

### MAXIM™ BONDING ADHESIVES

**PRODUCT:** MAXIM™ FAST SET BONDING ADHESIVE

**PART**

**NUMBER:** 100812      Universal Cartridge (250 mL)      6 units/case      6 lbs/case

**DESCRIPTION:** Maxim™ Fast Set Bonding Adhesive is used for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other **non-structural** panels. Maxim™ Fast Set Bonding Adhesive has excellent adhesion to bare steel, galvanized steel, aluminum and e-coated panels. Maxim™ Fast Set Bonding Adhesive is backed with a full-life time warranty by Evercoat.

**FEATURES & BENEFITS:**

Packaged in a Universal Cartridge: applied with a standard caulking gun  
Low odor formula  
Contains glass beads for control of bond line thickness  
Corrosion resistant properties: eliminates application of epoxy or self-etch primers  
No wax surface film after cure  
1:1 mix ratio  
Changes color as it cures  
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 using a 60-80 grit grinding disc. 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™ Fast Set Bonding Adhesive to the frame and new panel. Brush the adhesive to a thin coat to cover all exposed bare metal. Apply a 3/8"-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 25-30 minutes. Remove all excess adhesive from the seams. Store used cartridges with tip down.

**TECHNICAL SPECIFICATIONS:**

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|------------------------------|--|
| ▪ Appearance                 | Black/White  |
| ▪ VOC                        | .42 lbs/gal (50 g/l)                                   |
| ▪ Odor                       | Non-offensive  |
| ▪ Working Time               | 10-15 minutes  |
| ▪ Clamp Time                 | 25-30 minutes  |
| ▪ Full Cure                  | 4 hours @ 70° F (21°C)                                 |
| ▪ Paint Time                 | 4 hours @ 70° F (21°C)                                 |
| ▪ Contents and Caution       | MSDS available upon request                            |
| ▪ For additional information | <a href="http://www.evercoat.com">www.evercoat.com</a> |



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