

3M™ Automix™ Panel Bonding Adhesive is a two part adhesive designed to bond steel, aluminum, SMC and FRP. When used according to directions, 3M™ Automix™ Panel Bonding Adhesive may be used in the replacement of automotive doorskins, quarter panels, box sides, van sides, roofs, and other outer body sheet metal.

DO NOT USE on structural components such as rails, pillars, rocker panels, core supports, etc..

1. Remove all paint and rust from surfaces to be bonded using a 36 or 50 grit 3M™ Abrasive Disc.
2. Straighten all metal, and “dry-fit” part.
3. Clamp part in place and check for fit and alignment.
4. Remove panel from vehicle.
5. Use 3M™ General Purpose Adhesive Cleaner (PN 08984, 08986 or 08987) to remove any grease, wax and/or tar from surface to be bonded. Read manufacturer’s hazard communication and follow manufacturer’s recommended guidelines for safe handling of the above chemical products.*
6. Place adhesive cartridge in applicator gun.
7. Remove end seal cap from adhesive cartridge.
8. Dispense just enough adhesive to be sure that both parts A and B are present.
9. Attach 3M™ Mixing Nozzle (PN 08193) to cartridge and lock in place with retaining collar.
10. You may cut end of mixing nozzle to provide desired bead size.
11. Apply adhesive to all areas to be bonded (all bare metal surfaces). Using a plastic spreader, tool out the adhesive to cover all bare metal surfaces.
12. Apply an adhesive bead approximately 1/4” from the inside edge of the replacement panel.

*Local air quality regulations may regulate or prohibit the use of surface preparation and cleanup materials based on VOC content. Consult your local air quality regulations.