

Personal Safety

• Respiratory Protection



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



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



- Remove remaining weld nuggets and adhesive material from the host panel with a grade 60 - 80 file belt or grinding disc. Prep remaining mating flanges on the host panel with a non-woven belt or disc.



- Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas.



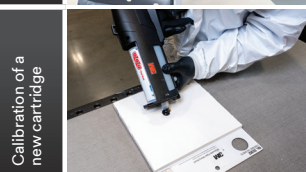
- Remove E-coat from the replacement panel mating flange areas using a non-woven belt or disc based on access.



- Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas.



- 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.
- Two layers are recommended to obtain the right coating thickness for optimum corrosion protection.
- Drying time: 10 - 20 minutes



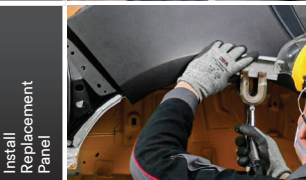
- Insert the the selected adhesive cartridge into a suitable application gun.
- Before attaching the mixer to the cartridge, squeeze out a small amount of material until both components are equally extruded.
- Attach the mixing nozzle and discard the first 2-4 cm (1-2") of extruded material, to remove any improperly mixed material.
- Note: The previous step is only necessary when using a new cartridge.



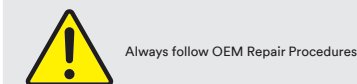
- If vehicle construction necessitates, apply NVH material or foams at original locations as required.



- 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.
- 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.



- 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.
- Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the repair procedure from the vehicle manufacturer.
- Note: Follow recommended adhesive clamp times flisted on the adhesive cartridge.



- Tool excess adhesive squeeze-out from the repair area prior to curing to seal the repair.
- Note: Avoid grinding to remove excess adhesive as this will expose bare metal, increasing your chances of corrosion.



- Apply foams at original locations as required.
- Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.

