



3M Panel Bonding Process

PERSONAL SAFETY

• Comfort Particle Mask P2



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



1 Host Panel Preparation



- Remove remaining material and contaminants from host panel. Prep remaining mating flanges on host panel with a Scotch-Brite™ Belt or Disc



3M™ Scotch-Brite™ File Belts



3M™ Scotch-Brite™ Roloc™ Disc



3M™ Body Repair Pistol Grip Disc Sander

2 Cleaning of the surface



- Degreasing host panel mating flange areas



3M™ General Purpose Adhesive Cleaner



3M™ Professional Panel Wipes

3 Replacement Panel Preparation



- Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt

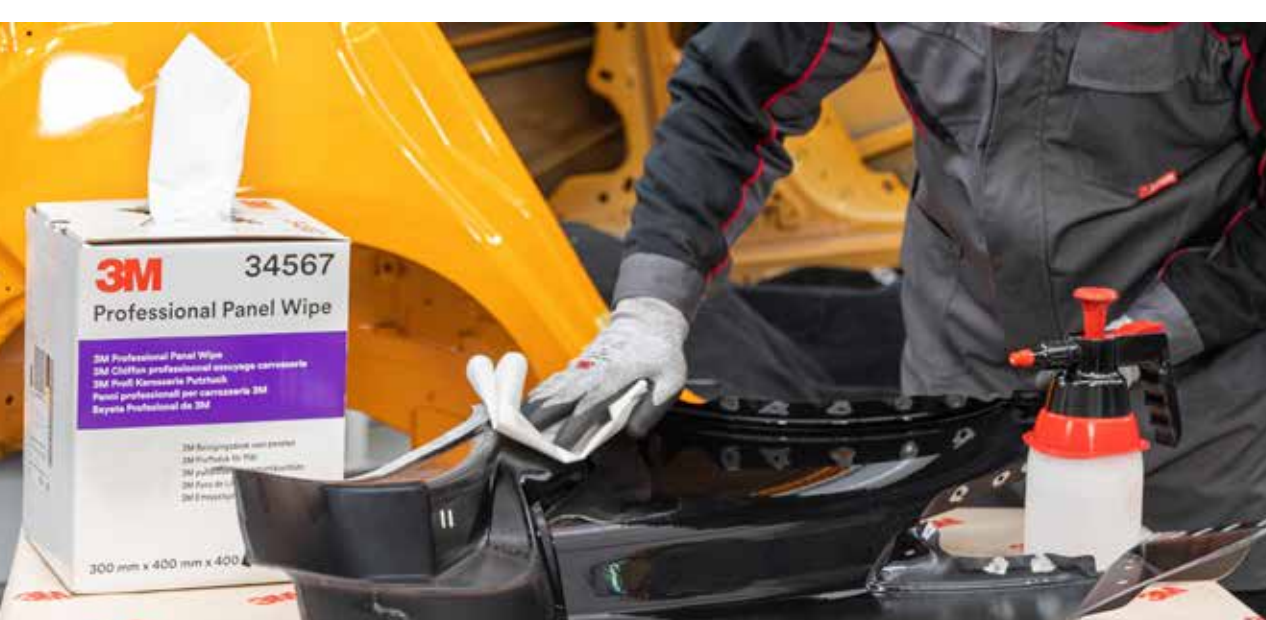


3M™ Scotch-Brite™ File Belts



3M™ File Belt Tool

4 Cleaning of the surface



- Degreasing replacement panel mating flange areas



3M™ General Purpose Adhesive Cleaner



3M™ Professional Panel Wipes

5 Corrosion Protection



- Apply weld-thru primer to all areas on host panel and replacement panel requiring welding operations, except the areas for bonding
- Two layers are recommended to obtain the right coating thickness for optimum corrosion protection
- Drying time: 10 - 20 minutes



3M™ Weld Thru II Primer

6 Calibration of a new cartridge



- Insert the cartridge into a suitable application gun
 - Before attaching the mixer to the cartridge, squeeze out a small amount of material until both components are equally extruded
 - Attach the mixing nozzle and discard the first 2-4 cm of extruded material, to remove any improperly mixed material
- Note: The previous step is only necessary when using a new cartridge.



3M™ Panel Bonding Adhesive



3M™ Pneumatic Applicator for 200ml Duopack Cartridge



3M™ Manual Applicator for 200ml Duopack Cartridge

7 Application



- 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 and all voids are filled

8 Install Replacement Panel



- Install replacement panel to host panel by clamping in place
 - Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use from the car manufacturer
- Note: Follow recommended adhesive clamp times: ~ after 4h @ 23°C ambient temperature

9 Adhesive Clean Up



- Tool excess adhesive squeeze-out from repair area prior to curing to seal the repair
- Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion



3M™ General Purpose Adhesive Cleaner



3M™ Professional Panel Wipes