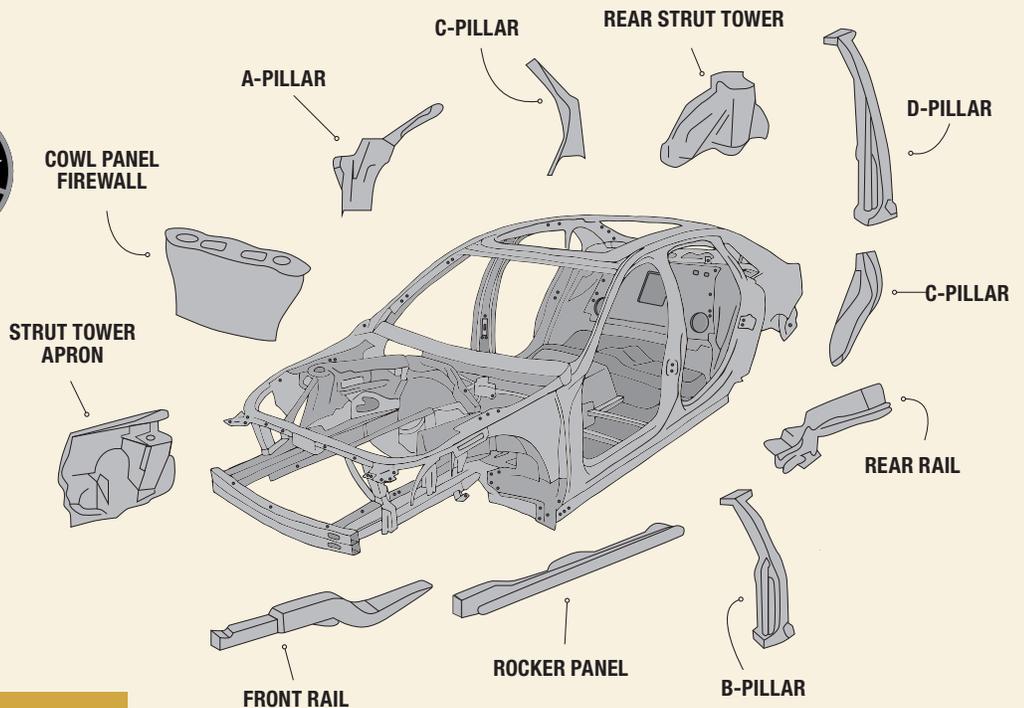


# DUAL-MIX™

## STRUCTURAL IMPACT RESISTANT ADHESIVE

### TYPICAL USES



39757

- OEM recommended
- Dual-Mix Forever Warranty
- Superior impact and peel strength
- Excellent corrosion resistance
- Minimized down times with multiple heat cure options
- 60 minute working time
- Spacer beads for consistent bond line thickness
- Rivet and weld bonding compatible



## STEP 1 PREP

Pre-fit all parts to ensure proper alignment and clearance. All means of fastening should be planned during the pre-fit. Clean surfaces to be bonded with **SEM Solve** or **XXX Universal Surface Cleaner**.

Grind each surface with a P80 grit grinding disc at a lower speed to maintain grinding marks. Do not grind at high speed.

Blow off with clean, dry, compressed air.

Re-clean surfaces with **SEM Solve** or **XXX Universal Surface Cleaner** if necessary.

**SMC and Fiberglass:** Panel must be completely dry before applying adhesive. Do not saturate exposed fibers.



### SEM Solve

A virgin solvent blend to clean panels prior to refinish or repair.

Part	Size
38371	Gallon
38373	20 oz. Aerosol
38374	Quart



### XXX Universal Surface Cleaner

A super compliant, waterborne cleaner that removes solvent and water soluble contaminants prior to refinishing.

Part	Size
77771	Gallon
77774	Quart

## STEP 2 MIXING

Place cartridge into **Universal Manual Applicator** or **Universal Pneumatic Applicator**.

Remove retaining nut and red insert. To maintain product quality, replace after use.

Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally.

Install static mixer. Dispense 2 – 3 inches of test material to make certain color is uniform prior to applying to job.



### Universal Manual Applicator

Part	Size
71119	1 Each



### Universal Pneumatic Applicator

Part	Size
70039	1 Each



### Integral Nut Square Static Mixers

Part	Size
70011	6 Pack
70012	50 Pack

## STEP 3 APPLY

Apply product to both bonding surfaces and tool with a spreader or acid brush covering all exposed bare metal. Use enough material to completely cover and fill the joint when bonded and clamped. Always follow step by step directions enclosed with cartridge. To assure maximum bond strength, surfaces must be mated within the adhesives working time.

Fastening with squeeze type resistance spot welding, rivets or MIG must be performed during the adhesives working time. Failure to do so will result in loss of adhesion and corrosion protection.

### Related Products

Part	Description	Size
39357	Flexible Urethane Foam*	7 oz. Cartridge
39573	Rust Preventer Cavity Wax*	24 oz. Aerosol
39574	Rust Preventer Cavity Wax*	Quart
39783	Weld-Thru Primer	16 oz. Aerosol
39977	Panel Vibration Control Material*	7 oz. Cartridge
39997	Rigid Urethane Foam*	7 oz. Cartridge
40783	Copperweld™ Primer*	20 oz. Aerosol
40786	Brushable Copperweld	8 oz. Can

\*OEM recommended



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Learn about Structural Impact Resistant Adhesive  
[semproducts.com/sira](http://semproducts.com/sira)