






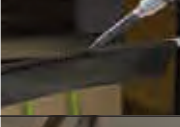






Weld Bonding (Excluding Door Skin)

1		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.
2		Mating Flange Panel Preparation Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.
3		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
5		Weld-Thru Primer Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.
6		Spot Weld Surface Preparation Identify replacement spot weld sites and remove Ecoat using Scotch-Brite™ belt where spot weld tips will contact host and replacement panel. Remove panel once complete.
7		Pre-Assembly NVH Replacement If vehicle construction necessitates, apply NVH material or foams at original locations as required.
8		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.
9		Install Replacement Panel Install replacement panel to host panel. Clamp in place.
10		Spot Weld Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.
11		Adhesive Clean Up Remove clamps and 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.
12		Post-Assembly Foam Replacement Apply foams at original locations as required.

Visit www.3m.com.au/aad or 3m.co.nz/aad for SOP's and videos

⚠ 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.

Product List ANZ

3M™ Cubitron™ II File Belt, grade 80+, PN 33440



Scotch-Brite™ Durable Flex Belt, CRS



Scotch-Brite™ Clean N Strip Disc, PN 57016 or Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466



3M™ Weld-Thru Coating II, PN 05917



3M™ Panel Bonding Adhesive, 200mL, PN 08115;



3M™ Flexible Foam, 200mL, PN 08463



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 07502 with appropriate cartridge



3M™ Lexa™ Protective Eyewear, PN 15200 or 3M Secure Fit SF401AF-AS



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

For ordering information, contact your 3M Sales Representative