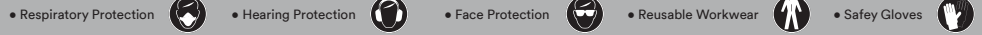


**Personal Safety**



Safety First! Always select appropriate personal protective equipment - eyewear, gloves, hearing and respiratory protection for your job and workplace.

Host Panel Preparation		<ul style="list-style-type: none"> <li>Remove remaining weld nuggets and adhesive material from the host panel with a grade 60 - 80 Cubitron™ II file belt or Roloc™ grinding disc. Prep remaining mating flanges on the host panel with a Scotch-Brite™ belt or Roloc™ disc</li> </ul>	<p>3M™ Scotch-Brite™ File Belts Coarse    3M™ Cubitron II 80 grade file belt    3M™ Scotch-Brite™ Roloc Disc Coarse    3M™ Pistol Grip Disc Sander    3M™ File Belt Tool</p>
Cleaning of the surface		<ul style="list-style-type: none"> <li>Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas.</li> </ul>	
Replacement Panel Preparation		<ul style="list-style-type: none"> <li>Remove E-coat from the replacement panel mating flange areas using a Scotch-Brite™ Belt or Disc based on access.</li> </ul>	<p>3M™ Scotch-Brite™ File Belts Coarse    3M™ Scotch-Brite™ Roloc Disc Coarse    3M™ Pistol Grip Disc Sander</p>
Cleaning of the surface		<ul style="list-style-type: none"> <li>Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas.</li> </ul>	
Corrosion Protection		<ul style="list-style-type: none"> <li>Apply weld-thru coating to all areas on the host panel and replacement panel that require welding operations. Weld-thru coating should not be used on areas that will be bonded or weld-bonded.</li> <li>Two layers are recommended to obtain the right coating thickness for optimum corrosion protection.</li> <li>Drying time: 10 - 20 minutes</li> </ul>	<p>3M™ Weld Thru II Primer</p>
Calibration of a new cartridge		<ul style="list-style-type: none"> <li>Insert the the selected adhesive cartridge into a suitable application gun.</li> <li>Before attaching the mixer to the cartridge, squeeze out a small amount of material until both components are equally extruded.</li> <li>Attach the mixing nozzle and discard the first 2-4 cm (1-2") of extruded material, to remove any improperly mixed material.</li> <li>Note: The previous step is only necessary when using a new cartridge.</li> </ul>	<p>3M™ Impact Resistant Structural Adhesive 200 mL    3M™ Manual Cartridge Applicator, 08571, 200 mL    3M™ Performance Pneumatic Applicator, 09930, 200 mL</p>
Pre-Assembly NVH Replacement		<ul style="list-style-type: none"> <li>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</li> </ul>	<p>3M™ NVH Dampening Material, 200 mL    3M™ Flexible Foam, 200 mL    3M™ Rigid Pillar Foam, 200 mL</p>
Application		<ul style="list-style-type: none"> <li>Apply a bead of adhesive to the mating flange areas on the host panel and replacement panel. Use a brush or spreader to ensure coverage of all bare metal areas.</li> <li>Apply an additional bead of adhesive to the host panel mating flange area to ensure proper bond line thickness and ensure all voids are filled.</li> </ul>	
Install Replacement Panel		<ul style="list-style-type: none"> <li>Install the replacement panel to the vehicle. Fitment adjustments should be made by sliding the part vs. lifting and reapplying. Once satisfied with fitment, clamp in place.</li> <li>Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the repair procedure from the vehicle manufacturer.</li> <li>Note: Follow recommended adhesive clamp times flisted on the adhesive cartridge.</li> </ul>	<p>Always follow OEM Repair Procedures</p>
Adhesive Cleanup		<ul style="list-style-type: none"> <li>Tool excess adhesive squeeze-out from the repair area prior to curing to seal the repair.</li> <li>Note: Avoid grinding to remove excess adhesive as this will expose bare metal, increasing your chances of corrosion.</li> </ul>	
Post-Assembly Foam Replacement		<ul style="list-style-type: none"> <li>Apply foams at original locations as required.</li> <li>Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.</li> </ul>	<p>3M™ NVH Dampening Material, 200 mL    3M™ Flexible Foam, 200 mL    3M™ Rigid Pillar Foam, 200 mL    3M™ Manual Cartridge Applicator, 08571, 200 mL    3M™ Performance Pneumatic Applicator, 09930, 200 mL</p>