

# Technical Data Sheet

## Door Skin Sealer-Adhesive



### Overview

A two-part, high-strength epoxy sealer and adhesive for steel automotive door skins. Exceptional bond-strength on bare steel, E-coat, paint and primer. Seals and bonds in one step to prevent water leaks and corrosion. Long, 45 minute, work life for use on large doors. Medium gray color, packaged in an economical 10 oz. Dual Cartridge for use with the Kent Automotive Dual Cartridge Applicator Gun and Turbo Mixer.

### Features/Benefits

- Seals and bonds in one step – Saves time with fewer steps and products needed for a solid repair
- Specifically formulated for steel door skins – Provides maximum bond strength on steel door skins
- Non-sag formula, medium gray color – Won't run on vertical surfaces, covers easily with any color paint
- Excellent adhesion and flexibility – Makes durable, long-lasting repairs on steel door skins
- Sandable and paintable in an hour – Significantly reduces labor time on panel replacements

### Applications

- Door skins
- Deck lids
- Hoods

### Method of Application

- Dual cartridge

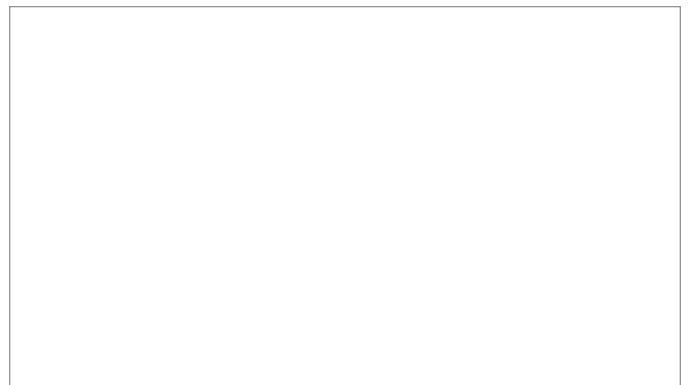
### Identification

- Adhesive


### Sizes

- 10 oz. (295ml) dual cartridge

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## Directions for Use

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1. Kent Automotive Door Skin Sealer-Adhesive is intended for exterior steel door panels and should not be used to bond structural components of any kind.
  2. Remove the old door skin using caution to minimize damage to the mating surfaces.
  3. 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.
  4. Trial-fit the replacement panel to ensure gaps don't exceed 1/8". Straighten or adjust the flanges until the fit is correct.
  5. Prepare the mating surfaces with Kent Automotive Acrysol™ to remove any grease, oil or other contaminants.
  6. Equalize the cartridge of Kent Automotive Door Skin Sealer-Adhesive and install the KT13427 Turbo Mixer.
  7. Apply a 1/4" bead of Door Skin Sealer-Adhesive to the door frame.
  8. Squeegee the Kent Panel Sealer-Adhesive onto the frame to ensure good contact and no air gaps.
  9. Place the door skin in position immediately; slide to realign if needed. Do not separate.
  10. Clamp or screw the door skin in place.
  11. Crimp the edge of the door skin around the edge of the door frame and smooth the seam with a hammer and dolly.
  12. Tool excess adhesive immediately and allow to cure. Heat may be used to speed curing: 150°F (65°C) maximum.
  13. Remove clamps after 1 hour.
  14. Repair cosmetic areas, prime and apply appropriate Kent Automotive seam sealers as needed, and paint. Apply corrosion protection products as needed.

## Technical Specifications

Application Thickness: 1/16" to 3/8"  
Work Life: 45 minutes, minimum  
Tensile Strength: 1,000 PSI  
Full Cure: 24 hours  
Sandable: 1 hour  
Time to Paint: 2 hours, 4B (excellent rating)  
Shear Strength: Over 1,000 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)