

PRODUCT: Panel Bond-45

PART NUMBER: 100**6045** **200mL Cartridge** **6 units per case** **6.0 lbs. per case**

DESCRIPTION: Evercoat #6045 Panel Bond-45 is a two-component epoxy adhesive used for replacing various body panels. It can be used to bond SMC to SMC, metal to metal and SMC to metal. Panel Bond-45 has corrosion-inhibiting properties that eliminates the need for epoxy primer or self-etch primers. It is backed with a full lifetime warranty by Evercoat.

SUBSTRATES:



- Cold Rolled Steel
- Aluminum
- SMC
- Fiberglass

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 to remove old adhesive, paint, primer and other contaminants
- Remove dust using compressed air and reclean with an all-purpose solvent cleaner
- Straighten damaged metal and dry-fit the parts

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

APPLICATION:

- Equalize the cartridge and gun out a bead of adhesive the length of the static mix tip to check for proper mix
- Apply a bead of adhesive to all bare metal surfaces of both pieces to be bonded
- Brush the adhesive to a thin coat to cover all exposed bare metal surfaces
- Apply a bead of the adhesive to the frame or new panel
- Clamp the new panel in its proper position
- Do not remove the clamps for 3.5 – 4 hours
- Remove all excess adhesive from the seams.

NOTE: This product is not intended for bonding structural components. If you are not a 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	45-50 minutes
Sand Time	3.5-4 hours
Cure Time	24 hours

NOTE: Physical testing performed at approximately 70°F (21°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. Material Safety Data Sheets can be found online at www.evercoat.com.



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