



PANEL BONDER 3500

TECHNICAL DATA SHEET



Item No. CE-PB

DESCRIPTION

Panel Bonder 3500 (Stock No. CE-PB) is a two-component panel bonding epoxy adhesive. Purchase includes 2 mixing nozzles.

FEATURES

- Includes written guarantee
- 10 mil glass bead technology for bond gap control
- Anti-corrosion formula bonds to bare metal without primer
- 0% V.O.C.'s

SUITABLE SUBSTRATES

- Aluminum
- Steel
- SMC
- FRP (fiber reinforced plastic)

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Description:
CE-PB	Panel Bonder 3500	Black	7.3 fl. oz.

- Working Time: 90 minutes
- Clamp Time: 4 hours
- Cure Time: 24 hours

Always wear OSHA required (PPE) Personal Protection Equipment as outlined on the SDS and product label to ensure your safety.

GENERAL INFORMATION:

The larger chamber contains a black epoxy based resin; the smaller side contains a beige catalyst system. Refer to the MSDS documents for additional information on safety and handling before use.

Crest's Epoxy Cartridge System is sold as a kit and performance has been verified using the kit contents. Do not attempt to use other mixers, for example, in the application of this product. Additional mixers (**Stock No. GP-MN**) are available.

Important: NOT to be used for bonding structural components. **NOTE:** For structural components, Crest carries Ashland 5770P Impact Durable Structural Adhesive. For detailed guidelines, refer to the specific OEM repair procedure.



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HANDLING AND APPLICATION

1. Remove damaged panel and grind all paint, rust, E-coat and galvanized from the surfaces to be bonded (including replacement panel), using a 36 grit abrasive disc, making sure to grind all areas to be bonded to the bare metal. **Note:** Uniform sparks should be flowing off the disc to ensure removal of the galvanized coating. When sectioning, the seam will need to be adequately beveled to assure a smooth transition to the existing panel so as to prevent ghost lines when painted.
2. Blow off all surfaces to be bonded with clean, dry air.
3. Straighten all metal, align replacement panel and dry fit the part with the suspension loaded. Make sure flanges meet flush. Building stress into the joint could cause failure.
4. Remove the part from the vehicle, clean surfaces with **Crest Acry-Solv (AAS or BSA)** and allow to dry.
5. Remove protective cover from nozzle end of Panel Bonder 3500. Insert flat screwdriver in top slot of plug and pry off to expose openings.
6. Load cartridge into **Stock No. GT-SU Applicator Gun** or **Stock No. GP-AO Air Gun**. Prior to attaching static mixer nozzle, dispense a small amount of adhesive to be sure that both sides flow evenly.
7. Install static mixer, **Stock No. GP-MN**. There is no need to cut the tip, due to excellent flow characteristics of this product. Dispense 1-2" of material and dispose, observing for desired mix and delivery.
8. Apply a 3/8" - 1/2" bead of adhesive to all areas to be bonded, then tool the adhesive evenly, making sure to cover all surfaces of bare metal.
9. Align the parts to be bonded and apply even pressure. After the panel has been positioned, do not pull it from the vehicle. Instead, if repositioning is required, slide the panels against one another insuring no air is trapped in the bond line.
10. Clamp tightly every 4" - 6" to ensure even clamping. The 10 mil glass beads will prevent over-clamping and allow proper bond line thickness.
11. Install screws or rivets in "hard to clamp" areas.
12. Tool the adhesive squeeze-out into the seam as you would with any traditional seam sealer.
13. Proceed with welding where required and in accordance with OEM recommendations. Exercise caution where welding as the adhesive can be combustible; we suggest welds to be at least 2 inches from the adhesive. Crest **Weld Seal Primer (AS-W)** is recommended for corrosion protection for welded areas only.
14. Clamp a minimum of 4 hours at 74°F. Longer clamp times may be necessary if lower temperatures are experienced. Clamp times may be accelerated by use of a heat gun or lamp.
15. Remove any excess adhesive from the sectioned area (if applicable). Additional grinding may be needed to assure a smooth seam. Finish seam with Crest **Rigid Red Epoxy (TER)** or **Shark Bite body filler (BSB)** followed by **Skim Coat Body Glaze (BSC)**. Allow proper dry time.
16. Sand, finish, and paint vehicle as needed.
17. Vehicle may be returned to service after 24 hours.

STORAGE

For future use of the adhesive, after removing from the gun, either leave the mixing tip on or replace the original plug, removed in Step 5. Store the partially used cartridge on its side for future uses.



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RELATED PRODUCTS

Part:	Product Name:	Size:
GT-SU	Universal Twin Cartridge Gun	Each
GP-AO	Air Gun	Each
BS-A	Acry-Solv	Quart
AA-S	Acry-Solv	17.25 OZ Aerosol
AS-W	Weld Seal	12.75 OZ Aerosol
GP-MN	Mixing Nozzle	Each
GPMN-50	Mixing Nozzle	50/Pk
TE-R	Rigid Red Epoxy	22 OZ Tube
BS-B	Shark Bite Body Filler	0.8 Gallon
BS-C	Skim Coat Body Glaze	32 fl. oz.

TECHNICAL CONSULTATION SERVICE

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 822-4100 for answers to your questions. Hours of operation are Monday through Friday 8:00 am until 4:30 pm EST.



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WARRANTY

Crest Industries, Inc. ("Crest") warrants to the original purchaser ("Purchaser") that its Panel Bonder 3500, Stock No. CE-PB ("Product"), will, when applied in accordance with the Crest Panel Bonding Guide (on the backside of this warranty statement), provide a bond for the life of the vehicle. The foregoing is Crest's sole and exclusive warranty, and all other warranties, express or implied, including the implied warranties of merchantability and fitness for a particular purpose, are excluded and disclaimed by Crest.

If this warranty is breached and the other conditions set forth herein have been met, Crest shall, as its sole and exclusive liability and Purchaser's sole and exclusive remedy, reimburse Purchaser for the reasonable costs of repair and/or replacement of the bonded components of the vehicle and loss of use of the vehicle. Except as provided above, Crest shall not be liable under any circumstance for any loss, damage, or expense directly or indirectly arising from the application and use of Product, and Crest shall not be liable for consequential or incidental damages.

The Product should only be used for bonding steel, aluminum, SMC or FRP in full or partial panel replacements as described on the Panel Bonding Guide on the backside of this warranty statement. The Product must not be used for bonding structural components.

This warranty is only valid if claim has been filed within 20 days of the discovery of the purported breach and the Warranty registration form set forth below has been filed with Crest within 60 days of application of the Product. Warranty registration forms should be sent to:

Crest
Industries, Inc.
1337 King Road
Trenton, MI 48183
Attention: Warranty Claims Manager

WARRANTY REGISTRATION FORM

Date _____ Repair Order # _____
Shop Name _____ Make/Model/Year _____
Address _____ VIN _____
Phone _____ Type of Repair _____
Repair Technician _____
Cartridge Lot No. _____ Date Performed _____

If Product cartridge is used on multiple vehicles, copy blank form and send a completed form for each vehicle.