

Technical Data Sheet

Ultra Flex® Sprayable Seam Sealer is an iso-free, multi-purpose sprayable sealant. It may be applied by caulking gun or spray equipment and is easily extruded and tooled. Ultra Flex® Sprayable Seam Sealer is a moisture curing sealant developed for automotive and industrial applications requiring elasticity, high strength and excellent adhesion. The product is tough, elastic and waterproof. It bonds aggressively to steel, aluminum, galvanized metal, fiberglass, urethane, epoxy, polyester, water-based primers, glass, Styrofoam® and many plastics.

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: Ready to use

FLASH TIMES/DRY TIMES



Work time: 10 minutes
 Paint time: 15 minutes to 48 hours
 Skin time: 35 minutes
 Full cure time: 12-24 hours (3/4" per 24 hours)

SURFACE PREPARATION



Clean with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

* 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: Surfaces must be clean and free from wax, silicone or grease. Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

APPLICATION

Application: Apply bead of sealant along seam to be sealed. Sealant may be tooled as desired, and holds brush marks very well. Full cure will be achieved in 12 – 24 hours depending on humidity and material thickness.

NOTE: Product can be painted after 15 minute flash. If product is to be painted, it must be painted within 48 hours to assure proper adhesion. If it is not painted within 48 hours, simply apply one coat of TPO Adhesion Promoter 1021 at any time after 48 hours prior to applying subsequent coats.

TIP: Another strategy for handling extended paint times is to apply 2 in 1 Primer 4603/4613/4623/4633 after a 15 minute flash over the Ultra Flex® Sprayable Seam Sealer, then abrade with a scuff pad (red or gray) and degrease prior to painting.

TIP: To save unused material for later use, leave the plastic nozzle on the cartridge. This will keep moisture from entering the cartridge and curing the material. Simply replace the nozzle with a new one the next time you use the product.

Application with 4435 Sprayable Seam Sealer Gun

To use as a sprayable seam sealer, point the gun at the object to be treated and press the trigger. Keep the gun between 4-12 inches (10-30 cm) away from the surface depending on what result you wish to obtain. When you have finished spraying, disconnect the air supply and hang the gun on a fastening hook to store it.

Refer the Technical Datasheet for #4435 Sprayable Seam Sealer Gun for spraying application.

Adjusting the product atomization: Turn the Air Control Knob clockwise to close the air passage gradually. This will reduce the atomization and make the texture rougher. Turn the Air Control Knob counter-clockwise to increase the atomization and spray a smoother texture.

Adjusting product quantity: Turn the Product Control Knob clockwise to gradually increase product flow. Turn counterclockwise to decrease the flow.

Combination adjustments: By adjusting both the Air and Product control knobs in combination you can achieve a variety of textures and widths of the product beads.

Adjusting total incoming air flow: If you have the optional Air Flow Regulator attached you can control the incoming air flow by turning the Regulator clockwise to increase the flow and counterclockwise to decrease the flow.

Note: The width of the product bead depends less upon adjusting the control knobs and more on the distance of the gun from the surface you are spraying.

PRODUCT SPECIFICATIONS

Color: Gray	Shelf Life: 10 months
RTU Solids: 99%	Size: 11 fl oz (305 ml)

REGULATORY

Category: Adhesive			
VOC Actual	0.44 #/gal (53 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	0.44 #/gal (53 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	3.37	Density of Material #/gal	12.5
Weight % of Water	0		

PHYSICAL PERFORMANCE PROPERTIES

- Shore A Hardness 35
- Elongation 575%
- Tensile strength 210 psi
- Cold temp resistance @ -20°F (-28°C) remains flexible
- Heat temp resistance @ 200°F (93°F) no degradation