

PRODUCT: MAXIM™ Large Panel Bonding Adhesive

PART NUMBER: 100816 250mL Cartridge 6 units/case

DESCRIPTION: Maxim™ Large 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. Meets OEM specifications and is backed with a full-life time warranty by Evercoat.

FEATURES & BENEFITS: Packaged in a Universal Cartridge: applied with a standard 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 times
Superior sag resistance
Easy to brush and spread
Cure time can be accelerated with heat

PREPARATION: Remove damaged panel. Grind surface area of the frame to remove old adhesive, rust and other contaminants. Straighten damaged area. On quarters and roofs, grind the new panel to bare steel. On doorskins, scuff the panel to remove the gloss.
Dry fit the panel to check for proper alignment.
Clean the mating surface areas of the frame and new panel.

APPLICATION: 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. Apply a bead of **Maxim™ Large Panel Bonding Adhesive** to the frame and new panel. Brush the adhesive to a thin coat to cover all exposed bare metal. Apply a 1/4" to 1/2" bead of the adhesive to the frame or new panel. Align the new panel to the frame. Slide the panel to reposition. Clamp or screw the new panel to the frame. Do not remove the clamps or screws for 6 hours. Remove all excess adhesive from the seams. Store used cartridges with the tip down.

TECHNICAL SPECIFICATIONS:

▪ Appearance	Gray/Black
▪ VOC	None
▪ Odor	Amine / mercapton
▪ Working Time	90-110 minutes
▪ Clamp Time	6 hours
▪ Full Cure	24 hours @ 72° F (22°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.