



# Control Flow Seam Sealer

## 4198

**Control Flow Seam Sealer is a two-part, non-sagging epoxy that is ideal for sealing vertical and horizontal seams and joints on automobiles and trucks. It features a 15 -20 minute work time and is paintable in 45 minutes. Control Flow Seam Sealer is 100% solids so it will not shrink, harden or crack.**



**Mix Ratio**  
1:1



### Suitable Substrates

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

**Cleaning & Sanding:** Use SCAT 6311, Speedi SCAT 6321 or Aqua SCAT 2 1391/1394 to clean surface. Bare metal should be primed with Self Etch Primer 6111/6114 or Epoxy Primer 6100 Series. Using an air gun, blow surface to be applied to remove all dust and wipe clean with a tack cloth.

**Cartridge Preparation:** Install Control Flow Seam Sealer into dual cartridge applicator gun (4440), remove nose plugs and equalize the cartridge. Install static mix nozzle and trim to desired bead size. Dispense until color is a light gray (about a 6" - 8" bead) and discard. Note: If the color appears too dark, it is an indication of an improper mix and the material will not fully cure.

**Application:** Dispense seam sealer into seam or joint. Smooth out if desired with tool or featheredge. Can be sanded in 45 minutes. Allow to dry 45 minutes before painting. Note: Material may set up in nozzle if left standing more than 5 minutes (depending upon the temperature and humidity). When storing cartridges, leave mixing nozzle in place. Before next use, replace with a new nozzle.



**Flash Times/Dry Times**

Work time.....	15 - 20 min
Paint time.....	45 - 60 min
Sand time.....	45 min
Cure time (delivery).....	1.5 - 2 hrs
Cure time (full).....	6 - 8 hrs



**Product Specifications**

Color.....	Gray
Size.....	7 fl oz
RTU solids.....	100%
Shelf life.....	1 year

**Regulatory**

Category.....	Sealant	
VOC actual (part A).....	0.05#/gal (6 g/l)	Wt % of volatiles..... 0
(part B).....	0.06#/gal (7 g/l)	Wt % of exempt compound..... 0
VOC regulatory (part A).....	0.05#/gal (6 g/l)	Vol % of exempt compound..... 0
(part B).....	0.05#/gal (6 g/l)	Wt % of water..... 0
Density.....	9.8	



**Limitations & Precautions**

- Visit [www.tat-co.com](http://www.tat-co.com) to assure use of the most current instructions and TDS on this product.
- See website ([www.tat-co.com](http://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.

**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.