## Weld Bonding (Excluding Door Skin)

### Host Panel Preparation
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.

### Mating Flange Panel Preparation
Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.

### Clean
Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.

### Dry Fit Panel
Dry fit replacement panel and complete any necessary metal straightening at flanges areas.

### Weld-Thru Primer
Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. **Caution: Do not use Weld-Thru Primer in adhesive bonding areas.**

### Spot Weld Surface Preparation
Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ belt where spot weld tips will contact host and replacement panel. Remove panel once complete.

### Pre-Assembly NVH Replacement
If vehicle construction necessitates, apply NVH material or foams at original locations as required.

### Apply Bonding Adhesive
Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange areas.

### Install Replacement Panel
Install replacement panel to host panel. Clamp in place.

### Spot Weld
Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.

### Adhesive Clean Up
Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. **Note: Grindong to remove excess adhesive can expose bare metal, causing corrosion.**

### Post-Assembly Foam Replacement
Apply foams at original locations as required.

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### Note:
Follow recommended internal corrosion protection processes prior to vehicle final assembly.

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### Product List

#### 3M™ Panel Bonding Adhesive,
50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115

#### 3M™ Impact Resistant Structural Adhesive
200mL, PN 07333; 450mL DMS, PN 57333

#### 3M™ Composite and Metal Bonding Adhesive,
200mL, PN 06219

#### 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
Respirator, PN 07182

#### 3M™ Virtua™ Protective Eyewear
Eyewear, PN 11326

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### WARNING
Follow OEM and/or welder manufacturers’ recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

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Visit 3MCollision.com for more SOPs and videos
Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at 3MCollision.com

For product material safety data sheets see 3MCollision.com

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