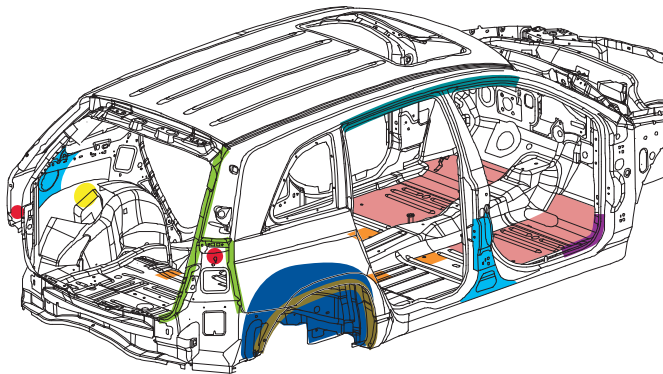




# Sealer/Sound Deadener Repair Guide



- Brushable
- Flowable
- Pumpable
- Resistance Weld-through
- Sealer Tape
- Sprayable
- Thumb Grade
- Non-Structural Flexible Acoustical
- Non-Structural Rigid Acoustical
- Mastic Pads

## SAFETY

This publication's purpose is to provide technical training information to individuals in the automotive trade. All test and repair procedures must be performed in accordance with the manufacturers service and diagnostic manuals. All warnings, cautions and notes must be observed for safety reasons. The following is a list of general guidelines.

- The information in this publication has been developed for service personnel, and can help determine the proper method(s) for repairing paint system repair failures.
- Always wear safety glasses when working on vehicles or vehicle components.
- Wear appropriate shoes and clothing.
- Avoid wearing jewelry, rings, watches and clothing with metal fasteners.
- Long hair can be caught in rotating machinery. Tie back long hair or wear a cap that covers and contains the hair.
- Avoid wearing belts with metal buckles.
- Review Material Safety Data Sheets (MSDS) when there is any question concerning the use, handling or disposal of a product.
- Review material labels for proper use.
- Wear breathing masks when recommended or if specified by state or local requirements.
- Improper service methods may damage the vehicle.

This safety information covers only the situations and procedures DaimlerChrysler Motors Corporation has encountered and recommended. DaimlerChrysler Motors Corporation cannot know, evaluate and advise the service trade of all conceivable ways in which service may be performed, or of the possible hazards of each. Consequently, DaimlerChrysler Motors Corporation has not undertaken any such broad service review. Accordingly, anyone who used a service procedure or tool that is not recommended in this publication, must be certain that neither personal safety, nor vehicle safety, is jeopardized by the service methods they select.

No part of this publication may be produced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording or otherwise, without the prior written permission of DaimlerChrysler Motors Corporation. DaimlerChrysler Motors Corporation reserves the right to make changes from time to time, without notice or obligation in prices, specifications, colors or materials, and to change or discontinue models. See your dealer for the latest information.

Typical Applications		Sealers & Foams									
		Brushable	Flowable	Pumpable	Resistance Weld-through	Sealer Tape	Sprayable	Thumb Grade	Non-Structural Flexible Acoustical	Non-Structural Rigid Acoustical	Mastic Pads
Floor Pan		X		X	X	X	X	X		X	
Body Seam		X		X	X	X	X	X			
Cowl		X		X	X	X		X		X	
Roof			X	X	X	X		X			
Wheel Well		X		X	X		X	X		X	
Trunk		X		X	X	X		X		X	
Door				X		X			X		
Cosmetic Seam				X		X	X				
Pillar		X		X	X	X		X	X		
Fuel Filler		X		X	X	X		X			
Lights				X	X	X		X			
Rocker Panel		X		X	X	X	X	X	X		
Engine Compartment		X		X			X				

## **Identifying Sealers**

Several types of sealers and sound deadeners are used during assembly. Therefore, specific applications may not be identified in this publication. General applications and the various types of products for repair will be featured to identify and replace OEM sealers and sound deadeners.

### **Helpful Sealer Tips**

- Check shelf life or expiration date prior to beginning sealer application.
- Be sure "work-time" is appropriate for sealer application.
- Temperature, humidity and thickness of sealer will affect the work, set and paintable times.
- Test-fit replacement panels prior to installation to insure tight fit and proper seal.
- Equalize 2K products according to adhesive manufacturer's recommendations.
- Always follow manufacturer's recommendations for storage, usage and application to achieve the best performance of the product.

## Terminology

**Work Time:** The length of time a sealer can continue to be applied or tooled effectively.

**Set Time:** Time when there is no longer product transfer.

**Handling Time:** The time when a part can be safely transported and sealer can no longer be tooled or repositioned.

**Full Cure Time:** Time when a sealer has reached it's full strength.

**Paintable Time:** Established time when refinish materials can safely be applied to a sealer.

## Sealers

**Brushable:** Single component sealer applied by brush.

**Flowable:** Sealer with low viscosity and self-leveling characteristics.

**Pumpable:** A two component or one component sealer that seals interior and exterior joints and voids.

**Resistance Weld-through:** Sealer/adhesive that can be used in conjunction with resistance spot welding.

**Sealer Tape:** Preformed Sealer.

**Sprayable:** Sealer applied with pneumatic dispenser to duplicate original textured appearance.

**Thumb Grade:** Heavy bodied sealer for sealing large gaps and filling voids. Should remain soft and pliable

## Sound Deadeners

**Non-Structural Flexible Acoustical:** Flexible foam with sealing and sound deadening properties.

**Non-Structural Rigid Acoustical:** Rigid foam with sealing and sound deadening properties.

**Mastic Pads:** Sound deadener that is preformed to fit a specific area.

## ***Paint & Material Usage***

### **Surface Preparation:**

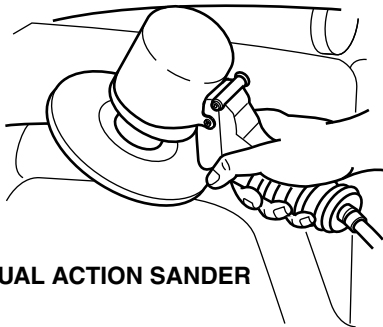
- The first step in any high quality repair is to wash the vehicle with hot, soapy water to remove water soluble contaminants such as dirt, tree sap, brake dust, road salt and bird droppings.
- The next step, after all water contaminants have been removed, is solvent cleaning. This step is designed to remove solvent soluble contaminants such as grease, oil, road tar, waxes, polishes and silicone.

### **Restoring Corrosion Protection:**

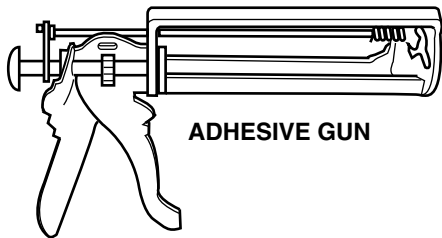
- Always restore OEM corrosion protection, wherever sanding or stripping has penetrated it.
- Always refer to paint manufacturer's recommendation for restoring corrosion protection.
- Always follow proper safety recommendations and utilize the correct safety equipment.

### **Basecoat/Clearcoat System:**

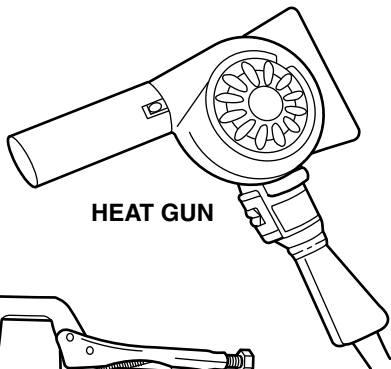
- Use a basecoat/clearcoat system for repair of DaimlerChrysler Motors vehicles, when basecoat/clearcoat was the original equipment finish.
- Never mix a combination of refinishing brands for a single repair.
- Always refer to paint manufacturer's recommendation for mixing and application procedures.



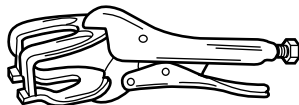
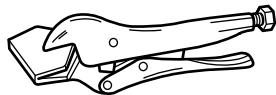
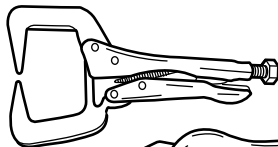
**DUAL ACTION SANDER**



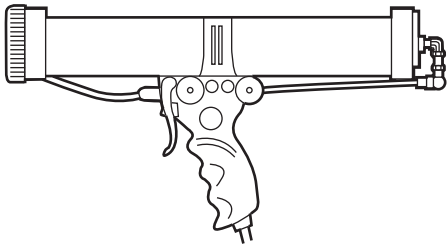
**ADHESIVE GUN**



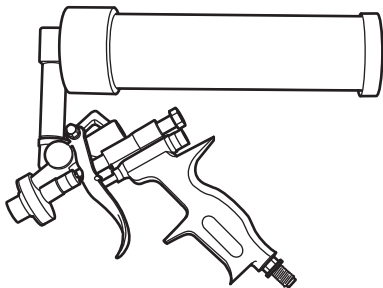
**HEAT GUN**



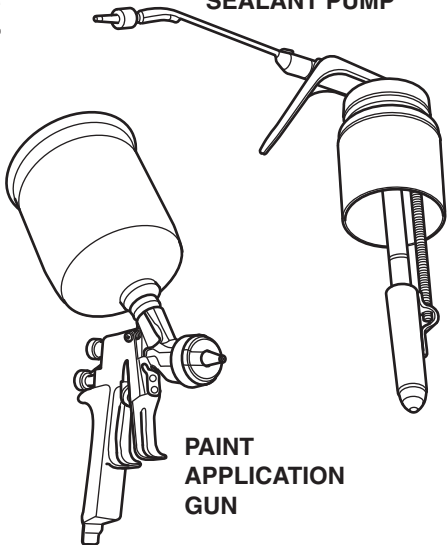
**CLAMPS**



**SRAYABLE SEAM SEALER GUNS**



**FLOWABLE  
SEALANT PUMP**



**PAINT  
APPLICATION  
GUN**

### **Flowable Seam Sealer**

8307 Automix™ Self-Leveling

Flows to level finish

Excellent for roof ditch applications

\*Use 3M 8117 or 9930 applicator gun

### **Sprayable Seam Sealer**

8374 Ultrapro™ MSP Sprayable

Apply with 3M 8400 applicator gun

Can produce bead, sprayed seam, or coating

### **1K/ Pumpable Seam Sealer**

8360/8361 Ultrapro™ Urethane

Reactive cure, no solvent evaporation

Paintable in 30 minutes, brushable

8369/8370 Ultrapro™ MSP

Reactive cure, no solvent evaporation

Paintable immediately, brushable

### **Thumb Grade Seam Sealer**

8578 Strip-Calk Black

“Thumb-in” pre-formed butyl strips

### **2K/ Pumpable Seam Sealer**

8308 Automix™ Heavy Bodied

Can be tooled, will hold on verticals

Can be used in many 1K applications, also

\*Use 3M 8117 or 9930 applicator gun

\*Use with 3M 8200 OEM Tip Kit

### **Brushable Seam Sealer**

8656 Brushable Seam Sealer Gray

Retains brush marks well

1K Pumpable sealers also brushable



**Seam Sealers  
Acoustical Foams**

## **Resistance Weld Through** **8116 Panel Bonding Adhesive**

- Structural adhesive
- Corrosion protection
- Outstanding strength and durability
- Able to resistance spot weld through before cure

## **Sealer Tape**

### **8475 and 8476 Seam Sealer Tape**

- Available in 3/8" (8475) and 7/8" (8476) widths
- Easily conformable to match OEM appearance

3M always recommends putting seam sealers over primer, not on bare metal. This greatly improves corrosion protection. Follow paint manufacturer recommendations for applying paint system

**Seam Sealers**  
**Acoustical Foams**



## **Non-Structural Flexible Acoustical Foam**

### **8463 Automix™ Flexible Foam**

- Flexible acoustical foam
- 10x expansion

## **Non-Structural Rigid Acoustical Foam**

### **8458 Automix™ Pillar Foam**

- Rigid acoustical foam
- 10x expansion

## **Mastic Pads**

A 3M undercoating can be used to produce a sound deadening pad. Use 8883 Underseal™ Undercoating Black or other 3M undercoating to perform this function.

## Flowable Seam Sealers

### 4227 Flexible Self-Leveling Seam Sealer

Flows to level finish

Excellent for roof ditch applications

### 4229 Controlled Flow Seam Sealer

Less flow than 4227, for angled surfaces

Still levels to a smooth finish

\*For seam sealers not found in the Duramix™ line, consider a 3M™ brand sealer



**Duramix™ Sealers and Foams**

## 2K/ Pumpable Seam Sealer

### 4225/4226 Seam Sealers

(Opaque/Black)

All-around urethane seam sealer

Paintable in 1 hour

### 4223 Factory Match Doorskin Sealer

Slight edge flow to match OEM appearance

Paintable in 1 hour

3M/Duramix always recommends putting seam sealers over primer, not on bare metal. This greatly improves corrosion protection. Follow paint manufacturer recommendations for applying paint system



## **Non-Structural Flexible Acoustical Foams**

### **4320 Flexible Foam**

Flexible acoustical foam

10x expansion

### **4350 Semi-Rigid Foam**

For a hardness between 4320 and 4330

10x expansion

### **4374 NVH Damping Material**

No expansion, for tight areas

Excellent damping qualities, stays flexible



**Duramix™ Sealers and Foams**

## **Non-Structural Rigid Acoustical Foams**

### **4330 Pillar Foam**

Rigid Acoustical Foam

10x expansion

All Duramix™ Sealers and foams are applied with the 4997 (manual) or 4947 (pneumatic) applicator guns



# International Epoxies & Sealers™

PRODUCT	IES #(s)	DESCRIPTION	APPLICATION / USES
<b>Be sure to visit us online at <a href="http://www.internationalepoxy.com">www.internationalepoxy.com</a></b>			
<b>INTER-MIX 30</b> Flowable Adhesive / Sealer 30 Minute	IES 8410	A flowable, self-leveling, semi-flexible seam sealer with no tooling required.	Designed for sealing roof seams, drip rails and other horizontal seams. Ford Explorers, Bronco, Escort & Aerostar roof panels and various other horizontal applications.
	Handling: 30 to 45 min. Paintable: 60 min.	Working: 20 to 30 min. Full Cure: 6 to 8 hours	Sandable: 60 min. Note: Ideal for use in heat / baker booths.
<b>INTER-MIX 15</b> Non-Sag Adhesive / Sealer 15 Minute	IES 8411	A non-sagging, semi-flexible adhesive / sealant.	A firm yet flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.
	Handling: 15 to 20 min. Paintable: 45 min.	Working: 15 to 20 min. Full Cure: 6 to 8 hours	Sandable: 45 min. Note: Ideal for use in heat / baker booths.
<b>INTER-MIX 5</b> Non-Sag Adhesive / Sealer 5 Minute	IES 8412	A non-sagging, semi-flexible adhesive / sealant.	A firm yet flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.
	Handling: 5 to 10 min. Paintable: 15 to 30 min.	Working: 5 to 10 min. Full Cure: 6 to 8 hours	Sandable: 15 to 30 min. Note: Ideal for use in heat / baker booths.
<b>INTER-MIX 15</b> Flexible Adhesive / Sealer 15 Minute	IES 8413	A non-sagging, extremely flexible adhesive / sealant.	A firm yet very flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints (pickup beds, hinges).
	Handling: 20 to 30 min. Paintable: 45 min.	Working: 15 to 20 min. Full Cure: 6 to 8 hours	Sandable: 45 min. Note: Ideal for use in heat / baker booths.



Pumpable Sealer



Flowable Sealer

All **INTER-MIX™** and **INTER-FOAM™** products are Made in the U.S.A.  
We are a proud member of I-CAR®



**IES™**  
1-800-451-7206

# International Epoxies & Sealers™

PRODUCT	IES #(s)	DESCRIPTION	APPLICATION / USES			
Be sure to visit us online at <a href="http://www.internationalepoxyes.com">www.internationalepoxyes.com</a>						
INTER-FOAM 5 Flexible Foam 5 Second	IES 8451 IES 8449	A two part flexible urethane foam. Expands 10 times its original volume. Will not bow out body panels.	Stops wind noise, water leaks & flutter in pillar posts, quarter panels, wheel housings & weather strips. Adds reinforcement to panels such as door skin brace, roof and hood panels.			
	Handling Paintable	2 to 3 min. 10 to 15 min.	Working Full Cure	3 to 5 sec. 10 to 15 min.	Sandable	not applicable
INTER-FOAM 10 Rigid Foam 10 Second	IES 8455	A two part rigid urethane foam. Expands 10 times its original volume.	Fills & reinforces pillar posts & box sections. Also stops wind, water & dust leaks. Eliminates panel flutter on cross members & provides sound deadening & compressive strength.			
	Handling Paintable	3 to 4 min. 10 to 15 min.	Working Full Cure	10 to 25 sec. 30 to 45 min.	Sandable	not applicable
SPRAYABLE Seam Sealer Beige / Gray	IES 1587/1588	A permanently flexible rubber base sprayable seam sealer formulated to duplicate automotive OEM coarse textured and beaded seams.	Has excellent adhesion to metal, galvanized steel, rigid plastics, fiberglass and aluminum. Contains no silicone. Paintable when cured.			
INTEGRA Urethane Sealant Black / Gray	IES 1560/1565	A one component polyurethane sealant formulated for a wide variety of bonding and sealing applications.	Tremendous strength and adhesion. Adheres to: steel, aluminum, fiberglass, SMC, most plastics, wood & concrete. Non-corrosive to metallic substrates. Ideal for Uni-Body type vehicles. May be brushed for OE look. Tack free in 15-25 min. Paintable in 15 min. <b>DO NOT USE FOR WINDSHIELD OR BACKGLASS INSTALLATIONS.</b> Note: Ideal for use in heat / baker booths.			



Flexible Foam



Rigid Foam



Sprayable Sealer



Pumpable Sealer



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1-800-451-7206

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# International Epoxies & Sealers™

PRODUCT	IES #(s)	DESCRIPTION	APPLICATION / USES
<b>Be sure to visit us online at <a href="http://www.internationalepoxy.com">www.internationalepoxy.com</a></b>			
<b>SALAMI-PACK</b> Urethane Sealant Gray	IES 1570	Used on automotive seams and joints that need a strong bond and have a lot of mechanical stress, shock, vibration and sudden impact.	Bonds steel, aluminum, SMC, FRP, galvanized, ABS, fiberglass, most rigid plastics, wood and glass. May be brushed for OE look. <b>DO NOT USE FOR WINDSHIELD OR BACKGLASS INSTALLATIONS.</b>  <b>Note: Ideal for use in heat / baker booths.</b>
<b>SPRAY LEAK SEALER</b> Black	IES 4590	Aerosol sealer used to reach hard to get areas.	Formulated to be sprayed through an extension tube to reach hard to get at areas. Seals firewalls, cowl seams, plenum seams, wheel housings, etc.
<b>FIRM &amp; FLEXIBLE</b> Clear	IES 1548	A fast setting, firm yet flexible clear sealant with excellent adhesion to most surfaces.	Will not crack or peel and stays clear. Seals wet or dry. Most automotive paints can be mixed directly into Firm & Flexible. Can be painted over within 30 minutes.
<b>FIRM &amp; FLEXIBLE</b> Black / White	IES 1540/1541 Black IES 1545/1546 White	A fast setting, firm yet flexible automotive seam sealant.	Sets to a firm yet flexible consistency with tremendous adhesion. Will not peel or crack. Seals wet or dry. Skins in approx. 1 minute. Can be painted in 20-30 minutes.



Pumpable Sealer



Sprayable Sealer

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# IES™

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# International Epoxies & Sealers™

PRODUCT	IES #(s)	DESCRIPTION	APPLICATION / USES
<b>Be sure to visit us online at <a href="http://www.internationalepoxy.com">www.internationalepoxy.com</a></b>			
<b>BRUSHABLE SEAM SEALER</b> White	IES 1511	A fast setting, permanent flexible sealant.	Used for sealing vertical and horizontal seams and joints (floor pans, trunks, firewalls, lab seams, etc.) Matches OEM brushed in sealers. Can be painted over in 20-30 minutes. Excellent adhesion to painted, bare or primed metal. Seals wet or dry.
<b>STRIP PUTTY</b> Black 3/16" Bead	IES 1508	A thumbable, easily tooled caulk.	Seals cracks, seams, joints, housings, etc. Will not dry out. Remains flexible. Seals out moisture, air and dust. Paintable immediately. Super feathered edge.
<b>INTER-SEAL</b> Seamtape	IES 70704-70706	INTER-SEAL Urethane Seamtape is a flexible self-adhesive sealing material, designed to cover large gap body seams. Clear in color. Easily conforms to irregular surfaces. Flexible. Paintable immediately.	
<b>NU SEAM</b> Seamtape	IES 70720, 70721	NU SEAM Sealant Tape quickly duplicates the factory appearance, is immediately paintable and has excellent adhesion.	
<b>SOUND DEADENER PADS</b>	IES 1581	Used to replace factory installed pan insulators damaged in collisions. Reduces road noise. Use on floor pans, trunks and door skins. Self adhering and paintable.	
	IES 1585	Elastomeric-type, self adhering. Used to replace factory installed pan insulators and general sound deadening applications. Easily conforms to irregular surfaces without heating. Can be painted with flexible paint.	

 Brushable Sealer
  Thumb Grade
  Sealer Tape
  Mastic Pads












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1-800-451-7206

# LORD Fusor® Automotive Repair Adhesives Sealers and Foams

**LORD**  
AskUsHow™











	WORK TIME	SANDABILITY	PAINTABILITY	HANDLING STRENGTH
<b>Fusor 123/126</b> For DCX 2K Pumpable Applications	5 to 10 min. @ 70°F  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:15 0:30 0:45 1:00 1:15+	10 min. @ 70°F  0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 123EZ/126EZ</b> For DCX 2K Pumpable Applications	10 to 15 min. @ 70°F  5 to 10 min. @ 90° F Hrs:Min 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:15 0:30 0:45 1:00 1:15+	30 min. @ 70°F  0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 112B/113B</b> (MOPAR #05083855AA) For DCX Resistance Weld-through Applications	35 to 40 min. @ 90°F  70 min. @ 70°F Hrs:Min 0:15 0:30 0:45 1:00 1:15+	2.5 to 3 hrs. @ 70°F  0:15 0:30 0:45 1:00 1:15+	8 hrs. @ 70°F  0:15 0:30 0:45 1:00 1:15+	2 to 2.5 hrs.  0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 121/124</b> For DCX Non-structural Flexible Acoustic Foam Applications	5 to 8 min. @ 70°F  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:15 0:30 0:45 1:00 1:15+	10 min. @ 70°F  0:15 0:30 0:45 1:00 1:15+	Full expansion in 2 to 3 min.  0:30 1:00 1:30 2:00 2:30 3:00+

# LORD Fusor®

## Automotive Repair Adhesives Sealers and Foams

# LORD

AskUsHow™

	WORK TIME	SANDABILITY	PAINTABILITY	HANDLING STRENGTH
<b>Fusor 800EZ/801EZ/803EZ For DCX 1K Pumpable Applications</b>	30 min.  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:15 0:30 0:45 1:00 1:15+	10 min.  0:15 0:30 0:45 1:00 1:15+	3 to 4 hrs.  0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 804/805 For DCX Sprayable Applications</b>	15 min. @ 70°F  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:15 0:30 0:45 1:00 1:15+	Immediately or within 4 days 0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 122EZ/125EZ For DCX Flowable Applications</b>	6 min. @ 90°F (32°C) 8 to 9 min. @ 70°F  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	30 min. @ 70°F  0:15 0:30 0:45 1:00 1:15+	30 min.  0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:30 1:00 1:30 2:00 2:30 3:00+
<b>Fusor 129 For DCX Flowable Applications</b>	5 to 8 min. @ 70°F  Hrs:Min 0:15 0:30 0:45 1:00 1:15+	30 min.  0:15 0:30 0:45 1:00 1:15+	30 min.  0:15 0:30 0:45 1:00 1:15+	Not Applicable 0:30 1:00 1:30 2:00 2:30 3:00+

## SIKKENS PAINTING RECOMMENDATIONS FOR ADHESIVES, SEALERS AND FOAMS

### 1. Prime Bare Metal



100 parts Autosurfacer  
50 parts Autosurfacer EP Hardener  
30 parts High Performance Reducer

### 2. Seal



100 parts Colorbuild  
50 parts Colorbuild Sealer Hardener  
30 parts High Performance Reducer

### 3. Color



2 parts Autobase Plus Mixed Color  
1 part High Performance Reducer

### 4. Clear



100 parts Autoclear III  
50 parts Standard Hardener  
30 parts Activator

See TDS for further  
information



## SIKKENS PAINTING RECOMMENDATIONS FOR ADHESIVES, SEALERS AND FOAMS

Autosurfacer EP  
Colorbuild  
Autobase Plus  
Autoclear III



Adhesive

N/R

33%

10%

10%

Sealant

N/R

33%

10%

10%

Foam

N/R\*

50%

10%

25%

Use Chart to determine if flex agent is required

Use Elast-O-Actif in Colorbuild and Autoclear III

Use Standard Hardener in Autobase Plus

Add Elast-O-Actif (or Hardener in AB + ) before hardener and reducer/activator

\* Do not use Autosurfacer EP on Foam

## SIKKENS PAINTING RECOMMENDATIONS FOR ADHESIVES, SEALERS AND FOAMS

Refer to accompanying product chart for specific application recommendations

If the sealant or adhesive has cured longer than the maximum paintable time then abrade the sealant or abrasive with a red scuff pad (e.g., 3M 07777) prior to painting

Some application require the addition of flex agent for proper paint system performance. Refer to accompanying additive chart for specific recommendations.

Prime all bare metal surfaces with Autosurfacer EP prior to painting

Autosurfacer EP should be applied to bare metal areas prior to applying sealants, adhesives or foams unless otherwise noted by the product manufacturer

Do not apply wet-on-wet sealers or topcoat systems to glass mount areas.

## PAINTING RECOMMENDATIONS FOR SEALERS, ADHESIVES AND FOAMS

**LESONAL**

Gray Epoxy  
Primer Sealer



2 parts Epoxy Primer Sealer  
1 part Epoxy Hardener Plus  
20% Reducer

Gray Urethane Surfacer



3 parts Gray Urethane Surfacer  
1 part Urethane Surfacer Hardener

Basecoat SB



2 parts Basecoat SB Color  
1 part Reducer

Glamour Clear



2 parts Glamour Clear  
1 part Clear Hardener  
20% Glamour Clear Reducer

Consult TDS Manual for more details



## PAINTING RECOMMENDATIONS FOR SEALERS, ADHESIVES AND FOAMS

**LESONAL**

REFER TO ACCOMPANYING PRODUCT CHART FOR SPECIFIC APPLICATION  
RECOMMENDATIONS

IF THE SEALANT OR ADHESIVE HAS CURED LONGER THAN THE MAXIMUM PAINTABLE TIME  
THEN ABRASE THE SEALANT OR ABRASIVE WITH A RED SCUFF PAD (E.G., 3M 07777) PRIOR  
TO PAINTING

SOME APPLICATION REQUIRE THE ADDITION OF **LESONAL FLEX ADDITIVE** FOR PROPER  
PAINT SYSTEM PERFORMANCE. REFER TO ACCOMPANYING ADDITIVE CHART FOR SPECIFIC  
RECOMMENDATIONS.

PRIME ALL BARE METAL SURFACES WITH **LESONAL EPOXY PRIMER** PRIOR TO PAINTING

**LESONAL EPOXY PRIMER** SHOULD BE APPLIED TO BARE METAL AREAS PRIOR TO  
APPLYING SEALANTS, ADHESIVES OR FOAMS UNLESS OTHERWISE NOTED BY THE PRODUCT  
MANUFACTURER

DO NOT APPLY WET-ON-WET SEALERS OR TOPCOAT SYSTEMS TO GLASS MOUNT AREAS.

Consult TDS Manual for more details





**MOPAR®**

10 Oz. Cartridge

MSQ: 1 Cartridges

**Part No. 04318026**



## **PAINTABLE REPAIR SEALER**

Excellent panel sealant, particularly in appearance areas. Fast-skinning surface that dries tack-free and can be painted in 30 minutes. Flows at temperatures above 50° F. Will not harden or crack.



High-strength structural acrylic adhesive for bonding bare metal cosmetic panels. Excellent for resistance weld bonding.

70 minute work time @ 70° F.

Handling strength in 2 1/2 hrs.

Full cure in 8 hrs.

7.6 Oz. Tube    MSQ: 1 Tube

**Part No. 05083855AA.**



**MOPAR®**

# SEALER REFINISH PROCESS



**SHERWIN  
WILLIAMS®**  
Automotive Finishes

## STEP 1

Thoroughly clean the areas requiring sealant application. Using a 3" nylon Roloc remove any existing sealant and/or loose paint as necessary. Solvent clean the affected areas with R7K158 or SC155.

## STEP 2

**Option 1:** Apply E2G970 Corrosion Shield® Etch Primer, followed by P30 Series Spectra Prime™ Primer Surfacer, to all bare metal areas.

**Option 2:** Apply NP75 DTM HS Primer to all bare metal areas.

*\*Refer to specific Product Data Sheets for Application Recommendations.*

## STEP 3

Apply the appropriate sealant per the manufacturer's recommendations. Observe the recommended sealer dry times before topcoating.

## STEP 4

Refinish the affected areas using the ULTRA SYSTEM® primer sealers and topcoats, as required to match the desired OE appearance. Refer to the specific Product Data Sheets for Application Recommendations.

## CONTACTS



**SHERWIN  
WILLIAMS®**  
Automotive Finishes

### Automotive Headquarters:

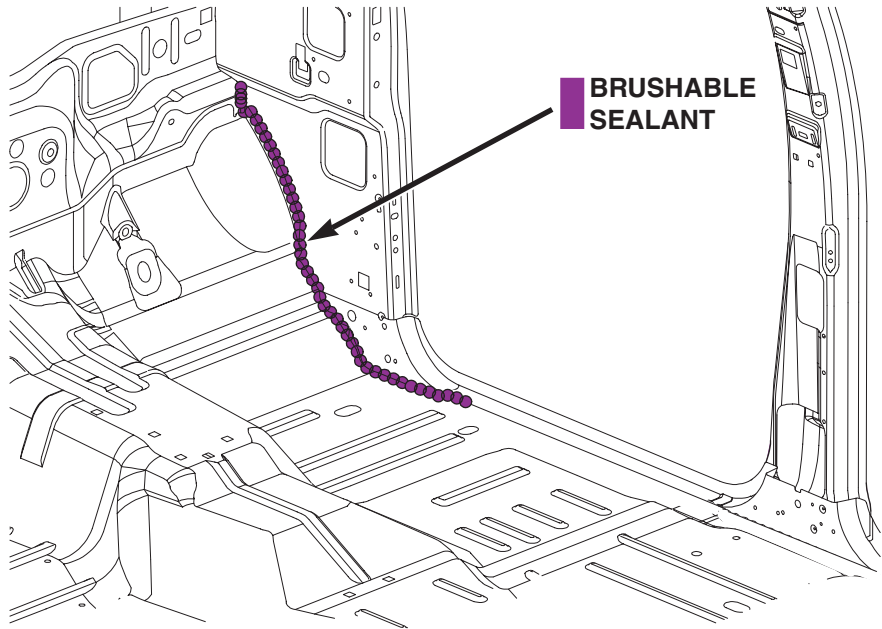
The Sherwin-Williams Automotive Finishes Corp.  
4440 Warrensville Center Road  
Warrensville Heights, OH, USA 44128-2837

### Customer Service:

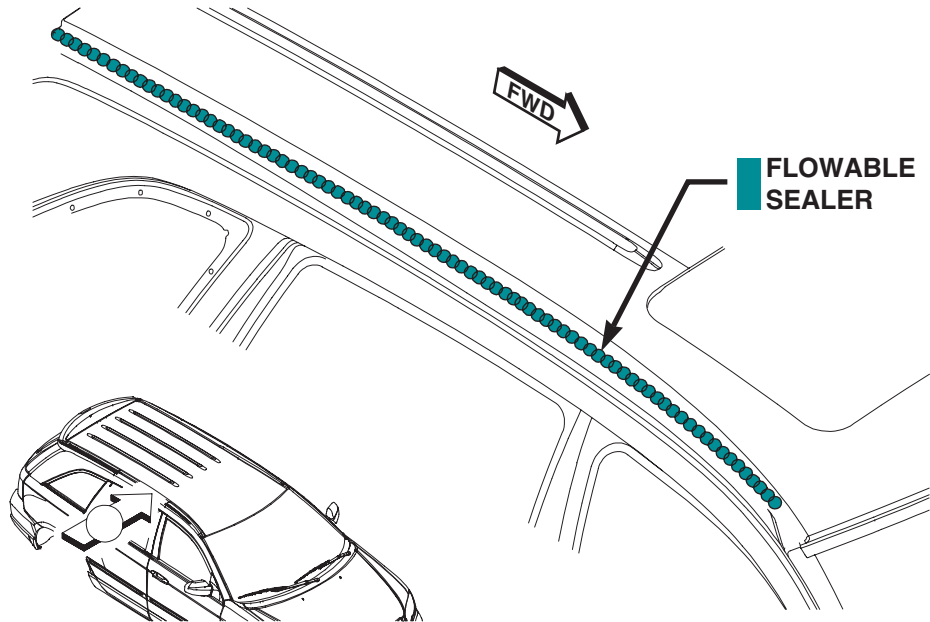
1-800-SW-ULTRA (800-798-5872)

The Sherwin-Williams Automotive Finishes Corp.  
OEM Services Group  
388 Robbins Drive  
Troy, MI 48083  
Phone: 248-588-3710

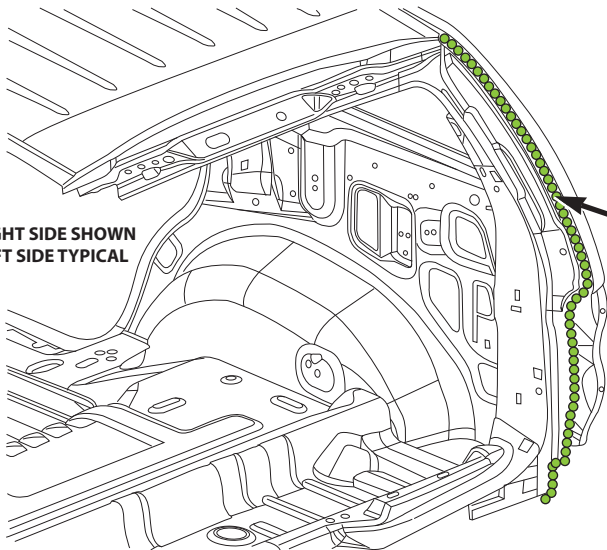
**Web-Site: [www.sherwin-automotive.com](http://www.sherwin-automotive.com)**



**BRUSHABLE  
SEALANT**

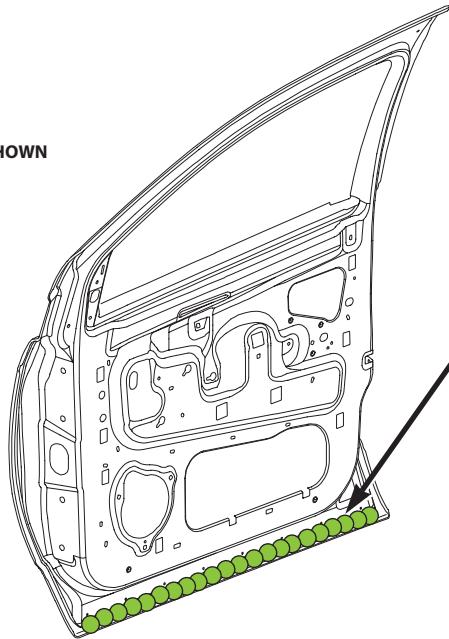


**RIGHT SIDE SHOWN  
LEFT SIDE TYPICAL**

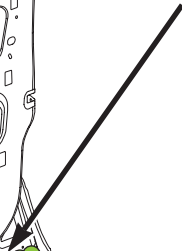


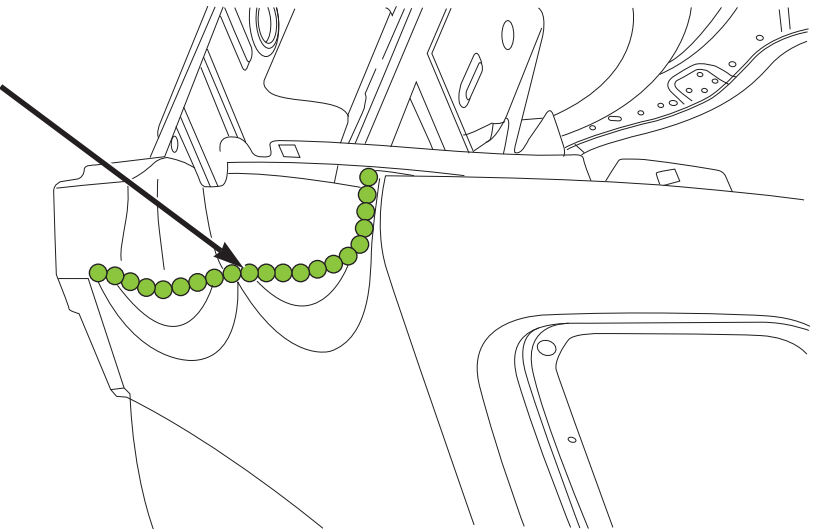
**PUMPABLE  
SEALER**

**TYPICAL DOOR SHOWN**

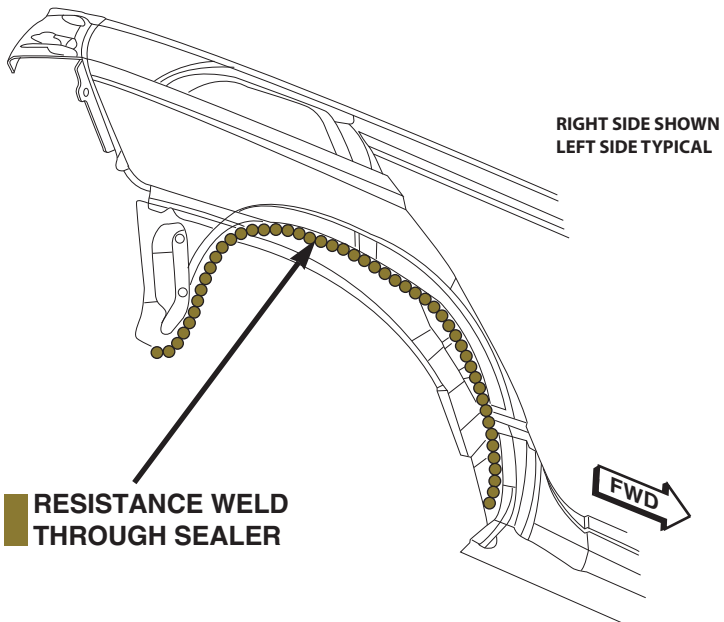


 **PUMPABLE  
SEALER**





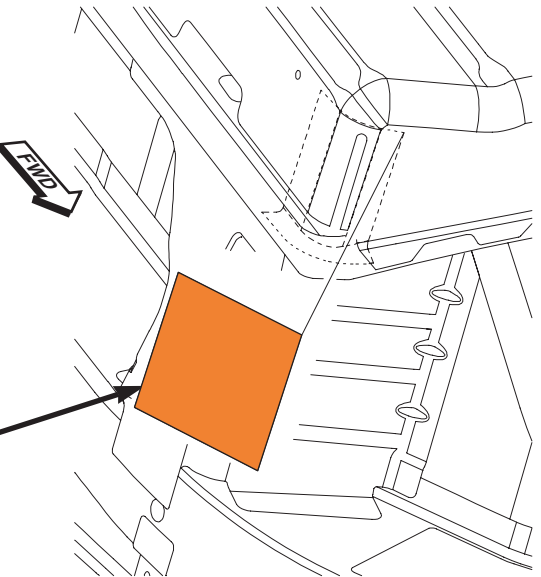
 **PUMPABLE  
SEALER**



**RIGHT SIDE SHOWN  
LEFT SIDE TYPICAL**

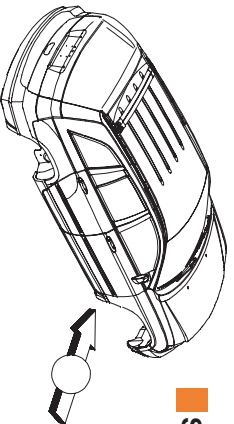
**RESISTANCE WELD  
THROUGH SEALER**

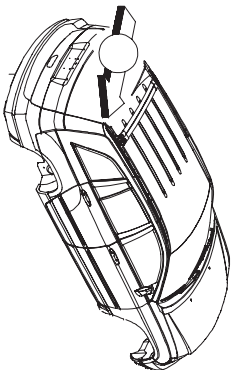
**FWD**



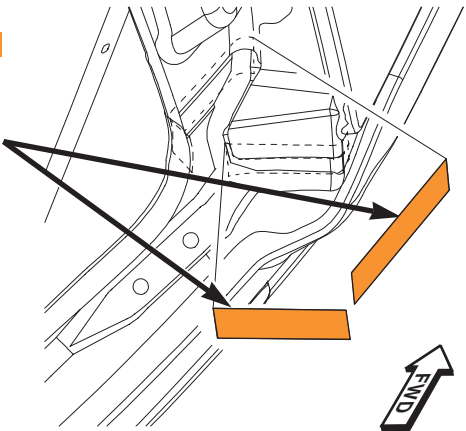
LEFT SIDE SHOWN  
RIGHT SIDE TYPICAL

 **SEALER TAPE**

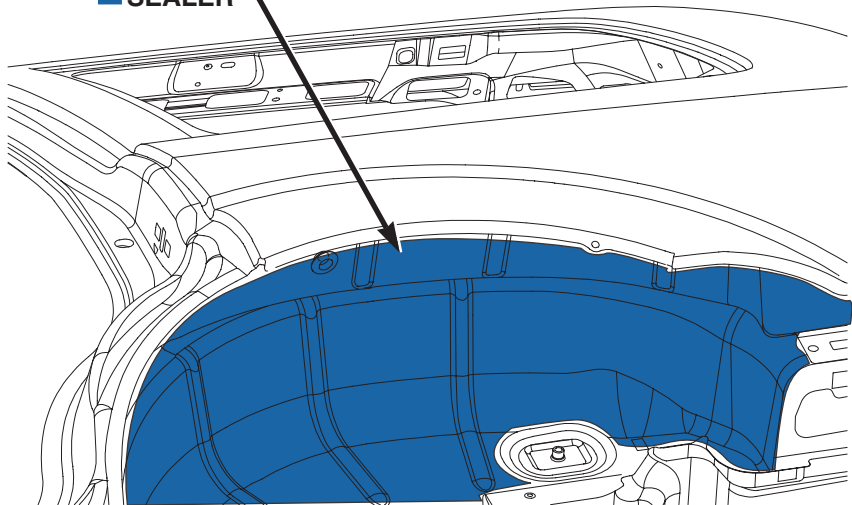




SEALER TAPE




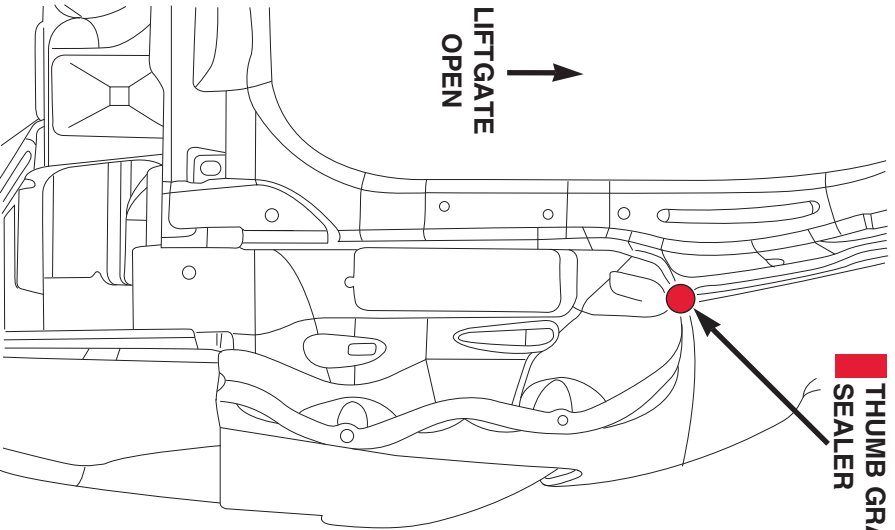
**SPRAYABLE  
SEALER**



**REAR WHEEL WELL**

 **THUMB GRADE  
SEALER**

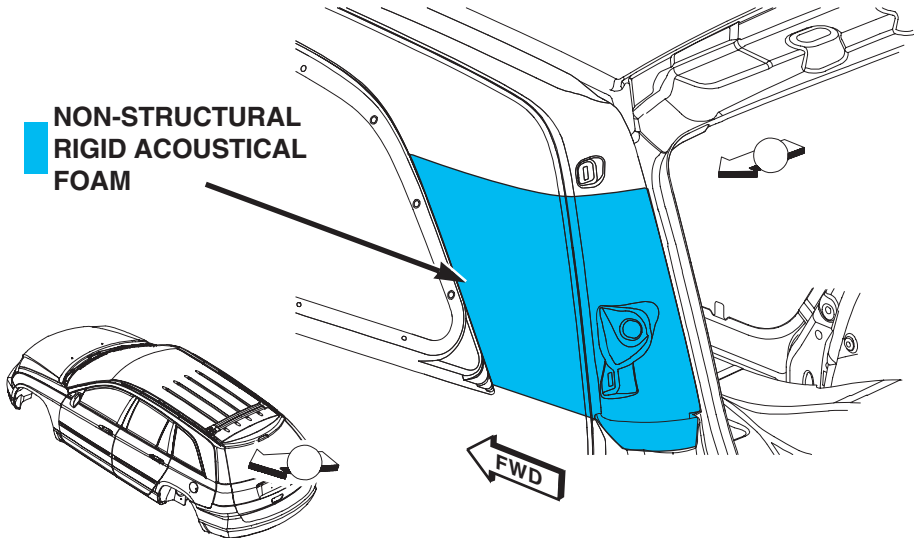
  
**LIFTGATE  
OPEN**



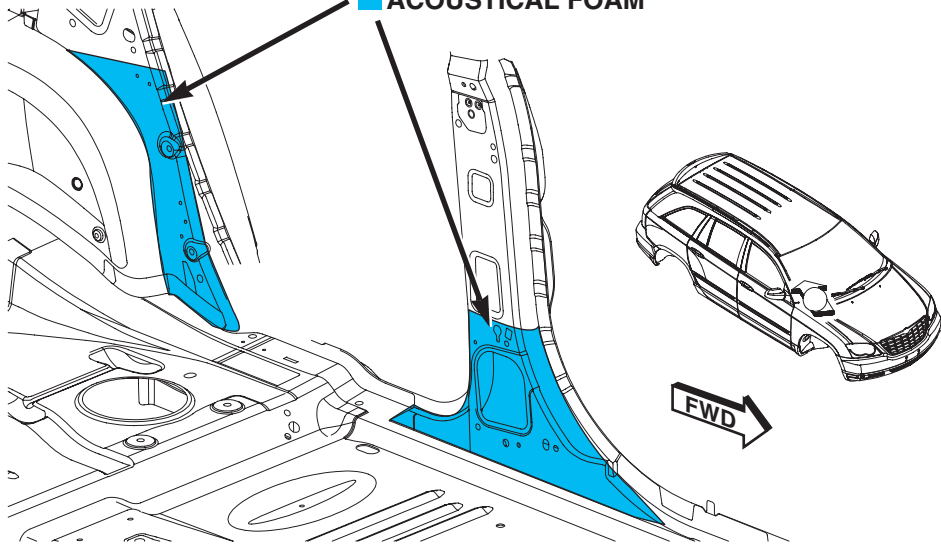
**NON-STRUCTURAL  
FLEXIBLE ACOUSTICAL  
FOAM**



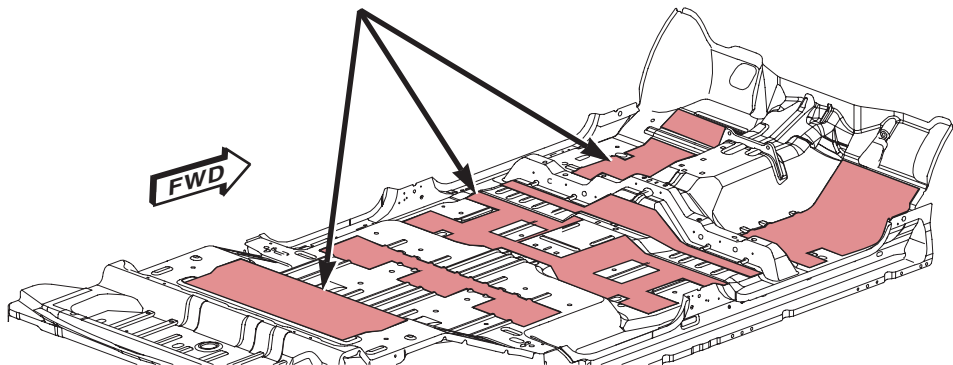
**NON-STRUCTURAL  
RIGID ACOUSTICAL  
FOAM**



**NON-STRUCTURAL RIGID  
ACOUSTICAL FOAM**



**MASTIC  
PADS/PATCHES**



# MANUFACTURER LISTING

SEALANT MANUFACTURERS		Technical Hotline
<b>3M</b> www.3m.com/automotive	1.877.MMM.CARS 1.877.666.2277	
<b>Duramix</b> www.duramix.com	1.877.MMM.CARS 1.877.666.2277	
<b>International Epoxies and Sealers</b> www.internationalepoxies.com mail@internationalepoxies.com	1.800.451.7206	
<b>LORD-Fusor</b> www.lord.com	1.800.234.3876	
<b>S &amp; R Fastener Company, Inc.</b> www.srfast.com mail@srfast.com	1.877.773.2276	

PAINT MANUFACTURERS		Technical Hotline
<b>Akzo-Nobel</b> www.akzonobelcarrefinishes.net	1.800.521.9222	
<b>Sherwin-Williams Automotive Finishes Corp.</b> www.sherwin-automotive.com	1.800.798.5872	



**sikkens**

**3M**



**LORIP**

Ask Us How™



**TES**



**SHERWIN-  
WILLIAMS®**  
AUTOMOTIVE FINISHES

**S&R**  
FASTENER CO., INC.

## DEALER TECHNICAL OPERATIONS Sealer/Sound Deadener Repair Guide

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