

**PRODUCT:** MAXIM™ Medium Set Bonding Adhesive

**PART NUMBER:** 100813      250mL Cartridge      6 units/case

**DESCRIPTION:** Maxim™ Medium Set Bonding Adhesive is a two part 1:1 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. Maxim™ Medium Set Bonding Adhesive has excellent adhesion to SMC and Fiberglass, cold rolled steel, aluminum and e-coats. Maxim™ Medium Set Bonding Adhesive is great for plastic repairs. Maxim™ Medium Set Bonding Adhesive is backed with a full lifetime warranty by Evercoat.

**FEATURES & BENEFITS:**

- Contains glass beads for control of bond line thickness
- Corrosion resistant properties
- Easy to brush and spread
- Superior Metal Bonding Strength
- Excellent Adhesion to SMC
- Bond, Sand and Paint the Same Day

**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. Using a new sanding disc, sand the surface to expose the bare metal leaving 1 – 1 ½” mating surface. Door Skin – Scuff sand the door skin to remove gloss. Do not remove e-coat.

**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™ Medium 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 the new panel to the frame. Do not remove the clamps for 1.5 – 2 hours. Remove all excess adhesive from the seams. Store used cartridges with tip down.

**TECHNICAL SPECIFICATIONS:**

▪ Appearance	Gray/Black
▪ VOC	Refer to Section 9 of the Safety Data Sheet
▪ Odor	Amine / mercapton
▪ Working Time	35-40 minutes
▪ Clamp Time	90-120 minutes
▪ Full Cure	12 hours @ Standard RT(77° F / 25°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](http://evercoat.com).