

# Duramix™ Universal Adhesive

## 4125

Application Guide

October, 2002

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### Easy Steps To Successful Bonding:

1. Clean all surfaces to be bonded. When bonding SMC and Fiberglass, clean by lightly scuffing the surface with a grade 80 abrasive. Do not use liquid cleaners on SMC and Fiberglass.
2. Scuff the bonding surfaces with a grade 80 abrasive. Remove all corrosion and debris from metal surfaces. When abrading SMC and Fiberglass, be careful not to break through the gel coat. Dry fit all parts prior to applying adhesive.
3. Mask the surfaces adjoining the bonding area in the event of adhesive squeeze-out. Have all clamps on hand and ready to use.
4. When bonding to steel, spread the bead of adhesive #4125 and cover all bare metal to prevent corrosion. When bonding to aluminum, etch the aluminum with Duramix™ Metal Etching Prep #4925.
5. Apply adhesive #4125 in a continuous bead to the parts to be bonded.
6. Starting at one end, align the parts and press into place. Apply clamps to hold the parts in place. The working time is approximately 10 minutes, after which a substantial bond is achieved.
7. Clamps can be removed after approximately 30 minutes.

If body filler is going to be used for contouring or blending, remove all exposed adhesive before applying body filler. **Do not put body filler on top of Duramix™ adhesives.**

**NOTE:** Full cure is achieved in 4 hours. A heat gun or radiant heating can be used to accelerate the cure.

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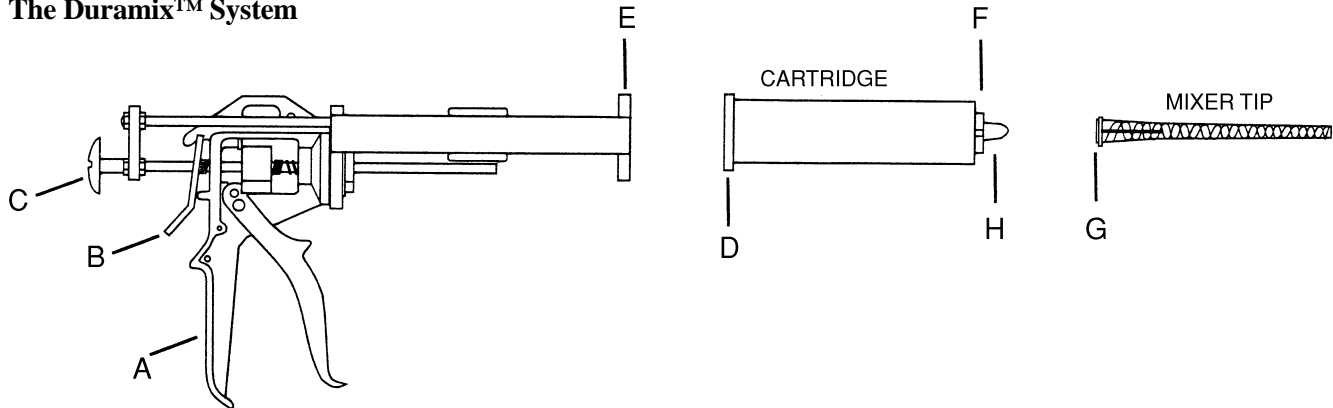
### Uses:

- Bonds light add-on and ground effects parts such as spoilers, flares, skirts, nameplates, side moldings, emblems and impact strips where a flexible adhesive is needed
- Bonds to fiberglass and SMC, urethane, plastics and metals
- Bonds fascias

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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™ Adhesive #4125

#### Working Properties

Dwell Time: 1 Min.  
Work Time: 10 Min.  
Bond Time: 30 Min.  
Cure Time: 4 Hrs.

### MATERIALS NEEDED:

- Duramix™ Universal Adhesive
- Duramix™ Acid-Etch Prep
- Duramix™ Metal Etch Prep
- Duramix™ Mixer Tips
- Duramix™ Mixer Dispenser

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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.

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## 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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## Warranty and Limited Remedy

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### Automotive Aftermarket Division

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