



Ultra Flex® Sprayable Seam Sealer 4182

Ultra Flex® Sprayable Seam Sealer is an iso-free, multi-purpose sprayable sealant. It may be applied by caulking gun or spray equipment and is easily extruded and tooled. It is a moisture curing sealant developed for automotive and industrial applications requiring elasticity, high strength and excellent adhesion.



Mix Ratio

Ready to use.



Suitable Substrates

- Raw plastic - rigid (SMC, BMC)
- Raw plastic - flex (ABD, PPO)
- Raw plastic - soft (PUR)
- Plastic part - primed
- OEM E-Coat
- Bare steel
- Bare galvanized
- Bare aluminum
- Body filler
- OEM finish & old paint work - reversible
- 1K primer
- 2K primer
- Fiberglass/SMC gel coat

Aftermarket E-coat must be solvent tested with Transtar Urethane Grade Reducers 6700 or 6700-F Series in an inconspicuous spot before application of new coating.

Note: Due to the diverse nature of plastics, always test plastic substrate for acceptable adhesion. Adhesion promoter maybe required for proper adhesion.

Note: Test pre-primed panels with acetone or paint thinner. If coating fails, strip panel to bare plastic & follow SOP 251 for Raw Plastic.



Surface Prep & Application

Surfaces must be clean and free from wax, silicone or grease. Clean surface with SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394.

Application: Apply bead of sealant along seam to be sealed. Sealant may be tooled as desired, and holds brush marks very well. Full cure will be achieved in 12 – 24 hours depending on humidity and material thickness.

NOTE: Product can be painted after 15 minute flash. If product is to be painted, it must be painted within 48 hours to assure proper adhesion. If it is not painted within 48 hours, simply apply one coat of TPO Adhesion Promoter 1021 at any time after 48 hours prior to applying subsequent coats.

TIP: Another strategy for handling extended paint times is to apply 2 in 1 Primer 4603/4613/4623/4633 after a 15 minute flash over the Ultra Flex® Sprayable Seam Sealer, then abrade with a scuff pad (red or gray) and degrease prior to painting.

TIP: To save unused material for later use, leave the plastic nozzle on the cartridge. This will keep moisture from entering the cartridge and curing the material. Simply replace the nozzle with a new one the next time you use the product.

Application with 4435 Sprayable Seam Sealer Gun

To use as a sprayable seam sealer, point the gun at the object to be treated and press the trigger. Keep the gun between 4-12 inches (10-30 cm) away from the surface depending on what result you wish to obtain. When you have finished spraying, disconnect the air supply and hang the gun on a fastening hook to store it. Refer the Technical Datasheet for #4435 Sprayable Seam Sealer Gun for spraying application.

Adjusting the product atomization: Turn the Air Control Knob clockwise to close the air passage gradually. This will reduce the atomization and make the texture rougher. Turn the Air Control Knob counter-clockwise to increase the atomization and spray a smoother texture.

Adjusting product quantity: Turn the Product Control Knob clockwise to gradually increase product flow. Turn counterclockwise to decrease the flow.

Combination adjustments: By adjusting both the Air and Product control knobs in combination you can achieve a variety of textures and widths of the product beads.

Adjusting total incoming air flow: If you have the optional Air Flow Regulator attached you can control the incoming air flow by turning the Regulator clockwise to increase the flow and counterclockwise to decrease the flow.

Note: The width of the product bead depends less upon adjusting the control knobs and more on the distance of the gun from the surface you are spraying.

**Flash Times/Dry Times**

Work time.....	10 min
Paint time.....	15 min to 48 hrs
Skin time.....	35 min
Full cure time.....	12 - 24 hrs (³ / ₁₆ " per 24 hours)

**Product Specifications**

Color.....	Gray	Size.....	11 fl oz
Shelf life.....	10 months	RTU solids.....	99%
Physical Performance Properties:			
Elongation.....	575%		
Shore D hardness.....	35		
Tensile strength.....	210 psi		
Cold temp resistance.....	@ -20°F (-28°C) remains flexible		
Heat temp resistance.....	@ 200°F (93°F) no degradation		

Regulatory

Category.....	Adhesive		
VOC actual.....	0.44#/gal (53 g/l)	Wt % of exempt compound.....	0
VOC regulatory.....	0.44#/gal (53 g/l)	Vol % of exempt compound.....	0
Wt % of volatiles.....	3.37%	Wt % of water.....	0
Density.....	12.5		



Limitations & Precautions

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.
- For automotive use only.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.