PANEL BONDING

Permanent, high-strength adhesion



Available in 210 mL cartridges with (3) 24-element nozzles (08-24D).

AE 260
Panel Bonding Adhesive

Heavy-bodied, high-strength 2:1 epoxy adhesive for composite and metal panel bonding applications. Contains glass beads to ensure proper bond line. Ideal for quarter panels, door skins with flanges, roof panels, truck box sides, and other outer body sheet metal. Delivers high peel and shear strength with weld-through capability for MIG and resistance spot welding. ***Not intended for use on structural components including core supports, rails, pillars, and rocker panels.***

Work Time: 60-90 minutes

Base Material: Epoxy **Color:** Black

MADE IN THE USA

TYPICAL WORKING PROPERTIES

	Part A	Part B	Mixed
Color:	Black	Amber	Black
Viscosity @ 77°F, cps:	200,000 – 400,000	75,000 – 125,000	—
Weight per Gallon, pounds:	10 – 10.5	8.5 – 9.0	9.3 – 9.8
Filler Type:	Non-Abrasive	Non-Abrasive	Non-Abrasive
Gel Time (1/8" bead @ 77°F), minutes:	—	—	60 – 90
Shelf Life, sealed containers:	12 months	12 months	—

Mix Ratio

	Parts By Weight	Parts By Volume
AE 260 Part A:	100	2
AE 260 Part B:	49	1

Recommended Cure Schedule

7 days at 77°F **OR** 2 hours at 150°F **OR** 1 hour at 179.6°F

Typical Cured Physical Properties

Hardness, Shore D:	65 – 75
Lap Shear Strength, (Al/Al) @ 77°F, psi:	4,240

Disclaimer

Due to variations in the storage, handling, and application of these materials, Adhesive Engineering makes no representations or warranties of any kind, expressed or implied, concerning their performance and shall not accept liability for the results obtained.

Caution

For professional use only. Refer to the Safety Data Sheet (SDS) and product label for safe use and handling instructions.

Directions

1. Ensure surfaces are clean, dry, and free of dirt, grease, oil, rust, paint, and other contaminants.
2. Scuff mating surfaces to bare metal where required. Not to be used with metal primers.
3. Test fit panels and prepare clamping before application.
2. Load the cartridge into a compatible dispensing gun. Remove cap and dispense a small amount to equalize pistons.
5. Attach mixing tip and dispense a small amount to ensure proper mixing.
6. Apply a continuous bead, assemble panels, and clamp to maintain alignment and bondline thickness.
7. Allow to cure before removing clamps, sanding, or refinishing. Prime and paint per manufacturer recommendations.

Preserving Unused Product

Replace the dual plug and secure with the cap.

Storage and Handling

Store indoor in a cool, dry location at a temperature between 50°F to 86°F. Protect from freezing.

Disposal

Dispose of contents and container in accordance with all federal, state, and local laws.

Warning

For industrial use only. Handle with care. An MSDS is available upon request. Prolonged skin contact may cause irritation or dermatitis. Wear eye protection and appropriate gloves when handling. If swallowed, seek medical attention immediately.

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ADHESIVE ENGINEERING

Adhesive Engineering is a division of Barker Industrial Group.
For over 30 years, we've worked alongside distributors, OEMs, manufacturers, and end users to develop adhesive and dispensing solutions for demanding real-world applications.

For more information and samples, contact your local distributor or an AE representative.
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