Quick Bonding with Duramix™
Super-fast Semi-Rigid Adhesive

Application Guide

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<th>Bonding Instructions</th>
<th>Uses:</th>
<th>Advantages Over Cyanoacrylate Adhesives:</th>
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<td>1. Clean the bonding surfaces with Duramix™ Plastic Parts Prep-Cleaner #4910.</td>
<td>• Emblems and trim pieces</td>
<td>• Does not run or sag</td>
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<tr>
<td>2. Thoroughly dry both surfaces with a clean lint-free cloth.</td>
<td>• Moldings and impact strips</td>
<td>• Has excellent gap filling capabilities</td>
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<td>3. Dry fit the pieces to be bonded to ensure a proper fit.</td>
<td>• Bumper mounting ears or tabs</td>
<td>• Does not become brittle like cyanoacrylate adhesives</td>
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<td>4. Prepare and equalize the Duramix™ Adhesive #4147 or #4247 cartridge according to the instructions on the back of this page.</td>
<td>• Repair where cyanoacrylate or weather strip adhesive is used</td>
<td>• Withstands wide temperature ranges</td>
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<td>5. Apply adhesive #4147 or #4247 to either part.</td>
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<td>• Does not require a separate accelerator</td>
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<td>6. Work quickly and mate the pieces together.</td>
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<td>7. Hold the pieces together according to the working times listed on the back of this Application Guide.</td>
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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™ Adhesive #4147 or #4247
Working Properties
Dwell Time: 10 Secs.
Work Time: 20 Secs.
Bond Time: 30 Secs.
Cure Time: 1 Hr.

MATERIALS NEEDED:
• Duramix™ Super-Fast Semi-Rigid Adhesive
• Duramix™ Plastic Parts Prep-Cleaner
• Duramix™ Mixer Tips
• Duramix™ Mixer Dispenser

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
ISO 14001
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