

Technical Data Sheet

Metal Bonding Adhesive



Overview

A two-part, high-strength methacrylate adhesive for non-structural steel automotive body panels. Exceptional bond strength on bare steel, E-coat, galvanized finishes, stainless steel and aluminum. Exceeds FMVSS 208 and 301 requirements for crash and rollover tests. Reduces the need for welding or mechanical fasteners. Seals and bonds difficult joints to prevent water leaks and corrosion. May be used in weld-bonding of body panels. Long, 60-minute work life for use on large panels. Neutral (brown) color, packaged in a 7 oz. Dual Cartridge for use with the Kent Automotive Dual Cartridge Applicator Gun (P33705) and Turbo Mixer

Features/Benefits

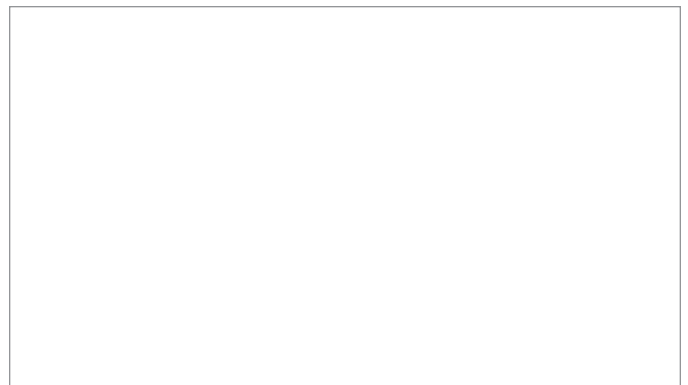
- Seals and bonds in one step – Saves time with fewer steps and products needed for a solid repair
- Exceeds FMVSS 208 and 301 crash and rollover tests – Provides maximum strength on non-structural steel automotive body panels
- Non-sag formula, neutral color – Won't run on vertical surfaces, covers easily with any color paint
- Contains glass beads for borderline control – Makes durable long-lasting repairs on non-structural steel automotive body panels
- Sandable and paintable in 2 hours – Significantly reduces labor time on panel replacements

Applications

- Quarter Panels
- Filler Panels
- Roof Skins
- Pickup Box Sides
- Fenders

Method of Application

- Dual Cartridge



Identification

- Panel Adhesive



Sizes

- 7 oz. (207ml) Dual Cartridge

Directions for Use

1. Kent Automotive Metal Bonding Adhesive is intended for exterior sheet metal panels and should not be used to bond structural components of any kind.
2. Remove the old panel by cutting out the spot-welds with a good quality spot-weld remover like the Kent Automotive ProBit™ to minimize damage to the mating flanges.
3. On beltline cuts, or where the rear quarter is spliced into the sail panel, leave enough of the old panel in place to allow a 1-1/2" minimum overlap with the new panel.
4. The exposed edge of the outer panel should be beveled; do not leave a sharp, squared edge on exposed cosmetic panels.
5. Clean all old sealers, adhesives, dirt and other foreign material from the mating surfaces. Remove loose paints, primers or E-coat that might interfere with good adhesion. Use a non-woven abrasive disc to minimize damage to galvanized coatings.
6. Trial-fit the replacement panel to ensure gaps don't exceed 1/8". Straighten or adjust the flanges until the fit is correct.
7. Drill 5/16" holes in the replacement panel where MIG plug welds are suggested by the car manufacturer.
8. Prepare all the mating surfaces with Kent Automotive Acrysol™ to remove any grease, oil or other contaminants.
9. Equalize the cartridge of Kent Metal Bonding Adhesive and install the KT13427 Turbo Mixer.
10. Apply a 3/8" bead of Metal Bonding Adhesive to both mating surfaces within 2" of the areas that will be welded. When weld-bonding, completely cover the flanges.
11. Squeegee the Kent Metal Bonding Adhesive onto the flanges to ensure good contact and no air gaps.
12. Place the panel in position immediately and slide to realign if needed. Do not separate.
13. Clamp or screw non-cosmetic areas of the panel in place. Use shims if necessary to maintain at least 1/16" of adhesive between panels. Do not shim if weld-bonding.
14. If weld-bonding, start welding immediately, before the Metal Bonding Adhesive sets.
15. Tool excess adhesive immediately and allow to cure. Remove all adhesive from exposed cosmetic seams. Heat may be used to speed curing: 150°F (65°C) maximum.
16. MIG weld appropriate areas suggested by the vehicle manufacturer. Remove clamps and temporary screws (or grind off heads) after 2 to 3 hours. Remove any adhesive from exposed cosmetic seams.
17. Repair cosmetic areas, prime and apply appropriate Kent Automotive seam sealers as needed, and paint. Apply Kent Guard corrosion protection products as needed.

NOTE: Store Metal Bonding Adhesive in an upright position in the original foil containers until ready to use. Store in a cool dry location. Ideal storage temperature is between 50°F and 60°F (10°C to 15°C). Exposure to higher temperatures will reduce shelf life.



Technical Specifications

Application Thickness: 1/16" to 3/8"
Work Life: 60 minutes, minimum
Full Cure: 24 hours
Sandable: 2 hours
Time to Paint: 2 hours, 4B (excellent rating)
Lap Shear Strength: 3,000 to 3,800 PSI (steel)
Peel Strength: 20 to 40 PLI (steel)
Low-temperature Flexibility: 10°F (-12°C)
Percent Solids: 100%
Sag: 1/2" bead, zero, 15 minutes at room temperature
Ultraviolet Resistance: 500 hours exposure, no deterioration
Temperature Range: -40°F to +225°F (-40°C to +107°C)

Minimum Welding Locations

----- WELD
..... APPLY ADHESIVE

