

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

Visit [www.3M.com.au/aad](http://www.3M.com.au/aad) or [www.3m.co.nz/aad](http://www.3m.co.nz/aad) for more SOPs and videos

Product List ANZ 3M™	
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	