1: REMOVE PANEL
Remove the damaged panel following the vehicle manufactures’ recommendations.

2: REPAIR
Straighten and repair the mating surfaces as needed.

3: PREPARE
Grind the surface areas to remove all old adhesive, spot welds, or corrosion.
- Door Skin: Scuff sand the new panel along the perimeter to remove the gloss where the adhesive will make contact.
- Quarter and Roof Panels: Grind the frame and perimeter of the new panels with 50-80 grit (following the vehicle manufacturer recommendations).

4: APPLY
Apply selected Evercoat Adhesive to mating surfaces and coat all exposed metal, then apply a 3/8 inch to 1/2 inch (9mm-12mm) bead along the perimeter of the structure.

5: ATTACH NEW PANEL
Align the new panel being sure to slide into place as needed. Do not separate panels once in place.

6: SECURE PANEL
Clamp or screw new panel into place according to product clamp time. See chart below.

**Panel Bond 30**
- **Product Code**: 106030 200ML CARTRIDGE
- **Product Description**: The fastest epoxy-only adhesive on the market today. 106030 has excellent gunability in hot and cold temperatures. It’s designed for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other non-structural panels. It has Excellent adhesion for metal-to-metal, metal-to-SMC and SMC-to-SMC.

**Panel Bond 45**
- **Product Code**: 106045 200ML CARTRIDGE
- **Product Description**: Panel Bond 45 is a one-to-one epoxy adhesive used for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other non-structural panels. Panel Bond 45 has excellent adhesion to SMC/FRP, cold rolled steel, aluminum and e-coats and is backed with a lifetime warranty by Evercoat.

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**Check Out These Other Evercoat Products For All Your Repair Needs.**

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<th>Better</th>
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| **EVER GOLD™ FILLER**<br>EVER° G® Filler<br>ID32 30 FL. G1, T-400<br>ID50 20 FL. G2, T-250<br>ID50 20 FL. G2, T-750 | **RAGE® ULTRA 50:1 FILLER**
- NO PUTTY NEEDED
- NO MIXING
- QUICK DRY TIME
- HIGH STRONGNESS |
| **METAL GLAZE® OEM**
- METAL GLAZE® OEM<br>1020-1050 ULTRA<br>1020-1050 FL. G2, T-250<br>1020-1050 FL. G2, T-750 | **QUANTUM 1 10:1 FILLER**
- NO PUTTY NEEDED
- NO MIXING
- QUICK DRY TIME
- HIGH STRONGNESS |

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**Work Time | Clamp Time | Cure Time**
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30-35 MIN. | 90-120 MIN. | 12 HOURS @ 70°F (25°C)
45-50 MIN. | 3.5-4 HOURS | 24 HOURS @ 70°F (25°C)
SEAM SEALERS
#106022 HEAVY BODIED & #106023 CONTROL FLOW

1: CLEAN
Clean area with all-purpose solvent cleaner and wipe with a clean dry rag.

NOTE: EVERCOAT Seam Sealer #106022 & #106023 can be used on bare metal.

2: PREPARE
Sand the area with 320 grit sandpaper or scuff pad.

3: CLEAN
Redo the area with an all-purpose solvent and wipe with a clean dry rag.

4: APPLY
Equalize cartridge and install static mixing tip. Dispense product to ensure even mixing and apply to the area as needed. Allow 30 minutes and prime according to your paint manufacturer’s recommendations.

HEAVY-BODIED
#106022 200ML CARTRIDGE
Heavy-Bodied Seam Sealer is a two-component epoxy seam sealer used to duplicate a variety of OEM seams. This non-sag seam sealer has excellent tooling characteristics and is compatible with most topcoats.

CONTROL-FLOW
#106023 200ML CARTRIDGE
Control-Flow Seam Sealer is an epoxy seam sealer with limited flow characteristics, ideal for use in sloped areas. The viscosity of this seam sealer allows for build without brush marks. Control-Flow Seam Sealer is compatible with most topcoats.

SEE IT ON YouTube
SEAM SEALERS