

# Technical Data Sheet

## Metal Patch Panel Adhesive



### Overview

A fast-set, 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. Short, 15-minute work life for use on small panels and patches. 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

- Patch Panels
- 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 Patch Panel 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 Patch Panel Adhesive and install the KT13427 Turbo Mixer.
10. Apply a 3/8" bead of Patch Panel 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 Patch Panel 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 Patch Panel 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 Patch Panel 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" - 3/8"  
Work Life: 15 minutes, minimum  
Full Cure: 24 hours  
Sandable: 2 hours  
Time to Paint: 2 hours, 4B (excellent rating)  
Lap Shear Strength: 1,800 to 2,400 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

