

Composite Panel Removal and Installation

1



Clean the Panels

Clean panels with soap and water followed by a VOC compliant surface cleaner. Thoroughly dry the parts. **DO NOT** apply any other cleaners throughout the remainder of the removal and installation procedure.

2



Panel Removal

Heat the bond line to 120–150°C and gently pry the panels apart with a rigid putty knife or equivalent. Remove all adhesive from the undamaged part using the same process as below. Let the surface cool.

3



Surface Prep

Sand the surfaces to be bonded using a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a low speed to rough up the area, or a P80 abrasive disc on a DA. Blow off the repair area with clean, dry air and a clean cloth. **Note: If flame heat was used to help separate panels it's a must that the after burn be removed with a P80 abrasive disc.** For metal parts, nothing coarser than P80 is necessary.

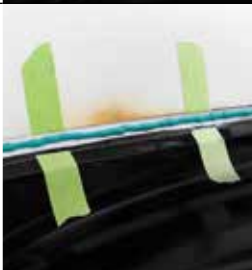
4



Dry Fit Parts

Dry fit all parts to ensure a good fit before dispensing and applying adhesive.

5



Apply Adhesive

Follow the Directions for Use to prepare, mix and apply 3M™ Panel Bonding Adhesive. Apply a continuous bead to one part. **Note: If you need to adjust the part, slide the part to prevent air pockets in the adhesive bead.**

6



Bond

Mate the parts. Apply clamps to the bonded panel surface and clamp within the desired area. **Note: Apply as many clamps as needed to bring the panels together. Make sure NOT to over clamp, which can result in squeezing the bondline dry of adhesive.** Remove any excess adhesive squeeze out.

Product List

3M™ Car Wash Soap Concentrate, 3.7L, PN 38377



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 75mm, PN 33391



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 150mm, 80+ grade, PN 31371



Scotch® Performance Green Masking Tape 233+, 18mm width



3M™ Panel Bonding Adhesive, 200ml, PN 8115



3M™ Impact Resistant Structural Adhesive, 200ml, PN 07333



Think About Your Health

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



3M™ Half Face Welding Respirator Kit, PN 6228



3M™ Solus™ 1000 Series Scotchgard™ Anti-fog Eyewear, PN S1201SGAF



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