



# 39337 DOOR SKIN & SMC ADHESIVE

## TECHNICAL DATA SHEET

### Description

**39337 DOOR SKIN & SMC ADHESIVE** bonds metal door skins to door frames and SMC panels to SMC and metal. The non-sag formulation allows for easy use at any angle, and the epoxy technology provides excellent strength, corrosion protection and a long shelf life.

### Features

- Epoxy technology
- Non-sag formulation
- Isocyanate free
- Bonds multiple substrates
- Long shelf life
- DUAL-MIX™ Forever Warranty

### Typical Properties

Container	7 oz. <b>DUAL-MIX</b> cartridge
Color	Black
Working time	25-30 minutes @ 70°F (21°C)
Set time	1 hour @ 70°F (21°C)
Cure time	24 hours @ 70°F (21°C)
Lap shear @ 77°F (25°C) (psi) on steel	2700-2800 ASTM D 1002
Bond line thickness	0.0005-0.007" (0.0127-0.1778 mm)

### Handling and Application

**PREPARATION:** Surfaces to be bonded should be cleaned as recommended in the Application section below.



#### MIXING:



Place cartridge into **70029 DUAL-MIX APPLICATOR GUN** or **70073 2:1 MANUAL APPLICATOR GUN**. To remove cap, insert flat head screwdriver into slot and pry upward. **NOTE:** For cap replacement, match circles and square, and snap back into place. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer. Cut tip to desired application size. Avoid marbling.

**Use Static Mixers:** **70011 INTEGRAL NUT SQUARE STATIC MIXERS** (6 pack) or **70012 INTEGRAL NUT SQUARE STATIC MIXERS** (50 pack)

#### APPLICATION:



#### Door Skin Replacement

1. Clean with **38373 SEM SOLVE**. Remove all loose paint, scale and rust from surfaces to be bonded.
2. Grind all surfaces to be bonded with a 36 grit disc. Blow off dust and re-clean with **38373**.
3. Dry fit panels to ensure proper alignment prior to applying adhesive.
4. Apply a 1/8" bead of **39337** to the inside edge of door skin or the inside edge of door frame.
5. Using a spreader, tool the adhesive evenly along the bond line.
6. Install door skin and crimp door skin flange.
7. Clean excess **39337** and seal crimped seam with **39377 SEAM SEALER**.

## APPLICATION

Cont’:



### SMC Panel Replacement

1. Remove damaged panel according to manufacturer’s recommended procedure. Remove any adhesive remaining on space frame with a 24 grit disc. Prime any bare metal exposed on the space frame.
2. Cut the new panel to fit using a cut-off wheel.
3. Clean all surfaces to be bonded with **3833( ) SCUFF & CLEAN** and rinse with water.
4. Next, clean with **38353 PLASTIC/LEATHER PREP**.
5. Grind surfaces to be bonded on replacement panel and space frame with a 24 grit disc.
6. Apply a  $\frac{3}{8}$  –  $\frac{1}{2}$ ” bead of **39337** to the bond line of the replacement panel. Using a spreader, tool the adhesive evenly along the bond line. This bead will serve as the adhesive and environmental seal for the interior of the unit.
7. Fasten the replacement panel to the space frame with mill and drill pads; or for SMC to SMC applications, use set screws or clamps. Clamps may be removed in 2 hours.

**NOTE:** One 7 oz. **39337** cartridge delivers 156” –  $\frac{3}{8}$ ” bead or 104” –  $\frac{1}{2}$ ” bead.

**NOTE:** To assure maximum bond strength, surfaces must be mated within the adhesive’s working time.

**NOTE: 39337 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.**

**STORAGE:**



**39337 DOOR SKIN & SMC ADHESIVE** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **39337** is 2 years when stored under normal conditions.

### **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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Users should review the Material Safety Data Sheet (MSDS) 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 MSDS and product label are available upon request.

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