



DUAL-MIX™ QUICK SET 20

TECHNICAL DATA SHEET



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

DESCRIPTION

Dual-Mix Quick Set 20 is a two-component, general purpose, urethane adhesive with a 20 second set time, designed for repair and bonding of most plastic, steel, aluminum, glass, SMC and fiberglass parts.

FEATURES

- Dual-Mix Forever Warranty
- OEM recommended
- High strength and sandable
- Bonds multiple substrates
- Non-sag formula
- Very fast setting

SUITABLE SUBSTRATES

- Primed or painted surfaces
- Plastic
- Bare metal
- SMC
- Fiberglass
- Glass
- Concrete
- Steel
- Aluminum
- Wood

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
40202	Dual-Mix Quick Set 20	Clear	1.7 oz. Cartridge
40207	Dual-Mix Quick Set 20	Clear	7 oz. Cartridge

Working time:	15 seconds @ 70°F (21°C)
Set time:	20 seconds @ 70°F (21°C)
Cure time:	15 minutes @ 70°F (21°C)
Lap shear @70°F (21°C) (psi) on steel:	2300+ ASTM D 1002

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HANDLING AND APPLICATION



PREPARATION:

FOR PLASTIC:

1. Clean with **Scuff & Clean** and rinse with water.
2. Clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.
3. Sand area to be repaired with P24 – P36 grit paper and blow off dust.
4. For application on TPO, EPDM, PP and other similar thermoplastics, use **Plastic Adhesion Promoter** or **XXX Adhesion Promoter** per instructions.

Note: **Plastic Adhesion Promoter** or **XXX Adhesion Promoter** must be completely flashed before application of top coat.

FOR METAL:

1. Clean with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Sand with P80 grit paper and blow off dust.
3. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

FOR SMC OR FIBERGLASS:

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

Note: Use masking tape to mask any exposed fibers prior to cleaning and always use clean, lint-free towels when cleaning surfaces to avoid lint and particle contamination.

2. Sand with P80 grit sandpaper and blow off dust.

FOR GLASS:

1. Clean with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Sand the surface when possible with P80 – P180 grit sandpaper.
3. Re-clean with **SEM Solve** or **XXX Universal Surface Cleaner**.

FOR CONCRETE OR WOOD:

Note: Surface must be clean, dry and free of any contaminants before applying adhesive. Sanding wood will help with adhesion.

MIXING:

Place cartridge into the **Universal Manual Applicator** or **Universal Pneumatic Applicator**. To remove cap, insert flat head screwdriver into slot and pry upward.



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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 squares, then snap back into place.

STATIC MIXERS:

Part:	Product Name:	For:	Container:
70011	Integral Nut Square Static Mixer	7 oz. cartridge	6 Pack
70012	Integral Nut Square Static Mixer	7 oz. cartridge	50 Pack
70020	1.7 oz. Turbo Static Mixer	1.7 oz. cartridge	6 Pack
70021	1.7 oz. Turbo Static Mixer	1.7 oz. cartridge	50 Pack



APPLICATION:

GENERAL PURPOSE BONDING:

1. Prepare surface as outlined in Preparation section.
2. Dry fit parts to ensure proper alignment.
3. For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied.

Note: Do not allow **Dual-Mix™ Quick Set 20** to flow over masked area or onto painted surface.

4. Apply **Dual-Mix Quick Set 20** to either surface.
5. Quickly bond the two surfaces. Hold or clamp together until set.

FOR TAB REPAIR USING PLASTIC REPAIR CONTOURING TAPE:

1. Prepare surface as outlined in Preparation section.
2. For badly torn damage, drill 1/8" holes approximately 1/2" apart into the repair area. This will help lock the repair material in place.
3. Cut a piece of **Plastic Repair Contouring Tape** twice the length of the repair.
4. Dispense **Dual-Mix Quick Set 20** onto **Plastic Repair Contouring Tape**. Quickly apply both to the repair area and mold into shape using gloved hands or a spreader.
5. Allow the repair material to cure for 5 minutes before removing the plastic film.
6. Sand with a P80 – P180 grit disc to desired shape and drill as needed.

Note: WORK QUICKLY! The repair material will set in 20 seconds.

CAUTION:

Dual-Mix Quick Set 20 can get very hot while curing.



STORAGE:

Dual-Mix Quick Set 20 should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Dual-Mix Quick Set 20** is 1 year when stored under optimal conditions.



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RELATED PRODUCTS

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Quart
70007	Plastic Repair Contouring Tape	15' Roll
70011	Integral Nut Square Static Mixers	6 Pack
70012	Integral Nut Square Static Mixers	50 Pack
70019	1.7 oz. Manual Applicator	Each
70020	1.7 oz. Turbo Static Mixers	6 Pack
70021	1.7 oz. Turbo Static Mixers	50 Pack
70039	Universal Pneumatic Applicator	Each
71119	Universal Manual Applicator	Each
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart
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.

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