

PRODUCT: Professional Panel Bond 90

PART NUMBER: 100843 200mL Cartridge 6 units per case

DESCRIPTION: Professional Panel Bond 90 is a two-component epoxy adhesive used for replacing various body panels. It can be used to bond quarter panels, door skins, roof skins, and bed sides. Professional Panel Bond 90 has corrosion-inhibiting properties. Backed with a full lifetime warranty by Evercoat.

SUBSTRATES:



- Cold Rolled Steel
- Aluminum
- Carbon Fiber
- SMC
- Fiberglass
- Metton® LMR

NOTE: All substrates must be properly sanded and cleaned prior to application for optimum performance. Follow OEM recommendations for bonding procedures.

CLEANING:



- Surface must be clean and free of dirt, oil, grease and wax
- Wash all surfaces with soap and water
- Follow soap and water wash with an all-purpose solvent cleaner

PREPARATION:



- Remove damaged panel and grind all areas to be bonded or welded with 36-50 grit to remove old adhesive, paint, primer, galvanized coating, e-coat, and rust
- Remove dust using clean compressed air
- Straighten damaged metal and dry-fit the parts
- Ensure all bonding surfaces are free of contaminants

NOTE: For more details refer to the vehicle manufacturer's recommended procedures for preparing the panels for bonding

APPLICATION:

- Pre-Fit the panel for proper alignment
- Equalize the cartridge until both sides flow equally
- Attach the included static mix tip
- Dispense a bead of material equal to length of mix tip to ensure proper mix
- Apply a bead of adhesive to both mating surfaces
- Brush or spread the adhesive to protect all exposed bare metal
- Apply a 3/8" – 1/2" (9mm – 13mm) bead of the adhesive to either surface
- Align in place and apply even pressure for recommended clamp time
- Clamp the new panel in its proper position for the recommended clamp time (Allow longer time for lower temperatures)
- Remove all excess adhesive from the seams

NOTE:

If adjustment is needed slide in place. Do not separate the panels. If the panel requires separation, remove the adhesive and repeat the application process. Not doing so could compromise the adhesive strength.

This product is not intended for bonding structural components. If you are not sure a panel should be bonded, then refer to the vehicle manufacturer's guidelines for bonding or weld the panel.

Always follow the vehicle manufacturer's recommendations and directions for using bonding adhesives.

TECHNICAL SPECIFICATIONS:

Work Time	90 minutes
Clamp Time	4 hours
Cure Time	24 hours

NOTE: Physical testing performed at approximately 74°F (23°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 www.evercoat.com.