

**3M** Science.  
Applied to Life.™



**Trusted and  
recommended  
for over 20 years.**

**3M™ Panel Bonding Adhesive**

# 3M™ Panel Bonding Adhesive

08115 / 08116 / 58115



## Proven and trusted performance. Provides a continuous bond and seals weld and rivet bonded areas against corrosion.

Designed to meet specific strength requirements for outer sheet metal panel replacement; panel bonding adhesive is typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.

*The above is a general description, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.*



- Recommended by many OEMs
- Provides corrosion protection with lifetime warranty
- Room temperature curing (accelerated curing with heat)
- Can be weld bonded or rivet bonded within working time
- Adheres to a wide variety of properly prepared steel and aluminum substrates
- May be used on many plastic and composite substrates
- Glass bead technology protects against overclamping and maintains a minimum bond line thickness
- Has excellent shelf life opened or unopened, reducing unused product replacement costs

# 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	24 hrs
58115	450mL DMS			45 min @ 32°C		
08116	200mL	Black	Epoxy	2 hrs @ 21°C 1 hr @ 32°C	6 hrs	24 hrs

\*May be accelerated with heat.

## Following OEM recommendations is very important for several reasons.

**Help Ensure Safety:** Meet the adhesive standards that have been set by the OEMs to manage crash energy and help protect occupants.

**Use Trusted Products:** Use products that have been rigorously tested to the OEM's performance requirements for strength and corrosion resistance.

**Mitigate Risk:** Help protect yourself and your business from potential liability — the vehicle was repaired as directed by the OEM.

**Simplify Your Process:** Eliminate confusion about which adhesive should be used and where. You're using the OEM recommended adhesive that is specifically called out for that procedure.

**Get Reimbursed:** OEM recommendations, which include 3M products, enable you to provide documentation to justify correct product usage and procedures needed for safe and responsible repairs.

## OEM Recommendations

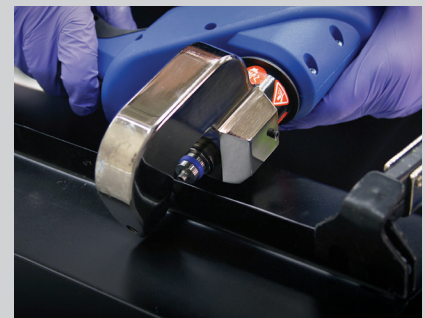
- ✔ 3M™ Panel Bonding Adhesive
- ✔ 3M™ Impact Resistant Structural Adhesive

Part No.	Fiat/ Chrysler	Ford	General Motors	Honda	Hyundai/ Kia	Jaguar/ Land Rover	Nissan	Tesla	Toyota	Volvo
08115		✔		✔	✔		✔		✔	✔
08116	✔		✔							✔
07333			✔	✔	✔	✔		✔		✔

**Please reference OEM Repair Procedures:** Collision repair shops should follow OEM recommendations. Always reference the OEM repair procedure to make sure the correct adhesive is being selected for that repair.



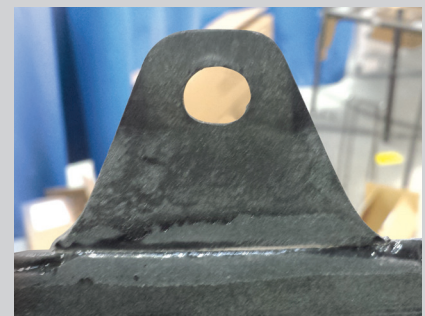
3M™ Panel Bonding Adhesive can be welded through within working time using squeeze-type resistance spot welding to form a weld bonded joint.



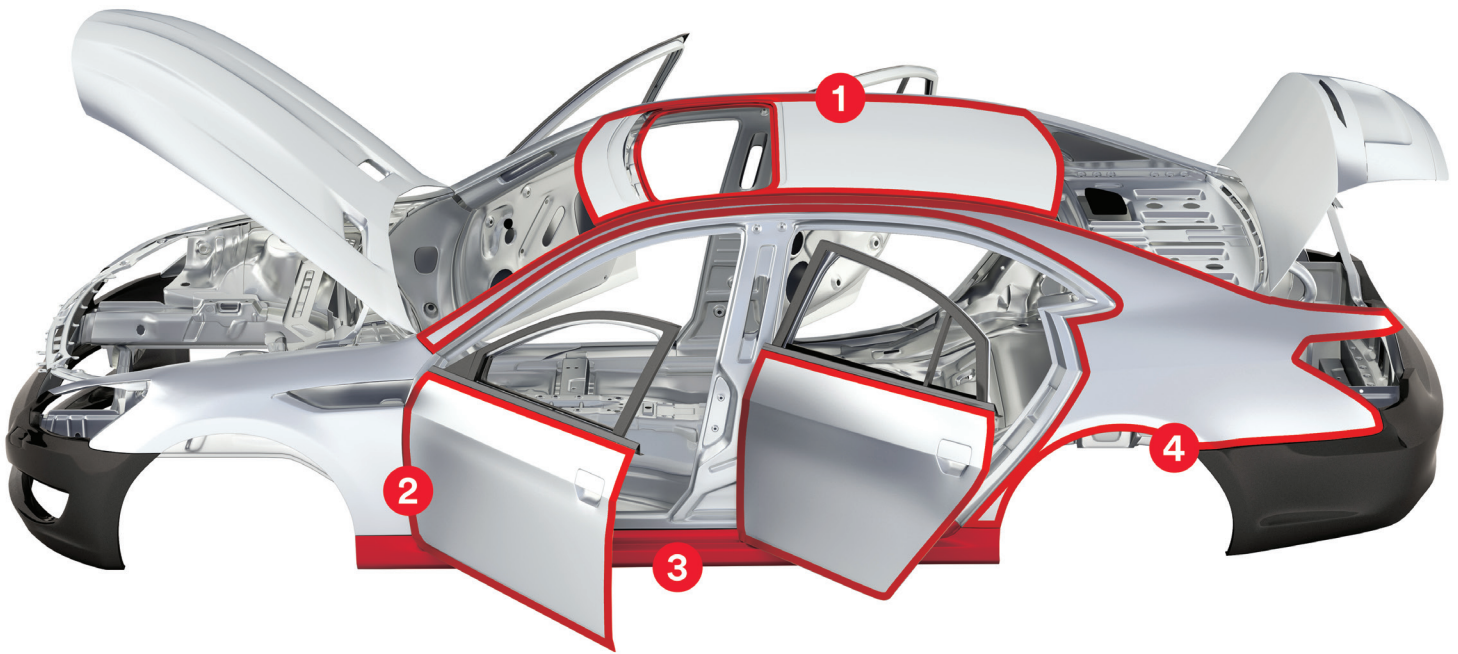
Recommended in OEM procedures for rivet bonding operations.



May be used for bonding door skins, quarter panels, roof skins, box sides, van/utility vehicle sides and sills when recommended by OEMs.



Can be used for bumper cover, composite and plastic repair when recommended by OEMs.



**Quick Reference:** Areas where 3M™ Panel Bonding Adhesive may be used.

- 1 Roof Skin    
 2 Door Skin    
 3 Sill    
 4 Quarter Panel/Truck Box/Van Side

Please reference OEM Repair Procedures.

## Ordering Information

3M™ Panel Bonding Adhesive			
Part No.	Size	Product	Case Qty.
08115	200ml	3M™ Panel Bonding Adhesive	6/Case
58115	450ml DMS	3M™ Panel Bonding Adhesive	4/Case
08116	200ml	3M™ Panel Bonding Adhesive	6/Case

Accessories		
Part No.	Size	Features/Applications
08193	400ml	<b>3M™ Static Mixing Nozzle:</b> 3/8 in. nozzle, pack (36)
08194	400ml	<b>3M™ Static Mixing Nozzle:</b> 3/8 in. nozzle, Bulk pack (50)
09930	200ml	<b>3M™ Performance Pneumatic Applicator:</b> Pneumatic — For 200mL product
08117	200ml	<b>3M™ Performance Manual Applicator:</b> Manual — For 200mL product
50601	2:1, 1:1	<b>3M™ Dynamic Mixing Nozzles:</b> DMS nozzle for adhesives, sealers and plastic repair products
58207	50:1, 2:1, 1:1	<b>3M™ Dynamic Mixing Nozzle Extension:</b> Use with DMS nozzles to provide a thinner bead and to get into hard to reach areas
50600	All DMS Products	<b>3M™ Dynamic Mixing Applicator:</b> Pneumatic — Professional applicator to dispense DMS products

For more information, visit:



### Automotive Aftermarket Division

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