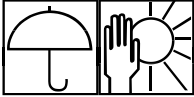





TECHNICAL DATA SHEET

Metal Bonding Adhesive – Fast Set

104112

DESCRIPTION:	A fast setting epoxy adhesive for metal to metal surfaces.																										
USES:	FOR PROFESSIONAL USE ONLY This adhesive is used for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other non-structural panels. Has excellent adhesion to bare steel, galvanized steel, aluminum, and e-coated panels. Meets GM6449G specifications.																										
STORAGE:	 <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>																										
PREPARATION:	 <p>Wash repair area with soap and warm water. Allow to dry thoroughly.</p>																										
MIXING:	 <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>																										
APPLICATION:	 <p>Apply a bead of Adhesive to the frame and new panel. Brush the adhesive to a thin coat to cover all exposed bare metal. Apply a 1cm - 1.25cm 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.</p>																										
FINISHING:	-																										
TECHNICAL SPECIFICATIONS:	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Color</td> <td>Black/White – Off-white</td> </tr> <tr> <td>Physical state</td> <td>Liquid</td> </tr> <tr> <td>Flash Point</td> <td>Open cup: >10°C (>50°F)</td> </tr> <tr> <td>pH</td> <td>3 to 3.5</td> </tr> <tr> <td>Relative Density</td> <td>1.03</td> </tr> <tr> <td>Vapour Density</td> <td>>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>10-15 minutes</td> </tr> <tr> <td>Clamp Time</td> <td>25-30 minutes</td> </tr> <tr> <td>Paint Time</td> <td>4 hours at 21°C (70°F)</td> </tr> <tr> <td>Full Cure</td> <td>4 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>50 g/l (0.42 lbs/gal) Volatile Organic Compound (VOC) compliant with European Directive 2004/24/42/CE of 21 April 2004.</td> </tr> </table>	Color	Black/White – Off-white	Physical state	Liquid	Flash Point	Open cup: >10°C (>50°F)	pH	3 to 3.5	Relative Density	1.03	Vapour Density	>1 [Air = 1]	Solubility	Insoluble in the following materials: cold water and hot water.	Work Time	10-15 minutes	Clamp Time	25-30 minutes	Paint Time	4 hours at 21°C (70°F)	Full Cure	4 hours at 21°C (70°F)	Contents and Caution	MSDS Available upon request	VOC	50 g/l (0.42 lbs/gal) Volatile Organic Compound (VOC) compliant with European Directive 2004/24/42/CE of 21 April 2004.
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SAFETY & HANDLING:	Read all directions and warnings prior to using Evercoat products. Material Safety Data Sheets can be found online at evercoat.com.																										