

**Composite Panel Removal and Installation**

<b>1</b>		<p><b>Clean the Panels</b></p> <p>Clean panels with soap and water followed by a VOC compliant surface cleaner. Thoroughly dry the parts. <b>DO NOT</b> apply any other cleaners throughout the remainder of the removal and installation procedure.</p>
<b>2</b>		<p><b>Panel Removal</b></p> <p>Heat the bond line to 250–300°F and gently pry the panels apart with a rigid putty knife or equivalent. Remove all adhesive from the undamaged part using the same process as below. Let the surface cool.</p>
<b>3</b>		<p><b>Surface Prep</b></p> <p>Sand the surfaces to be bonded using a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a low speed to rough up the area, or a P80 abrasive disc on a DA. Blow off the repair area with clean, dry air and a clean cloth. <b>Note: If flame heat was used to help separate panels it's a must that the after burn be removed with a P80 abrasive disc.</b> For metal parts, nothing coarser than P80 is necessary.</p>
<b>4</b>		<p><b>Dry Fit Parts</b></p> <p>Dry fit all parts to ensure a good fit before dispensing and applying adhesive.</p>
<b>5</b>		<p><b>Apply Adhesive</b></p> <p>Follow the Directions for Use to prepare, mix and apply 3M™ SMC/FRP Repair Adhesive. Apply a continuous bead to one part. <b>Note: If you need to adjust the part, slide the part to prevent air pockets in the adhesive bead.</b></p>
<b>6</b>		<p><b>Bond</b></p> <p>Mate the parts. Apply clamps to the bonded panel surface and clamp within the desired area. <b>Note: Apply as many clamps as needed to bring the panels together. Make sure NOT to over clamp, which can result in squeezing the bondline dry of adhesive.</b> Remove any excess adhesive squeeze out.</p>

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**Product List**

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378



3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 80+ grade, PN 31371



Scotch® Performance Green Masking Tape 233+, 18mm width (.71 in.), PN 26334



3M™ SMC/FRP Repair – 10, 400mL, PN 08272



3M™ SMC/FRP Repair – 35, 400mL, PN 08273



3M™ SMC/FRP Repair – 90, 400mL, PN 08274



3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280



**Think About Your Health**

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

## 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](http://3MCollision.com)

For product material safety data sheets see [3MCollision.com](http://3MCollision.com)

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**IMPORTANT NOTE:** There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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