

Door Skin Replacement		
1		Door Frame Preparation 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.
2		Clean Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.
3		Replacement Skin Prep Scuff replacement skin mating flange areas using Scotch-Brite™ hand pad.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.
5		NVH (Noise, Vibrations and Harshness) Replacement Apply NVH material (Seam Sealer 8369 or 8370) at original locations on intrusion beam.
6		Apply Bonding Adhesive 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.
7		Install Door Skin Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary.
8		Clamp and Cure Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze-out from hem flange area with a VOC compliant cleaner.
9		Seam Sealing Re-apply seam sealer to hem flange as required following general seam sealing guidelines.

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Product List ANZ	
3M™ Cubitron™ II File Belt, grade 80+, PN 33440	
Scotch-Brite™ Durable Flex Belt, CRS	
Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 115mm x 230mm, Very Fine, PN 64659	
Scotch-Brite™ 7447 Hand Pads, Very Fine, 150mm x 230mm PN 64926	
3M™ MSP Seam Sealer, PN 08370 (grey) or PN 08369 (white)	
3M™ Panel Bonding Adhesive, 200mL, PN 08115;	
3M™ EZ Sand Multi- Purpose Flexible Adhesive, 200mL, PN 05887	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07502 and Appropriate cartridge	
3M™ Lexa™ Protective Eyewear, PN 15200 or 3M Secure Fit SF401AF-AS	