

Door Skin Replacement		
1		<p>Door Frame Preparation</p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ belt.</p>
2		<p>Clean</p> <p>Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
3		<p>Replacement Skin Prep</p> <p>Scuff replacement skin mating flange areas using Scotch-Brite™ hand pad.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.</p>
5		<p>NVH Replacement</p> <p>Apply NVH material at original locations on intrusion beam.</p>
6		<p>Apply Bonding Adhesive</p> <p>Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
7		<p>Install Door Skin</p> <p>Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)</p>
8		<p>Clamp and Cure</p> <p>Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze-out from hem flange area with a VOC compliant cleaner.</p>
9		<p>Seam Sealing</p> <p>Re-apply seam sealer to hem flange as required following general seam sealing guidelines.</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™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659	
Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926	
3M™ NVH Dampening Material, PN 04274	
3M™ Urethane Seam Sealer, PN 08361	
3M™ MSP Seam Sealer, PN 08370	
3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115	
3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219	
3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310	
3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887; 600mL DMS, PN 55887	

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	

Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

Individual Product Instruction and Safety Information

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

For product material safety data sheets see go.3M.com/SDS

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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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