



www.medallionrefinish.com

5751 N. Webster Street
Dayton, OH 45414-0802
Phone 937-890-6547
Toll Free 800-257-6547
Fax 937-890-6320

RS-7190

TECHNICAL DATA

Epoxy Panel Bonder (Epoxy)

DESCRIPTION:

RS-7190 Epoxy Panel Bonder is an epoxy based adhesive designed to be used on door skins/quarter-panels and large panels. It has excellent adhesion to cold rolled steel, aluminum, galvanized, SMC, FRP and other composite plastics. It has an open time 75-90 minutes which allows time to apply the adhesive and install the panel. **RS-7190 Epoxy Panel Bonder** is designed for use on medium to large panels. This Epoxy Panel Bonder is an excellent product for commercial truck shops.

FEATURES:

- ✓ Excellent sag resistance
- ✓ 75-90 minute work time
- ✓ Clamp time 4 hours for quarters
- ✓ Excellent adhesion
- ✓ Uses RS-852 Premium Dual Component Gun
- ✓ Does not require a primer
- ✓ 2:1 mix ratio
- ✓ 24 hour full cure
- ✓ Sandable
- ✓ Paintable

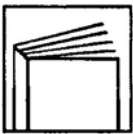


2 to 1 mix



PANEL REMOVAL

Remove damaged panel from vehicle. Be careful not to cut into adjacent panels, mating flanges or reinforcements.



SURFACE PREPARATION:

(Inner Panel)

Remove all adhesive, sealants and foams using a surface disc. Grind the mating areas with 80 grit. Surface must be cleaned to bare metal. Straighten all damaged metal. Dry fit the new panel for proper fit.

(New Panel)

Clean the bonding areas of the new panel with wax & grease remover before prepping surface. Using a coarse surface prep disc, remove E-coat from all areas to be bonded. Grind the mating areas with 80 grit. Dry fit the panel. Clamp the part in place and check for proper fit and alignment. Adjust the clamps for proper tension. Remove the new panel.

PRODUCT / PACKAGE SET-UP:

Static mix cartridge must be equalized before use. Gun out a test bead to check for proper mixing before applying to panels.

APPLYING PANEL BONDING ADHESIVE:

Clean all the surfaces to be bonded with wax & grease remover and allow to thoroughly dry. Force dry with clean air source and a blow gun.



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Run a generous bead of Epoxy Panel Bonder that will be sufficient to cover the entire bonding area of both panels. Spread the adhesive out to cover all bare metal to a thickness of at least 1/16" on each panel.

INSTALLING THE NEW PANEL:

Fit the panel immediately. Slide the panel for proper fit and alignment. **Do not separate the two panels.** Position and install the clamps approximately 10-12" apart. Screws may be used in areas where clamps can not be installed. Remove any excess bonding adhesive with a squeegee, spreader or clean dry cloth.



CLEAN-UP:

RS-7190 Epoxy Panel Bonder can be wiped off using a clean dry cloth and a wax & grease remover or general purpose solvent before it cures.



STORAGE:

RS-7190 Epoxy Panel Bonder should be stored in a cool, dry area. To ensure maximum shelf life, store below 73°F (23°C) or refrigerate. It should not be exposed to conditions of elevated temperatures for long periods of time. Contents may prematurely age and react if exposed to temperatures in excess of 120°F (49°C).

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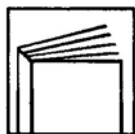
Medallion™
Refinish System



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TECHNICAL INFORMATION



Color	Opaque/black
Technology	Epoxy
Odor	Ammoniacal
Mix Ratio	2:1
Open Time	75-90 min.
Repositioning Time after clamped	45 min.
Clamp Time	
Thin bondlines	4 hrs.
Thick Bondlines	4 hrs.
Full Cure	24 hrs.
Dry to Sand 70°F (21°C) 50% RH	
Air Dry	4 hrs.
Force Dry(heat lamp or heat gun)	45 min. @ 200°F
V.O.C.	<2% volatile wt.
Coverage 1/4" bead	
Package	200 ml
Number per Case	6
Shelf Life	12 months
Tensile Shear	
Steel	3800 psi
Aluminum	3500 psi
ABS	800 psi
304 SS	4000 psi
T-Peel	
Steel / Steel .020 gap	40 pli
Steel / Steel .010 gap	40 pli
Side Impact Hammer (joules)	
Steel	4.5
Aluminum	4.5

RUBBER-SEAL® Material Safety Data Sheet (MSDS) is available on our website
www.medallionrefinish.com

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Refinish System