



39927 and 39708 FLEXIBLE SEM-WELD

TECHNICAL DATA SHEET

Description

39927 and **39708 FLEXIBLE SEM-WELD** are epoxy repair materials that provide durable and flexible repairs when working with urethane and other plastic parts such as PUR, RIM and TPUR.

Features

- State of the art epoxy technology
- Superior adhesion
- Does not shrink or pinhole
- Zero VOC
- Excellent sanding and featheredge
- No adhesion promoter necessary
- **DUAL-MIX™ Forever Warranty**

Typical Properties

Containers	39927: 7 oz. DUAL-MIX cartridge
Color	39708: 10 oz kit
Working time	Black
Set time	3-5 minutes @ 70°F (21°C)
Sand time	5-10 minutes @ 70°F (21°C)
Cure time	15-20 minutes @ 70°F (21°C)
	1 hour @ 70°F (21°C)

Handling and Application

PREPARATION:



Suitable substrates- PUR, RIM and TPUR.

1. Clean with **3833() SCUFF & CLEAN** and red scuff pad. Rinse with water and dry.
2. Clean with **38353 PLASTIC/LEATHER PREP**. Apply per directions.
3. Sand with 80 grit paper 2-3 inches around the damaged area.
4. “V” groove damaged area with a 24 grit disc. Grind slowly. Excess heat may seal the pores of the plastic making adhesion difficult.
5. Re-clean with **38353**.

MIXING:



39927 - Place cartridge into **70029 DUAL-MIX APPLICATOR GUN**. Remove cartridge tip. Prior to installing static mixer, equalize cartridge by dispensing product until both parts flow equally. Install static mixer and cut tip to desired bead size. Dispense 2-3 inches of test material to make certain color is uniform prior to applying to job. Avoid marbling.

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

39708 - Squeeze out equal amounts of A and B. Mix well to obtain a uniform mixture with no streaks.

APPLICATION:



1. Reinforce large holes and damaged areas from the back side with **70006 PLASTIC REPAIR REINFORCING TAPE**. In such cases, clean the back side of the area with **3833()** and **38353**. Grind with a 24 grit disc at low RPM. Place **70006** over the repair. Apply **FLEXIBLE SEM-WELD** and spread firmly.
2. Apply **FLEXIBLE SEM-WELD** to the repair area. Press firmly to eliminate air pockets. Apply higher than surrounding area to allow for sanding.
3. After **FLEXIBLE SEM-WELD** has cured for 15-20 minutes, sand first with 80 grit, then finish with 180 grit paper.
4. For slight imperfections, reapply a skin coat of **FLEXIBLE SEM-WELD** or use **39482 FLEXIBLE POLYESTER GLAZE**.
5. To fill sand scratches and prepare surface for painting, apply **3913() FLEXIBLE PRIMER SURFACER**, **420()3 HIGH BUILD PRIMER SURFACER** or **39624 WORLD CLASS™ FLEXIBLE PRIMER SURFACER**.

STORAGE:



39927 and **39708 FLEXIBLE SEM-WELD** should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **39927** and **39708** 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.

DISCLAIMER: The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

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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