

MAXIM™ Bonding Adhesive Lifetime Warranty

NON-WELD

Evercoat® guarantees to the original purchaser that **Maxim™ Panel Bonding Adhesives** (812, 814 or 816) when used in strict accordance with Evercoat's application and use instructions, will provide a durable, corrosion-free bond for the life of the vehicle.

This warranty covers the actual cost incurred by the installer for labor, replacement parts and materials. It also covers compensation for a reasonable cost to the vehicle owner for the loss of use of the vehicle during replacement.

This warranty is voided if welding is used in conjunction with **Maxim™ Panel Bonding Adhesives**.

Evercoat's liability for breach of warranty hereunder is in all instances limited solely and exclusively to the reasonable cost of repairs and/or replacement of the bonded metal components of the vehicle.

Evercoat shall not be liable under any circumstance for any loss, damage, or expense directly or indirectly arising from the application and use of **Maxim™ Bonding Adhesives** sold hereunder or from any other cause. Evercoat shall not be liable under any circumstances for consequential or incidental damages.

Maxim™ Metal Bonding Adhesives shall only be used to bond metal to metal in full or partial replacements of door skins, quarter panels, roof skins, rear body panels.

Maxim™ Universal Bonding Adhesive can be used to bond SMC to SMC, SMC to metal or metal to metal in full or partial replacements of door skins, quarter panels, roof skins and rear body panels.

Evercoat Maxim™ Bonding Adhesives shall not be used for bonding of structural parts such as rails, pillars, rocker panels, core supports, etc.

A copy of this document must be retained with the original repair order. If a claim is submitted to ITW Evercoat this warranty is void unless a copy of the warranty and original repair order is submitted along with an estimate for repair.

Date of Repair _____	Repair Order # _____
Make/Model/Year _____	VIN # _____
Evercoat Product # _____	Batch # _____
Type of Repair _____	Technician _____

ADHESIVE / WELD BONDING

Evercoat guarantees to the original purchaser that **Maxim™ Panel Bonding Adhesives** (812, 814 or 816) when used in strict accordance with Evercoat's application and use instructions, will provide a durable bond for the life of the vehicle.

This warranty covers the actual cost incurred by the installer for labor, replacement parts and materials. It also covers compensation for a reasonable cost to the vehicle owner for the loss of use of the vehicle during replacement.

Evercoat's liability for breach of warranty hereunder is in all instances limited solely and exclusively to the reasonable cost of repairs and/or replacement of the bonded metal components of the vehicle.

Evercoat shall not be liable under any circumstance for any loss, damage, or expense directly or indirectly arising from the application and use of **Maxim™ Bonding Adhesives** sold hereunder or from any other cause. Evercoat shall not be liable under any circumstances for consequential or incidental damages.

Maxim™ Metal Bonding Adhesives shall only be used to bond metal to metal in full or partial replacements of door skins, quarter panels, roof skins and rear body panels.

Maxim™ Universal Bonding Adhesive can be used to bond SMC to SMC, SMC to metal or metal to metal in full or partial replacements of door skins, quarter panels, roof skins and rear body panels.

Evercoat Maxim™ Bonding Adhesives shall not be used for bonding of structural parts such as rails, pillars, rocker panels, core supports, etc.

This warranty is only valid if used in conjunction with compression and mig-welding techniques approved by I-CAR

A copy of this document must be retained with the original repair order. If a claim is submitted to ITW Evercoat this warranty is void unless a copy of the warranty and original repair order is submitted along with an estimate for repair.

Date of Repair _____	Repair Order # _____
Make/Model/Year _____	VIN # _____
Evercoat Product # _____	Batch # _____
Type of Repair _____	Technician _____



Metal-to-Metal Non-Structural Bonding Adhesive

Product: #100812 Fast Set and #100814 Medium Set Bonding Adhesive

FEATURES

- ✓ Meets GM6499G Automotive Specifications
- ✓ Low odor formula
- ✓ Contains glass beads to control bond line thickness
- ✓ Corrosion resistant properties; eliminates application of epoxy or self-etch primers
- ✓ No wax surface film after cure
- ✓ 1:1 mix ratio
- ✓ Cure time can be accelerated with heat

Preparation

1. Grind the bonding surface area of the frame to remove old adhesive, rust, welds and paint.
2. Straighten and align flanges and frames to insure proper fit of the new panel.
3. Using a new sanding surface disc, sand the surface to expose the bare metal leaving 1 – 1½" mating surface.
4. New panel: **Door Skin** - Scuff sand the door skin to remove gloss. Do not remove the e-coat.
Quarter, Roof Panels - remove all coatings to expose bare metal from all mating surfaces.

TECHNICAL DATA

Work Time	Medium	30-40 minutes
	Fast	10-15 minutes
Clamp Time	Medium	90 minutes
	Fast	30 minutes
Full Cure/Paint Time	Medium	8 hrs. @ 70°F
	Fast	4 hrs. @ 70°F
Lap Shear		
Cold Rolled Steel	Medium	meets or exceeds GM Spec
	Fast	meets or exceeds GM Spec
Aluminum	Medium	meets or exceeds GM Spec
	Fast	meets or exceeds GM Spec
Galvanneal	Medium	meets or exceeds GM Spec
	Fast	meets or exceeds GM Spec

Application

1. Equalize the cartridge according to "Cartridge Set-up Procedure".
2. Apply the bonding adhesive to the frame and the new panel. Brush the adhesive to a thin coat to cover all exposed bare metal.
3. Apply a bead to all mating surfaces (3/8-1/2").
4. Install the new panel to the frame. Slide the panel to reposition. Do not lift the panel to reposition.
5. Secure the panel with clamps or screws.
6. Allow the bonding adhesive to cure for the proper times before unclamping.

For More Information
www.evercoat.com
Tech Service
513-489-1941

Caution: Refer to the Material Safety Data Sheets, label and Product Information Sheets for safe use and handling instructions. Technical Data provided represent typical data. Not all tests are run on each batch of products. Fibre Glass-Evercoat does not have control over shop conditions and procedures, therefore the results may vary. Our products are intended for sale to professional and commercial customers. They are not intended for consumer use.

For additional information contact



Fibre Glass-Evercoat
a division of Illinois Tool Works Inc.
6600 Cornell Road
Cincinnati, Ohio 45242
(513) 489-7600
www.evercoat.com