














Weld Sealing		
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.
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 Seam Sealer Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.
9		Install Replacement Panel Install replacement panel to host panel. Clamp in place.
10		Spot Weld Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.
11		Sealer 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 sealer can expose bare metal, causing corrosion.
12		Post-Assembly Foam Replacement Apply foams at original locations as required.


⚠ 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


- 3M™ Mini File Belt Sander, 330mm., PN 33573 

- 3M™ Cubitron™ II File Belt, 10mm x 330mm 80+, PN 33440 


- Scotch-Brite™ Durable Flex Belt, CRS 


- Scotch-Brite™ Roloc™ Clean N Strip XT Disc CX-DR 


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

- 3M™ Weld-Thru Coating II, PN 05917 

- 3M™ Flexible Foam, 200mL, PN 08463 

- 3M™ MSP Seam Sealer, PN 08369 

- 3M™ MSP Seam Sealer, PN 08370 

- 3M™ Rigid Pillar Foam, 200ml, PN 08458 

Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300 

- 3M™ Half Face Welding Respirator Kit, PN 6228 

- 3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS 

Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

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