

Aluminum Rivet Bonding		
1		Host Panel Preparation Using a grade 80 abrasive belt, remove remaining rivet material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Durable Flex Belt.
2		Mating Flange Panel Preparation Remove E-coat from replacement panel mating flange areas using a Scotch-Brite™ Belt or Clean and Strip Disc.
3		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
4		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
5		Rivet Preparation Identify replacement rivet sites and prepare the surface for the type of rivet recommended by the manufacturer. (For blind or solid rivets, drill all necessary holes.) Remove panel once complete.
6		Pre Assembly NVH Replacement If vehicle construction necessitates, apply 3M™ NVH Dampening Material or 3M™ Flexible Foam at original locations as required.
7		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 area to ensure proper bond line thickness.
8		Install Replacement Panel Install replacement panel to host panel taking care to avoid scraping off any adhesive during installation. Clamp in place.
9		Install Rivets and Welds Install replacement rivets to all areas as recommended by the OE manufacturer. Note: Rivets must be installed while adhesive is uncured. Weld cosmetic joints/splices as necessary or recommended by the OE Manufacturer.
10		Adhesive Clean Up Remove clamps and tool excess adhesive squeeze out from repair area prior to curing to seal the repair. An acid brush works well to remove adhesive from between clamps. Note: Grinding to remove excess cured adhesive can expose bare metal, causing corrosion.
11		Post Assembly Foam Replacement Apply foams at original locations as required.

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Product List	
3M™ File Belt Sander, 18 in., PN 33575	
3M™ Cubitron™ II File Belt, grade 80+, PN 33446	
Scotch-Brite™ Durable Flex Belt, CRS, PN 64475	
Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552	
Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555	
3M™ NVH Dampening Material, PN 04274	
3M™ Flexible Foam, 200mL, PN 08463	
3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115	
3M™ Composite and Metal Bonding 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™ Virtua™ Protective Eyewear, PN 11326	

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

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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