



Ultra Flex® Seam Sealer & Adhesive

4172

Ultra Flex® Seam Sealer & Adhesive is a solvent- and isocyanate-free multi-purpose sealant. It may be applied by caulking gun or spray equipment and is easily extruded and tooled. 4172 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 finish & old paint work - reversible
- Bare steel
- Bare galvanized
- Bare aluminum
- Body filler
- 1K primer
- 2K primer
- Fiberglass/ SMC gel coat

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.

For Bonding: Abrading with 180-220 grit abrasive followed by cleaning with SCAT will improve the bond strength.

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 immediately. If product is to be painted, it must be painted within 2 hours to assure proper adhesion. If 4172 is not painted within 2 hours, simply apply one coat of TPO Adhesion Promoter 1021 at any time after 2 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 immediately over the 4172 then abrading with a scuff pad (red or gray) and degreasing 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.

Refer the Technical Datasheet for #4435 Sprayable Seam Sealer Gun for spraying application.

**Flash Times/Dry Times**

Work time..... 10 min
 Paint time..... Immediately paintable
 Skin time..... 12 min
 Full cure time..... 12 - 24 hrs (³/₁₆" per 24 hours)

**Product Specifications**

Color..... Tan
 Shelf life..... 1 year
 Physical Performance Properties:
 Elongation 230%
 Shore D hardness 45
 Tensile strength 190 psi
 Cold temp resistance..... @ -20°F (-28°C) remains flexible
 Heat temp resistance @ 200°F (93°F) no degradation

Size 11 fl oz
 RTU solids 99%

Regulatory

Category Adhesive
 VOC actual 0#/gal (0 g/l)
 VOC regulatory 0#/gal (0 g/l)
 Wt % of volatiles..... 0.8%
 Density 12.5

Wt % of exempt compound 0
 Vol % of exempt compound 0
 Wt % of water 0

**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.

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.