

Panel Bonding (Excluding Door Skin)		
<b>1</b>		<p><b>Host Panel Preparation</b> Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt to remove all adhesive, corrosion and coatings.</p>
<b>2</b>		<p><b>Replacement Panel Preparation</b> Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.</p>
<b>3</b>		<p><b>Clean</b> Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
<b>4</b>		<p><b>Dry Fit Panel</b> Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove panel in preparation for adhesive application.</p>
<b>5</b>		<p><b>Weld-Thru Primer</b> Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.</p>
<b>6</b>		<p><b>Pre-Assembly NVH Replacement</b> If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
<b>7</b>		<p><b>Apply Bonding Adhesive</b> Apply adhesive to mating flange areas on host panel and replacement panel, covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
<b>8</b>		<p><b>Install Replacement Panel</b> Install replacement panel to host panel. Clamp in place and make required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use, or the OE manufacturer. Follow recommended adhesive clamp times.</p>
<b>9</b>		<p><b>Adhesive Clean Up</b> Tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. <b>Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.</b></p>
<b>10</b>		<p><b>Post-Assembly Foam Replacement</b> Apply foams at original locations as required.</p>
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Product List	
3M™ File Belt Sander, PN 28366	
3M™ Cubitron™ II File Belt, grade 80+, PN 33446	
Scotch-Brite™ Durable Flex Belt, CRS, PN 64475	
Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470	
Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466	
3M™ Weld-Thru Coating II, PN 05917	
3M™ NVH Dampening Material, PN 04274	
3M™ Flexible Foam, 200mL, PN 08463	
3M™ Panel Bonding Adhesive, 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115; 50mL, PN 38315	
3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219	
3M™ Rigid Pillar Foam, 200mL, PN 08458	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07182	
3M™ Lexa™ Protective Eyewear, PN 15200	