

**3M** Science.  
Applied to Life.™



3M Automotive Aftermarket

# 3M™ Panel Bonding Adhesive

Trusted and recommended  
for over 15 years.

# Proven and trusted performance.

This two-part epoxy adhesive has been used in replacement of outer body panels for well over 15 years. It is accepted and recommended industry wide as a bonding solution that technicians have come to rely on daily when making quality repairs.

## Applications

- Door skins
- Quarter panels
- Truck box sides
- Roof skins
- Bumper cover and plastic repair (under certain conditions)

## Product Usage

OEM's and third parties often call for the use of adhesive in outer panel replacements. In many cases the use of adhesive alone is specified, or its use in conjunction with weld bonding or rivet bonding is recommended. 3M™ Panel Bonding Adhesive is intended to provide additional bond strength to the replaced outer panel while also providing corrosion resistance.

### Areas of typical usage\*

**Blue** Adhesive bonded areas

**Red** Suggested welded areas

\*NOTE: This product is not intended to bond structural components of a vehicle such as pillars, rockers or frame members. If doubt exists as to whether a particular component is structural, then that component should be welded. For structural based repairs consider 3M™ Impact Resistant Structural Adhesive.



Door skin



Quarter panel



Truck box side assembly



Truck box side panel




Roof skin



Van side

## 3M™ Impact Resistant Structural Adhesive

	Part No.	Size	Colour	Chemistry	Work Time	Clamp/ Handling Time	Cure Time
	07333	200mL	Dispenses Silver, Cures Purple	Epoxy	60 min @ 21°C 30 min @ 80°C (may be accelerated with heat)	8 hrs @ 21°C (may be accelerated with heat)	24 hrs @ 21°C

# How are you inhibiting corrosion today?

## Corrosion

The use of 3M Panel Bonding Adhesive with corrosion inhibitors completely seals weld or rivet bonded joints, preventing corrosion.

## Save Valuable Time & Process Steps for Shops

3M Panel Bond Adhesive can cut down on process steps, reduce time and speed up the repair simply by cutting down on the number of components that need to be removed. Interior disassembly as well as possible interior damage, due to the welding process, can be greatly minimised when using 3M Panel Bonding Adhesive.

## Noise Vibration Harshness (NVH)

The use of 3M Panel Bonding Adhesive provides an added layer of noise and vibration damping protection.



Corrosion

## Welding vs. Adhesive Bonding

	Welding	Adhesive Bonding
Permanence	Permanent	Permanent
Stress Distribution	Local stress points in structure	Good uniform load distribution (except in peel mode)
Appearance	Usually acceptable (some dressing may be required)	No surface marking and joint almost invisible
Materials Joined	Limited to similar material groups (generally)	Ideal for most dissimilar materials
Corrosion Resistance	Accelerates corrosion	Excellent fatigue and electrical resistance reduces corrosion

# Did you know?

You can weld through uncured 3M™ Panel Bonding Adhesive (PN 08115) using squeeze-type resistance spot welding to form a weld bonded joint.

3M Panel Bonding Adhesive (PN 08115) is approved by Toyota, Mitsubishi, Chrysler, Honda, GM, Ford and many other OEM's and third parties recommend 3M Panel Bonding Adhesive.

Learn more at [3m.com.au/aad](https://3m.com.au/aad).

3M Panel Bonding Adhesive (PN 08115) can be “heat set” in as little as 15 minutes to handling strength.

3M Panel Bonding Adhesive has excellent adhesion to cold rolled steel, aluminium, sheet molded compound (SMC), fibre reinforced plastic (FRP) and more.

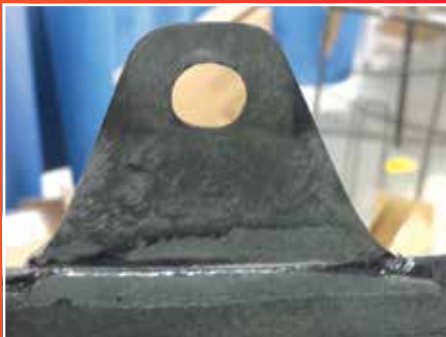
3M Panel Bonding Adhesive (PN 08115) works very well to repair many plastic substrates without the application of adhesion promoter.



Weld Bond



Rivet Bond



Plastic Repair

## Training Video



Scan QR Code for more information about PN 08115



For training videos and more  
[3m.com.au/aad](https://3m.com.au/aad)



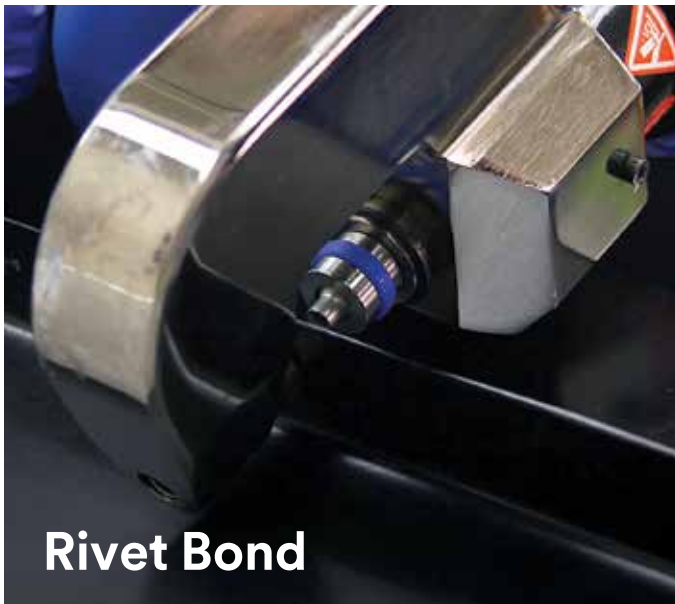
# 3M™ Panel Bonding Adhesive

- OEM and third party referenced for use in repairs
- Room temperature curing (accelerated curing with heat)
- Can be weld bonded or rivet bonded through prior to curing
- Corrosion inhibiting formula
- Two-part epoxy technology
- Excellent adhesion to cold rolled steel, aluminium, sheet molded compound (SMC), fibre reinforced plastic (FRP) and more



Part No.	Size	Colour	Chemistry	Work Time	Clamp/Handling Time	Cure Time
08115	200mL	Black	Epoxy	90 min @ 21°C / 45 min @ 32°C (may be accelerated with heat)	4 hrs @ 21°C (may be accelerated with heat)	24 hrs @ 21°C
38315	50mL					21°C

**3M Panel Bonding Adhesive provides a continuous bond and seals weld and rivet bonded areas against corrosions.**



# 3M™ Panel Bonding Adhesive



Part No.	Size	Colour	Chemistry	Work Time	Clamp/ Handling Time	Cure Time
08115	200mL	Black	Epoxy	90 min @ 21°C	4 hrs @ 21°C (may be accelerated with heat)	24 hrs @ 21°C
38315	50mL			45 min @ 32°C (may be accelerated with heat)		

## Applicators

	Part No.	Size
3M™ Performance Manual Applicator 	08117	200mL
3M™ Manual Cartridge Applicator 	08571	200mL
3M™ Performance Manual Applicator 	08190	50mL

## Accessories

	Part No.	Size
3M™ Static Mixing Nozzle 	38191	50mL
	38193	
	08193	200mL,
	08194	400mL

## Substitution

3M™ Panel Bonding Adhesive can be used in outer body panel bonding applications, including weld bonding or rivet bonding of non-structural vehicle components. Where specified by an OEM, 3M recommends following that particular recommended product use or practice. Where non-structural bonding is being conducted and an OEM has not provided specific guidance on the use of a panel bond adhesive, 3M would recommend the use of PN 08115 in the repair (including weld bonding or rivet bonding applications) following stated 3M directions for use, given they both serve as outer body panel bonding adhesives. For best results, 3M recommends referencing the OEM recommendations, where provided or available, in a repair situation in addition to the 3M directions for use. While it is the responsibility of the repairer to evaluate the overall situation in order to decide which product is fit for the specific use, 3M supports the use of 3M Panel Bonding Adhesive for panel replacements in cold repair, rivet bonded and weld bonded applications. Subject to the conditions described above, 3M Panel Bonding Adhesive should be appropriate for use in all outer panel bonding applications when directions for use are followed, where the following products are recommended: 3M™ Scotch-Weld™ Epoxy Adhesive DP490 or OEM Self-Branded Adhesives used in exterior panel attachment.

Learn more about our complete system of body repair solutions at [3m.com.au/aad](http://3m.com.au/aad)



 /3MCollisionRepairANZ

 /3Maadaustralia



Want a product sample or demo, or to speak to a 3M expert? Let us know here: <http://go.3m.com/4AHf>

For videos and more, visit: [3m.com.au/aad](http://3m.com.au/aad)

3M Automotive  
Aftermarket Division  
Building A, 1 Rivett Rd  
North Ryde, NSW, 2113

Phone 136-136  
Web [www.3m.com.au/aad](http://www.3m.com.au/aad)



 SUBSCRIBE to our channel to watch comprehensive instructional videos [www.youtube.com/3MAADAustralia](http://www.youtube.com/3MAADAustralia)

 LIKE us on FACEBOOK [www.facebook.com/3mcollisionrepairanz](http://www.facebook.com/3mcollisionrepairanz)