

**3M™ Duramix™ Controlled Flow Seam Sealer
4229/08329**

Application Guide

Simple Steps for Product Application

1. Prepare the surface by removing all old sealer material that has cracked or debonded.
2. Prime all cleaned and abraded metal surfaces prior to applying seam sealer(s). If an acid-etch (self-etching) primer is used, a 2K epoxy or urethane primer must be applied before the application of the seam sealer. **DO NOT apply acid-etch primer over seam sealer.**
3. Make sure that the area is completely dry. A heat gun may be used to ensure that there is no moisture in the channel. Bubbling may occur where moisture is present. Allow sufficient time for area to cool back down before applying sealer. Lightly scuff primer prior to applying 3M™ Duramix™ sealer #4229/08329.
4. Level the vehicle and form a dam at the ends of the channel using masking tape.
5. Before filling the channel with the seam sealer, check to see that there is a flush fit at the seam where the roof panel meets the side panel. In seams where the fit is not flush, fill only the gaps with seam sealer and allow the sealer to set up for a few minutes. Once the gaps are filled, you can cosmetically fill the channel to the desired level according to the instructions in step 6. Use only tapered 3M™ Duramix™ Mix Tips #4902 to dispense seam sealer #4227. Mix Tip 08193 will be used with 08329. **Note:** Do not cut tapered nozzle tip as improper mixing may occur.
6. Dispense 3M™ Duramix™ seam sealer #4229/08329 along the center of the channel approximately 1/4" deep until the entire length of the channel is filled. It is important that you keep the mixing tip immersed in the sealer. Failure to do so may create air pockets underneath the surface of the sealer. If the tip must be moved to another location in the channel, be sure to re-immers the tip into the seam sealer.
7. The seam sealers will flow immediately upon dispensing, but will become non-runny in approximately 10 seconds. When applying to sloped areas, dispense the sealer toward the slope. This will allow the sealer to run down the slope as it sets up.
8. Allow sufficient time for the seam sealer to cure prior to painting, typically 30 minutes at 72° F (22° C).
9. If sealer has been allowed to cure longer than 4 hours, lightly scuff to promote adhesion.

Sealing, Priming & Painting

Seal, prime and paint according to paint manufacturer's recommendations for painting flexible plastic parts. (Use only flexibilized acrylic urethane paint systems in accordance with paint manufacturer's recommendations.)

Uses

- Can be used to fill channels and drip rails on all types of vehicles
- Can be used to recreate puddle-type seams
- Can be used to seal water leaks in drip rails and channels
- Remains flexible
- Will not shrink

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

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