

Duramix™ Super-Fast Adhesive

4747

Quick Bonding with Super-Fast Semi-Rigid Adhesive

Application Guide

October, 2002

Bonding Instructions

1. Clean the bonding surfaces with Duramix™ Plastic Parts Prep-Cleaner #4910.
2. Thoroughly dry both surfaces with a clean lint-free cloth.
3. Dry fit the pieces to be bonded to ensure a proper fit.
4. Prepare the Duramix™ Super-Fast Adhesive #4747 cartridge according to the instructions on the back of this page.
5. Apply adhesive #4747 to either part.
6. Work quickly and mate the pieces together.
7. Hold the pieces together for 30 seconds.

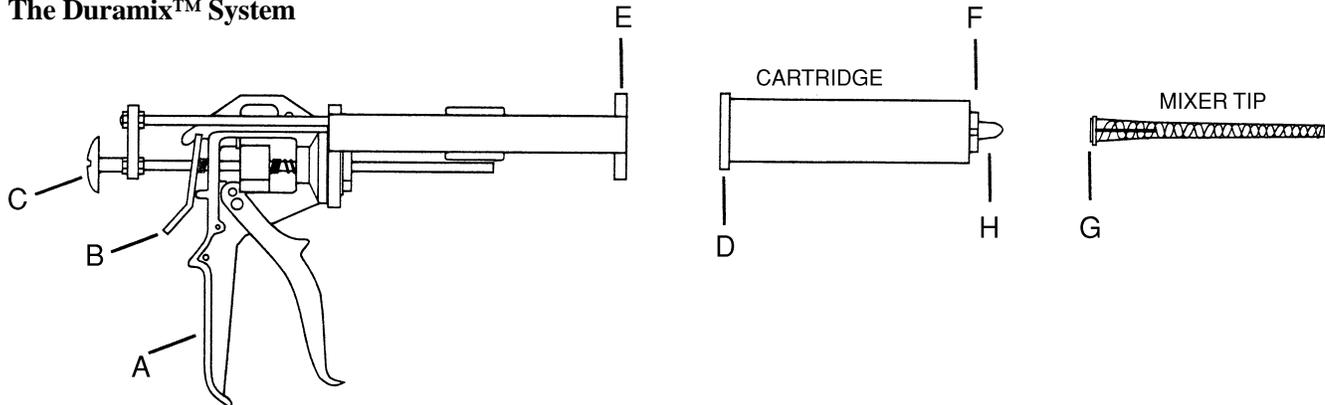
Advantages Over Cyanoacrylate Adhesives:

- Does not require a separate accelerator
- Has excellent wide gap filling capabilities
- Is not brittle like cyanoacrylate adhesive
- Withstands wide temperature ranges
- Does not run or sag

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The Duramix™ System



HOW TO USE THE DURAMIX™ MIXER

1. Slide pushrods to full back position
 - a.) Hold handle (A)
 - b.) Push release lever (B)
 - c.) Pull knob (C)
2. Place Duramix™ cartridge into holder
 - a.) Insert with notched side of flange (D) down
 - b.) Place cartridge nose through opening in mount (E)
3. Slide pushrods forward
 - a.) While depressing lever (B)
 - b.) Push the knob on back of gun forward (C)

PREPARING THE CARTRIDGE

1. Remove cartridge tip
 - a.) Cut seal at bayonet notch (H) with razor blade or knife
2. Equalize the components
 - a.) Load cartridge into gun as described above
 - b.) Squeeze trigger to discharge small amount of each component
 - c.) If cartridge is clogged, clear with pin
 - d.) Discharge components again—both should flow evenly
 - e.) **DO NOT USE EXCESSIVE FORCE – THIS COULD CAUSE CARTRIDGE TO BURST**
3. Attach the static mixer tip
 - a.) Push mixer tip flange (G) onto cut bayonet (H)
 - b.) Twist the mixer tip 1/2 turn to lock it under the cartridge ears (F)

DISPENSING THE PRODUCT

1. Dispense Duramix™ adhesive
 - a.) Squeeze the trigger to push the two components through the static mixer tip
2. Keep Duramix™ adhesive flowing
 - a.) Do not allow Duramix™ adhesive to exceed its maximum dwell time in the static mixer tip

STORING DURAMIX™ PRODUCTS PROPERLY

1. One (1) year shelf life can be realized by storing unopened package at temperatures of 65°F-85°F (18°C-29°C) in a dry place.
2. After opening, keep mix tip on to serve as a cap. Store cartridge in rack #4934 or #4935 with the mix tip facing down. Consult your supplier for these items.

PRODUCT INFORMATION AND PROPERTIES

Duramix™ Super-Fast Adhesive #4747

Working Properties

Dwell Time: 10 Secs.

Work Time: 20 Secs.

Bond Time: 30 Secs.*

Cure Time: 60 Mins.*

*These times are for best results at 75°F (24°C). These times will be longer in colder temperatures. As a general rule, for every 20°F (11°C) below 75° (24°C), these times will double.

MATERIALS NEEDED:

- Duramix™ Super-Fast Semi-Rigid Adhesive
- Duramix™ Mixer Tips #4909
- Duramix™ Mixer Dispenser #4991

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Precautionary Information

Refer to the Product Label and the Material Safety Data Sheet (MSDS) for health and safety information before using the product. For environmental information, refer to the MSDS. Always wear gloves, eye protection, appropriate respiratory protection, and work in a well-ventilated area.

For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-888-663-1394. Address correspondence to: 3M Automotive Aftermarket Division, 3M Center, Building 223-6N-01, St. Paul, MN 55144-1000. Our fax number is 651-733-9175.

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ISO 9002

This Automotive Aftermarket Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



Automotive Aftermarket Division

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Recycled Paper
40% pre-consumer
10% post-consumer

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