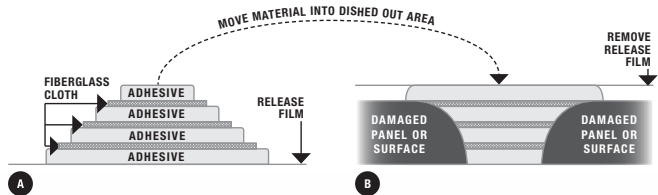
Prep as outlined above for bonding.

1. Apply **Dual-Mix Rigid Plastic Repair Material** to both bonding surfaces. Use enough material to completely fill the joint when parts are clamped. Do not over clamp. To assure maximum bond strength, surfaces must be mated within adhesive's working time.
- ! IMPORTANT:** **Dual-Mix Rigid Plastic Repair Material** is intended for secondary (cosmetic) panels only. Structural components should never be repaired unless specified by the OEM.

## FRONT SIDE/COSMETIC REPAIR

Prep as outlined above for repairing.

1. Sand with P80 grit sandpaper 2 – 3 inches around damaged area.
2. Dish out the damaged area 1 – 2 inches beyond the damage on all sides with a P36 grit grinding disc, making sure to round off any hard edges around the repair area. Blow off dust with clean, dry, compressed air.
3. Construct a pyramid shaped patch matching the size of the dished area using progressively smaller, alternating layers of **Fiberglass Cloth** and **Dual-Mix Rigid Plastic Repair Material** onto a piece of **Release Film**. See illustration **A**.
4. Place pyramid shaped patch into dished area and roll with **Fiberglass Roller** to press patch into repair and remove air pockets. See illustration **B**.



5. Leave **Release Film** on surface and allow **Dual-Mix Rigid Plastic Repair Material** to set.
6. After **Dual-Mix Rigid Plastic Repair Material** has set and cooled completely, remove **Release Film**. Sand with P80 grit sandpaper, then P180 grit sandpaper. Blow off dust with clean, dry, compressed air.
7. **Dual-Mix Rigid Plastic Repair Material** can also be used as a skim coat, if necessary, to fill in any errant sand scratches, grind marks or pin holes. **Carbo Fill+™** is also recommended for skim coating applications and does not require heat cure, allowing for a faster repair. Sand with P180 grit sandpaper.
8. Blow off dust with clean, dry, compressed air. Prime and refinish per manufacturer's instructions.

Refer to the **Rigid Plastic Repair Material Technical Data Sheet** for more detailed instructions and information.



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Learn about Dual-Mix  
Rigid Plastic Repair Material  
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