

Technical Data Sheet

Control Flow Seam Sealer is a two-part, non-sagging epoxy that is ideal for sealing vertical and horizontal seams and joints on automobiles and trucks. It features a 15 -20 minute work time and is paintable in 45 minutes. Control Flow Seam Sealer is 100% solids so it will not shrink, harden or crack.

SUITABLE SUBSTRATES

Substrate		Substrate		Substrate	
Bare Steel	✓	Raw Plastic - Rigid (SMC, BMC) +	✓	Primer - Self-Etching	✓
Bare Galvanized	✓	Raw Plastic - Flexible (ABD, PPO) +	✓	Primer - 1K	
Bare Aluminum	✓	Raw Plastic - Soft (PUR) +	✓	Primer - 2K	✓
OEM E-Coat**	✓	Plastic Part - Primed ++	✓	OEM Finish & Old Paint Work - Reversible	
Fiberglass/SMC Gel Coat	✓	Body Filler	✓	OEM Finish & Old Paint Work - Non-Reversible	✓

** Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

+ Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

++ Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.

MIXING



By Volume: 1:1

FLASH TIMES/DRY TIMES



Work time: 15-20 minutes
Paint time: 45-60 minutes
Sand time: 45 minutes
Cure time (delivery): 1.5-2 hours
Cure time (full strength): 6-8 hours

SURFACE PREPARATION



Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394. Prime bare metal with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series.

* For more information on surface prep and application refer to next page.

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.
- See next page for more detailed production application.

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SURFACE PREPARATION

Cleaning & Sanding: Use SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 to clean surface. Bare metal should be primed with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series. Using an air gun, blow surface to be applied to remove all dust and wipe clean with a tack cloth.

CARTRIDGE PREPARATION & APPLICATION

Cartridge Preparation: Install Control Flow Seam Sealer into dual cartridge applicator gun (4440), remove nose plugs and equalize the cartridge. Install static mix nozzle and trim to desired bead size. Dispense until color is a light gray (about a 6" - 8" bead) and discard. Note: If the color appears too dark, it is an indication of an improper mix and the material will not fully cure.

Application: Dispense seam sealer into seam or joint. Smooth out if desired with tool or featheredge. Can be sanded in 45 minutes. Allow to dry 45 minutes before painting.

Note: Material may set up in nozzle if left standing more than 5 minutes (depending upon the temperature and humidity). When storing cartridges, leave mixing nozzle in place. Before next use, replace with a new nozzle.

PRODUCT SPECIFICATIONS

Color: Gray	Shelf Life: 1 year
RTU Solids: 100%	Size: 7 fl oz (207 ml)

REGULATORY

Category: Sealant			
VOC Actual	Part A - 0.05 #/gal (6g/l) Part B - 0.06 #/gal (7g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	Part A - 0.05 #/gal (6g/l) Part B - 0.06 #/gal (7g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	0	Density of Material #/gal	9.8
Weight % of Water	0		