

PRODUCT: MAXIM™ Multi-Panel Panel Bonding Adhesive

PART

NUMBER: 100815 250mL Cartridge 6 units/case

DESCRIPTION: Maxim™ Multi-Panel Bonding Adhesive is a one-to-one epoxy adhesive used for bonding various surfaces. It is used for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other non-structural panels. Has excellent adhesion to SMC, cold rolled steel, aluminum and e-coats. Maxim™ Multi-Panel Bonding Adhesive is backed with a full lifetime warranty by Evercoat.

FEATURES & BENEFITS:

Packaged in a Universal Cartridge: applied with a standard-style, heavy duty caulking gun
1:1 mix ratio
Contains glass beads for control of bond line thickness
Corrosion resistant properties: eliminates application of epoxy or self-etch primers
Excellent working time
Superior sag resistance
Easy to brush and spread
Excellent adhesion to SMC/FRP
Cure time can be accelerated with heat

PREPARATION: Remove damaged panel. Grind surface area with 36-50 grit to remove adhesive, rust and other contaminants. Straighten damaged area. On quarters and roofs, grind the new panel to bare steel. On e-coated door skins, scuff the panel to remove the gloss. Dry fit the panel to check for proper alignment. Clean the contact surface areas.

APPLICATION: Equalize the cartridge to remove any air. Affix Evercoat-supplied mix tip to cartridge. Gun out a bead of adhesive until a uniform color is achieved. Apply a 1/4" – 3/8" bead of **Multi-Panel Bonding Adhesive** to the contact surfaces. Brush the adhesive to a thin coat to cover all exposed bare metal. Apply a second 1/4" – 3/8" bead of the adhesive to one contact surface only. Align the contact surfaces. Clamp or screw the contact surfaces. Remove all excess adhesive from the seam. Once parts are clamped, do not re-position after 15 minutes. Wait at least 4 hours before removing the clamps or screws. Cure time can be accelerated with heat (not to exceed 180°F/82°C). Store used cartridges with the tip down or remove tip and reinsert the original plugs.

TECHNICAL SPECIFICATIONS:

▪ Appearance	Gray/Black
▪ VOC	Refer to Section 9 of the Safety Data Sheet
▪ Odor	Amine / mercapton
▪ Working Time	35-45 minutes
▪ Clamp Time	3.5 hours
▪ Full Cure	24 hours @ 70° F (21°C)

NOTE: Properties are typical values and should not be considered as sales specifications. Physical testing performed @ ~72°F (22°C) / 75% RH unless otherwise noted.

SAFETY & HANDLING:

For professional use only, read all directions and warnings prior to using Evercoat® products. Keep cartridge closed and store in a cool dry place.

Safety Data Sheets can be found online at evercoat.com.



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