

PERSONAL SAFETY

- Comfort Particle Mask P2
- Hearing Protection
- Face Protection
- Reusable Workwear
- Safety Gloves

1 Host Panel Preparation		<ul style="list-style-type: none"> Remove remaining material and contaminants from host panel. Prep remaining mating flanges on host panel with a Scotch-Brite™ Belt or Disc 	
2 Cleaning of the surface		<ul style="list-style-type: none"> Degreasing host panel mating flange areas 	
3 Replacement Panel Preparation		<ul style="list-style-type: none"> Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt 	
4 Cleaning of the surface		<ul style="list-style-type: none"> Degreasing replacement panel mating flange areas 	
5 Corrosion Protection		<ul style="list-style-type: none"> Apply weld-thru primer to all areas on host panel and replacement panel requiring welding operations, except the areas for bonding Two layers are recommended to obtain the right coating thickness for optimum corrosion protection Drying time: 10 - 20 minutes 	
6 Calibration of a new cartridge		<ul style="list-style-type: none"> Insert the cartridge into a suitable application gun Before attaching the mixer to the cartridge, squeeze out a small amount of material until both components are equally extruded Attach the mixing nozzle and discard the first 2-4 cm of extruded material, to remove any improperly mixed material <p>Note: The previous step is only necessary when using a new cartridge.</p>	
7 Application		<ul style="list-style-type: none"> Apply adhesive to mating flange areas on host panel and replacement panel, covering all bare metal areas Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness and all voids are filled 	
8 Install Replacement Panel		<ul style="list-style-type: none"> Install replacement panel to host panel by clamping in place Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use from the car manufacturer <p>Note: Follow recommended adhesive clamp times: ~ after 4h @ 23°C ambient temperature</p>	
9 Adhesive Clean Up		<ul style="list-style-type: none"> Tool excess adhesive squeeze-out from repair area prior to curing to seal the repair <p>Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion</p>	