

Personal Safety

• Comfort Particle Mask P2



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



<p>1 Host Panel Preparation</p>		<ul style="list-style-type: none"> After the removal of the outer panel, remove any remaining material and contaminants from host panel. Prep remaining mating flanges on host panel with a Scotch-Brite™ Belt or Disc. 	<p>3M™ Scotch-Brite™ File Belts 3M™ Pistol Grip Disc Sander 3M™ Scotch-Brite™ Roloc Disc 3M™ Cut-Off Wheel Tool ø 75 mm, ø 100 mm</p>
<p>2 Cleaning of the surface</p>		<ul style="list-style-type: none"> Degrease host panel mating flange areas using a general purpose adhesive cleaner with fast flash off. 	<p>3M™ General Purpose Adhesive Cleaner 3M™ Professional Panel Wipes</p>
<p>3 Replacement Panel Preparation</p>		<ul style="list-style-type: none"> Remove the E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt. <p>Caution: E-Coat should only be removed in areas where adhesive is recommended by the vehicle manufacturer.</p>	<p>3M™ Scotch-Brite™ File Belts 3M™ File Belt Tool</p>
<p>4 Cleaning of the surface</p>		<ul style="list-style-type: none"> Degrease replacement panel mating flange areas using a general purpose adhesive cleaner with fast flash off. 	<p>3M™ General Purpose Adhesive Cleaner 3M™ Professional Panel Wipes</p>
<p>5 Corrosion Protection</p>		<ul style="list-style-type: none"> Apply Zinc Rich weld-thru coating to all areas on host panel and replacement panel requiring welding operations. Do not apply in areas requiring adhesive. Two layers are recommended to obtain the right coating thickness for optimum corrosion protection Drying time: 10 - 20 minutes 	<p>3M™ Weld Thru II Primer</p>
<p>6 Calibration of a new cartridge</p>		<ul style="list-style-type: none"> Insert the cartridge into an applicator gun designed for the adhesive cartridge. 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. Note: The previous step is only necessary when using a new cartridge 	<p>3M™ Panel Bonding Adhesives 3M™ Manual Applicator for 200ml Duopack Cartridge 3M™ Pneumatic Applicator for 200ml Duopack Cartridge</p>
<p>Pre-Assembly NVH Replacement</p>		<ul style="list-style-type: none"> If vehicle construction necessitates, apply NVH material or foams at original locations as required. 	<p>3M™ NVH Dampening Material</p>
<p>7 Application</p>		<ul style="list-style-type: none"> Apply adhesive to mating flange areas on host panel and replacement panel. Spread the adhesive covering all bare metal areas with an acid brush or plastic applicator. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness and all voids are filled. 	
<p>8 Install Replacement Panel</p>		<ul style="list-style-type: none"> Install replacement panel to host panel by clamping in place, being careful to not scrape off any of the adhesive during the process. Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the repair procedure of the vehicle. Note: Follow recommended adhesive clamp times: Minimum 4 hours @ 23°C ambient temperature. 	
<p>9 Adhesive Clean Up</p>		<ul style="list-style-type: none"> Tool excess adhesive squeeze-out from repair area once clamping is complete. Do not allow adhesive squeeze out to cure. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion. 	<p>3M™ General Purpose Adhesive Cleaner 3M™ Professional Panel Wipes</p>
<p>Post-Assembly Foam Replacement</p>		<ul style="list-style-type: none"> Apply foams at original locations as required by the vehicle repair procedure. Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly. 	<p>3M™ Flexible Foam 3M™ Rigid Pillar Foam</p>