

Weld Sealing		
<b>1</b>		<p><b>Host Panel Preparation</b></p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.</p>
<b>2</b>		<p><b>Mating Flange Panel Preparation</b></p> <p>Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.</p>
<b>3</b>		<p><b>Clean</b></p> <p>Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
<b>4</b>		<p><b>Dry Fit Panel</b></p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas.</p>
<b>5</b>		<p><b>Weld-Thru Primer</b></p> <p>Use Scotch-Brite™ belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. <b>Caution: Do not use Weld-Thru Primer in adhesive bonding areas.</b></p>
<b>6</b>		<p><b>Spot Weld Surface Preparation</b></p> <p>Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.</p>
<b>7</b>		<p><b>Pre-Assembly NVH Replacement</b></p> <p>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
<b>8</b>		<p><b>Apply Seam Sealer</b></p> <p>Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.</p>
<b>9</b>		<p><b>Install Replacement Panel</b></p> <p>Install replacement panel to host panel. Clamp in place.</p>
<b>10</b>		<p><b>Spot Weld</b></p> <p>Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.</p>
<b>11</b>		<p><b>Sealer Clean Up</b></p> <p>Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. <b>Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.</b></p>
<b>12</b>		<p><b>Post-Assembly Foam Replacement</b></p> <p>Apply foams at original locations as required.</p>

**⚠ WARNING**

Follow OEM and/or welder manufacturers' recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

**Product List**

- 3M™ File Belt Sander, 18 in., PN 33575 

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- 3M™ Cubitron™ II File Belt, grade 80+, PN 33446 

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- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475 

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- Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552 

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- Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555 

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- 3M™ Weld-Thru Coating II, PN 05917 

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- 3M™ NVH Dampening Material, PN 04274 

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- 3M™ Flexible Foam, 200mL, PN 08463 

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- 3M™ Urethane Seam Sealer, PN 08361; PN 08362 

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- 3M™ MSP Seam Sealer, PN 08370 

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- 3M™ Rigid Pillar Foam, 200mL, PN 08458 

**Think About Your Health**

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300 







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- 3M™ Half Facepiece Respirator, PN 07182 

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- 3M™ Virtua™ Protective Eyewear, PN 11326 

**Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.**

Aluminum Part Replacement	
<b>1</b>	 <p><b>Pre-Cleaning</b> Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>	 <p><b>Sealer/Coating Removal</b> Use Scotch-Brite™ Clean and Strip Disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.</p>
<b>3</b>	 <p><b>Rivet/Spot Weld Removal</b> Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. <b>Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.</b></p>
<b>4</b>	 <p><b>Panel Separation</b> Separate exterior panel from the host panel. <b>DO NOT force separation in areas where the weld isn't completely removed, go back to step 3 and finish weld removal before continuing.</b></p>
<b>5</b>	 <p><b>Surface Preparation</b> Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean and Strip Disc.</p>
<b>6</b>	 <p><b>Panel Installation</b> <b>Follow OEM recommendations where applicable.</b> Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc.</p>

Product List
<p>Meguiar's® Shampoo Plus, 1 gallon, PN D11101</p> 
<p>Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701</p> 
<p>Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552</p> 
<p>Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555</p> 
<p>3M™ File Belt Sander, 18 in., PN 33575</p> 
<p>Scotch-Brite™ Durable Flex Belt, CRS, PN 64475</p> 
<p>3M™ Cubitron™ II File Belt, grade 80+, PN 33446</p> 
<p>3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115</p> 
<p>3M™ Impact Resistant Structural Adhesive 200mL, PN 07333; 450mL DMS, PN 57333</p> 

Think About Your Health
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p> 
<p>3M™ Half Facepiece Respirator, PN 07182</p> 
<p>3M™ Virtua™ Protective Eyewear, PN 11326</p> 

**Note: Use caution when working on aluminum parts. Use tools that have been cleaned properly or designated for use on aluminum to reduce potential cross contamination. Do not re-use abrasives that were previously used on steel repairs.**