

# Technical Data Sheet

## Panel Sealer-Adhesive



### Overview

A two-part, high-strength, epoxy sealer and adhesive for non-structural steel automotive body panels. Exceptional bond strength on bare steel, E-coat, paint and primer. 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, 45 minute work life for use on large panels. Neutral (off-white) color, packaged in a 10 oz. Dual Cartridge for use with the Kent Automotive Dual Cartridge Applicator Gun (P33705) and Turbo Mixes.

### Features/Benefits

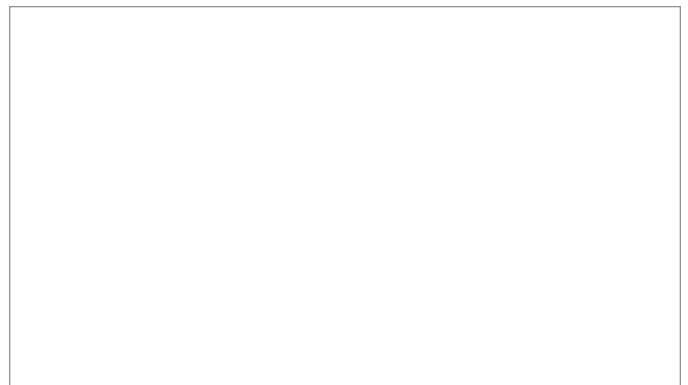
- Seals and bonds in one step – Saves time with fewer steps and products needed for a solid repair
- Specifically formulated for steel body panels – Provides maximum bond strength on non-structural steel automotive body panels
- Non-sag formula, neutral color – Won't run on vertical surfaces; covers easily with any color paint
- Excellent adhesion and flexibility – Makes durable, long-lasting repairs on non-structural steel automotive body panels
- Sandable in 90 minutes, paintable in 2 hours – Significantly reduces labor time on panel replacements

### Applications

- Quarter Panels
- Roof Skins
- Door Skins
- Filler Panels
- Pickup Box Sides
- Patch Panels

### Method of Application

- Dual Cartridge



## Identification

- Panel Adhesive



## Sizes

- 10 oz. (300ml) Dual Cartridge

## Directions for Use

1. Kent Automotive Panel Sealer-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 the 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 the mating surfaces with Kent Automotive Acrysol™ to remove any grease, oil or other contaminants.
9. Equalize the cartridge of Kent Automotive Panel Sealer-Adhesive and install the KT13427 Turbo Mixer.
10. Apply a 3/8" bead of Panel Sealer-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 Panel Sealer-Adhesive onto the flanges to ensure good contact and no air gaps.
12. Place the panel in position immediately; slide to realign if needed. Do not separate.
13. Clamp or screw (non-cosmetic areas) 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 sealer-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 car manufacturer. Remove clamps and temporary screws (or grind off heads) after 2 to 3 hours. Remove any cured adhesive from exposed, cosmetic seams.
17. Repair cosmetic areas, prime and apply appropriate Kent Automotive seam sealers as needed, and paint. Apply Kent corrosion protection products as needed.



### Technical Specifications

Application Thickness: 1/16" to 3/8"  
Work Life: 45 minutes minimum  
Tensile Strength: 3,600 PSI  
Full Cure: 24 hours  
Sandable: 2 hours  
Time to Paint: 2 hours, 4B (excellent rating)  
Shear Strength: Over 2,000 PSI  
Low-temperature Flexibility: 10°F (-12°C)  
Percent Solids: 100%  
Sag: Zero, 15 minutes at room temperature  
Ultraviolet Resistance: 500 hours exposure, no deterioration  
Temperature Range: -40°F to +350°F (-40°C to +177°C)

### Minimum Welding Locations

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

