






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.

Host Panel Preparation		<ul style="list-style-type: none"> 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. 	    
Cleaning of the surface		<ul style="list-style-type: none"> Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas. 	
Replacement Panel Preparation		<ul style="list-style-type: none"> Remove E-coat from the replacement panel mating flange areas using a non-woven belt or disc based on access. 	   
Cleaning of the surface		<ul style="list-style-type: none"> Using an appropriate VOC compliant degreaser, clean the replacement panel mating flange areas. 	
Corrosion Protection		<ul style="list-style-type: none"> 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 	
Calibration of a new cartridge		<ul style="list-style-type: none"> Insert the the selected adhesive cartridge into a suitable application gun Before attaching the mixing nozzle to the cartridge, squeeze out a small amount of material until both components are equally extruded. The cartridge is now equalized. Attach the mixing nozzle and discard the first 2-4 cm (1-2") of extruded material, to remove any improperly mixed material. 	  
Pre-Assembly NVH Replacement		<ul style="list-style-type: none"> If vehicle construction necessitates, apply NVH material or foams at original locations as required. 	  
Application		<ul style="list-style-type: none"> 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 Replacement Panel		<ul style="list-style-type: none"> 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 in the OEM repair procedure. Note: Follow recommended adhesive clamp times listed on the adhesive cartridge. 	 <p>Always follow OEM Repair Procedures</p>
Adhesive Clean Up		<ul style="list-style-type: none"> Tool excessive adhesive squeeze-out from the flange joint prior to curing to seal the repair. Clean any uncured adhesive from unwanted areas using a VOC compliant cleaner. Note: Avoid grinding to remove excess adhesive as this will expose bare metal, increasing your chances of corrosion 	
Post-Assembly Foam Replacement		<ul style="list-style-type: none"> Apply foams at original locations as required. Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly. 	    