




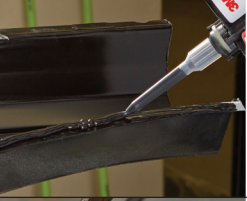





Panel Bonding (Excluding Door Skin)		
1		<p>Host Panel Preparation</p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.</p>
2		<p>Replacement Panel Preparation</p> <p>Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip Disc.</p>
3		<p>Clean</p> <p>Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flange areas. Remove panel in preparation for adhesive application.</p>
5		<p>Pre Assembly NVH Replacement</p> <p>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
6		<p>Apply Bonding Adhesive</p> <p>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.</p>
7		<p>Install Replacement Panel</p> <p>Install replacement panel to host panel. Clamp in place and make required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use, or the OE manufacturer. Follow recommended adhesive clamp times.</p>
8		<p>Adhesive Clean Up</p> <p>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.</p>
9		<p>Post Assembly Foam Replacement</p> <p>Apply foams at original locations as required.</p>

Visit 3MCollision.com for more SOPs and videos

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

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

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



3M Automotive Aftermarket Division
3M Center, Building 223-6S-07
St. Paul, MN 55144-1000
U.S.A.

3M, Accuspray, Cubitron, E-A-R, Hookit, Platinum, PPS, Rocker Gard, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, Trizact and Virtua are trademarks of 3M Company. All other trademarks are property of their respective owners.

Web 3MCollision.com

Please recycle. Printed in U.S.A. © 3M 2019. All rights reserved. Rev 7/19.

60-4402-8068-7