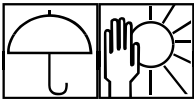


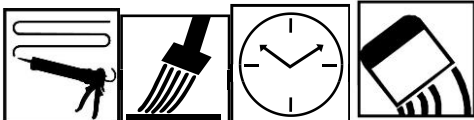


# TECHNICAL DATA SHEET

## Metal Bonding Adhesive – Medium Set

104112 / 70884

<b>DESCRIPTION:</b>	A two part epoxy adhesive for the bonding of bare steel, galvanized steel, aluminum, GRP, composites and most rigid plastics.																						
<b>USES:</b>	<b>FOR PROFESSIONAL USE ONLY</b> This adhesive is used for bonding door skins and other non-structural panels. Has excellent adhesion to bare steel, galvanized steel, aluminum, and e-coated panels, GRP, composites and most rigid plastics.																						
<b>STORAGE:</b>	 <p>Store in accordance with local regulations. Observe label precautions. Store in a cool, well-ventilated area away from incompatible materials and ignition sources. Keep away from: oxidising agents, strong alkalis, strong acids. No smoking. Prevent unauthorised access. Store used cartridges with tip down. Do not empty into drains.</p>																						
<b>PREPARATION:</b>	 <p>Ensure surfaces to be bonded are clean and free from oil and grease. Remove any paint and sand the area with P180 abrasive. e-coat should be abraded but not removed. Dry-fit the components to ensure alignment of the areas to be bonded. Thoroughly clean areas to be bonded.</p>																						
<b>MIXING:</b>	 <p>Equalize the cartridge to remove any air. Gun out a bead of adhesive the length of the static mix tip to check for proper mix.</p>																						
<b>APPLICATION:</b>	 <p>Apply a bead of adhesive to the frame and new panel. Spread the adhesive to a thin coat to cover all exposed bare metal. Apply a 5mm bead of the adhesive to the frame or new panel. Align the new panel to the frame. Slide the panel to position. Clamp the panel to the frame. Remove any excess adhesive. Do not remove the clamps for 3.5 hours.</p>																						
<b>FINISHING:</b>	-																						
<b>TECHNICAL SPECIFICATIONS:</b>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Color</td> <td>Black/Gray</td> </tr> <tr> <td>Physical state</td> <td>Liquid</td> </tr> <tr> <td>Flash Point</td> <td>93°C (199.9°F)</td> </tr> <tr> <td>Vapour Density</td> <td>&gt;1 [Air = 1]</td> </tr> <tr> <td>Solubility</td> <td>Insoluble in the following materials: cold water and hot water.</td> </tr> <tr> <td>Work Time</td> <td>40-50 minutes</td> </tr> <tr> <td>Clamp Time</td> <td>3.5 hours</td> </tr> <tr> <td>Paint Time</td> <td>24 hours at 21°C (70°F)</td> </tr> <tr> <td>Full Cure</td> <td>24 hours at 21°C (70°F)</td> </tr> <tr> <td>Contents and Caution</td> <td>MSDS Available upon request</td> </tr> <tr> <td>VOC</td> <td>77 g/l (0.64 lbs/gal) Volatile Organic Compound (VOC) compliant with European Directive 2004/24/42/CE of 21 April 2004.</td> </tr> </table>	Color	Black/Gray	Physical state	Liquid	Flash Point	93°C (199.9°F)	Vapour Density	>1 [Air = 1]	Solubility	Insoluble in the following materials: cold water and hot water.	Work Time	40-50 minutes	Clamp Time	3.5 hours	Paint Time	24 hours at 21°C (70°F)	Full Cure	24 hours at 21°C (70°F)	Contents and Caution	MSDS Available upon request	VOC	77 g/l (0.64 lbs/gal) Volatile Organic Compound (VOC) compliant with European Directive 2004/24/42/CE of 21 April 2004.
Color	Black/Gray																						
Physical state	Liquid																						
Flash Point	93°C (199.9°F)																						
Vapour Density	>1 [Air = 1]																						
Solubility	Insoluble in the following materials: cold water and hot water.																						
Work Time	40-50 minutes																						
Clamp Time	3.5 hours																						
Paint Time	24 hours at 21°C (70°F)																						
Full Cure	24 hours at 21°C (70°F)																						
Contents and Caution	MSDS Available upon request																						
VOC	77 g/l (0.64 lbs/gal) Volatile Organic Compound (VOC) compliant with European Directive 2004/24/42/CE of 21 April 2004.																						
<b>SAFETY &amp; HANDLING:</b>	Read all directions and warnings prior to using Evercoat products. Material Safety Data Sheets can be found online at evercoat.com.																						

# TECHNICAL DATA SHEET

**Metal Bonding Adhesive  
– Medium Set**

104112 / 70884