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.

3M™ Impact Resistant Structural Adhesive

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Size</th>
<th>Colour</th>
<th>Chemistry</th>
<th>Work Time</th>
<th>Clamp/Handling Time</th>
<th>Cure Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>07333</td>
<td>200mL</td>
<td>Dispenses Silver, Cures Purple</td>
<td>Epoxy</td>
<td>60 min @ 21°C 30 min @ 80°C (may be accelerated with heat)</td>
<td>8 hrs @ 21°C (may be accelerated with heat)</td>
<td>24 hrs @ 21°C</td>
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3M™ Impact Resistant Structural Adhesive

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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.

Welding vs. Adhesive Bonding

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

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.

Training Video

Scan QR Code for more information about PN 08115

For training videos and more 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

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

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<tr>
<td>08115</td>
<td>200mL</td>
<td>Black</td>
<td>Epoxy</td>
<td>90 min @ 21°C / 45 min @ 32°C (may be accelerated with heat)</td>
<td>4 hrs @ 21°C (may be accelerated with heat)</td>
<td>24 hrs @ 21°C</td>
</tr>
<tr>
<td>38315</td>
<td>50mL</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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</tbody>
</table>
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.co.nz/aad

For videos and more, visit: 3m.com.au/aad

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