

Weld Bonding (Excluding Door Skin)

1		<p>Host Panel Preparation</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 to remove all adhesive, corrosion and coatings.</p>
2		<p>Mating Flange Panel Preparation</p> <p>Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.</p>
3		<p>Clean</p> <p>Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas.</p>
5		<p>Weld-Thru Primer</p> <p>Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.</p>
6		<p>Spot Weld Surface Preparation</p> <p>Identify replacement spot weld sites and remove Ecoat using Scotch-Brite™ belt where spot weld tips will contact host and replacement panel. Remove panel once complete.</p>
7		<p>Pre-Assembly NVH Replacement</p> <p>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
8		<p>Apply Bonding Adhesive</p> <p>Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange areas.</p>
9		<p>Install Replacement Panel</p> <p>Install replacement panel to host panel. Clamp in place.</p>
10		<p>Spot Weld</p> <p>Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.</p>
11		<p>Adhesive Clean Up</p> <p>Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.</p>
12		<p>Post-Assembly Foam Replacement</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, PN 28366



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



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



Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470



Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466



3M™ Weld-Thru Coating II, PN 05917



3M™ NVH Dampening Material, PN 04274



3M™ Flexible Foam, 200mL, PN 08463



3M™ Panel Bonding Adhesive, 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115; 50mL, PN 38315



3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219



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



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851

All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.



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Door Skin Replacement		
1		<p>Door Frame Preparation</p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ belt.</p>
2		<p>Clean</p> <p>Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
3		<p>Replacement Skin Prep</p> <p>Scuff replacement skin mating flange areas using Scotch-Brite™ hand pad.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.</p>
5		<p>NVH Replacement</p> <p>Apply NVH material at original locations on intrusion beam.</p>
6		<p>Apply Bonding Adhesive</p> <p>Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
7		<p>Install Door Skin</p> <p>Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)</p>
8		<p>Clamp and Cure</p> <p>Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze-out from hem flange area with a VOC compliant cleaner.</p>
9		<p>Seam Sealing</p> <p>Re-apply seam sealer to hem flange as required following general seam sealing guidelines.</p>

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3M™ Cubitron™ II File Belt, grade 80+, PN 33446	
Scotch-Brite™ Durable Flex Belt, CRS, PN 64475	
Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659	
Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926	
3M™ NVH Dampening Material, PN 04274	
3M™ Urethane Seam Sealer, PN 08361	
3M™ MSP Seam Sealer, PN 08370	
3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115	
3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219	
3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310	
3M™ EZ Sand Multi-Purpose Flexible Adhesive, 200mL, PN 05887; 600mL DMS, PN 55887	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07182	
3M™ Lexa™ Protective Eyewear, PN 15200	

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Panel Bonding (Excluding Door Skin)		
1		<p>Host Panel Preparation</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 to remove all adhesive, corrosion and coatings.</p>
2		<p>Replacement Panel Preparation</p> <p>Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.</p>
3		<p>Clean</p> <p>Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove panel in preparation for adhesive application.</p>
5		<p>Weld-Thru Primer</p> <p>Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.</p>
6		<p>Pre-Assembly NVH Replacement</p> <p>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
7		<p>Apply Bonding Adhesive</p> <p>Apply adhesive to mating flange areas on host panel and replacement panel, covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
8		<p>Install Replacement Panel</p> <p>Install replacement panel to host panel. Clamp in place and make required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use, or the OE manufacturer. Follow recommended adhesive clamp times.</p>
9		<p>Adhesive Clean Up</p> <p>Tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.</p>
10		<p>Post-Assembly Foam Replacement</p> <p>Apply foams at original locations as required.</p>

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3M™ Cubitron™ II File Belt, grade 80+, PN 33446	
Scotch-Brite™ Durable Flex Belt, CRS, PN 64475	
Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470	
Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466	
3M™ Weld-Thru Coating II, PN 05917	
3M™ NVH Dampening Material, PN 04274	
3M™ Flexible Foam, 200mL, PN 08463	
3M™ Panel Bonding Adhesive, 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115; 50mL, PN 38315	
3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219	
3M™ Rigid Pillar Foam, 200mL, PN 08458	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07182	
3M™ Lexa™ Protective Eyewear, PN 15200	

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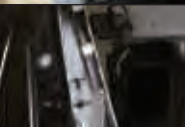





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Weld Sealing		
1		<p>Host Panel Preparation</p> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.</p>
2		<p>Mating Flange Panel Preparation</p> <p>Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.</p>
3		<p>Clean</p> <p>Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
4		<p>Dry Fit Panel</p> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas.</p>
5		<p>Weld-Thru Primer</p> <p>Use Scotch-Brite™ belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.</p>
6		<p>Spot Weld Surface Preparation</p> <p>Identify replacement spot weld sites and remove Ecoat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.</p>
7		<p>Pre-Assembly NVH Replacement</p> <p>If vehicle construction necessitates, apply NVH material or foams at original locations as required.</p>
8		<p>Apply Seam Sealer</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>
9		<p>Install Replacement Panel</p> <p>Install replacement panel to host panel. Clamp in place.</p>
10		<p>Spot Weld</p> <p>Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.</p>
11		<p>Sealer Clean Up</p> <p>Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.</p>
12		<p>Post-Assembly Foam Replacement</p> <p>Apply foams at original locations as required.</p>

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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.

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

- Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470 

- Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466 

- 3M™ Weld-Thru Coating II, PN 05917 

- 3M™ NVH Dampening Material, PN 04274 

- 3M™ Flexible Foam, 200mL, PN 08463 

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

- 3M™ MSP Seam Sealer, PN 08370 

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

Think About Your Health

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

- 3M™ Half Facepiece Respirator, PN 07182 

- 3M™ Lexa™ Protective Eyewear, PN 15200 

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Aluminum Repair Procedures

Body Repair

Aluminum Rivet Bonding

1		Host Panel Preparation Using a grade 80 abrasive belt, remove remaining rivet material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Durable Flex Belt.
2		Mating Flange Panel Preparation Remove Ecoat from replacement panel mating flange areas using a Scotch-Brite™ Belt or Clean N Strip Disc.
3		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
4		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
5		Rivet Preparation Identify replacement rivet sites and prepare the surface for the type of rivet recommended by the manufacturer. (For blind or solid rivets, drill all necessary holes.) Remove panel once complete.
6		Pre Assembly NVH Replacement If vehicle construction necessitates, apply 3M™ NVH Dampening Material or 3M™ Flexible Foam at original locations as required.
7		Apply Bonding Adhesive Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange area to ensure proper bond line thickness.
8		Install Replacement Panel Install replacement panel to host panel taking care to avoid scraping off any adhesive during installation. Clamp in place.
9		Install Rivets and Welds Install replacement rivets to all areas as recommended by the OE manufacturer. Note: Rivets must be installed while adhesive is uncured. Weld cosmetic joints/splices as necessary or recommended by the OE Manufacturer.
10		Adhesive Clean Up Remove clamps and tool excess adhesive squeeze out from repair area prior to curing to seal the repair. An acid brush works well to remove adhesive from between clamps. Note: Grinding to remove excess cured adhesive can expose bare metal, causing corrosion.
11		Post Assembly Foam Replacement Apply foams at original locations as required.

Product List

3M™ File Belt Sander, PN 28366



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



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



Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470



Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466



3M™ NVH Dampening Material, PN 04274



3M™ Flexible Foam, 200mL, PN 08463

3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115



3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219



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

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3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



Aluminum Repair Procedures

Body Repair

Aluminum Part Replacement

1



Pre-Cleaning

Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

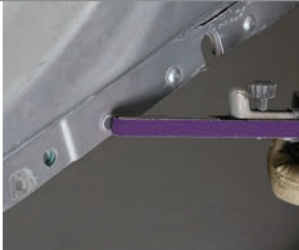
2



Sealer/Coating Removal

Use Scotch-Brite™ Clean N 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.

3



Rivet/Spot Weld Removal

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. **Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.**

4



Panel Separation

Separate exterior panel from the host panel. **DO NOT force separation in areas where the weld isn't completely removed, go back to step 3 and finish weld removal before continuing.**

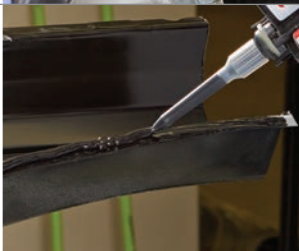
5



Surface Preparation

Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean N Strip Disc.

6



Panel Installation

Follow OEM recommendations where applicable. Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc.

Product List

3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377



3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350



Scotch-Brite™ Roloc™ + Clean N Strip, XT Disc, PN 07470



Scotch-Brite™ Roloc™ + Clean N Strip TR Disc, PN 07466



3M™ File Belt Sander, PN 28366



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



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



3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115



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



3M™ Half Facepiece Respirator, PN 07182

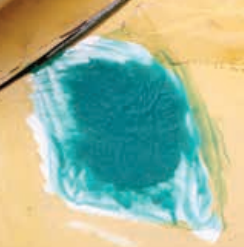


3M™ Lexa™ Protective Eyewear, PN 15200



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.




Back Side Reinforcement (SMC, FRP, Composites)

1		<p>Clean the Damaged Area Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. Do not apply any other cleaners throughout the remainder of the repair procedure.</p>
2		<p>Surface Preparation Grind the backside of the repair with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip grinder set at a low speed. When finished the sanded area should be at least 2 in. larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.</p>
3		<p>Adhesion Promoter No adhesion promoter is needed for SMC or FRP repairs. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter to the repair area. Allow to dry for at least 5 minutes.</p>
4		<p>Alignment Align the front side of the repair and cover the damaged area with Scotch® Auto Body Repair Tape to keep the adhesive from the back side from flowing through to the front side.</p>
5		<p>Prepare and Apply Reinforcement Material Cut a piece of fiberglass matting 1-1/2 in. larger than the damaged area. Following product instructions, apply a “tight coat” of matting adhesive to the repair area to ensure good contact with the composite. Place the fiberglass mat on a clean, dry work surface. Saturate the entire section of mat with matting adhesive on both sides and apply it over the “tight coat” on the repair. Apply more 3M™ Fiberglass Mat Adhesive if necessary.</p>
6		<p>Dry Allow the matting adhesive to cure for 45 minutes at 75°F.</p>

Product List

<p>3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378</p>	
<p>3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987</p>	
<p>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391</p>	
<p>3M™ Pistol Grip Disc Sander, PN 33577</p>	
<p>3M™ Polyolefin Adhesion Promoter, PN 05907</p>	
<p>Scotch® Auto Body Repair Tape, 2 in. x 125 in., PN 95331</p>	
<p>3M™ Aluminum Foil Tape 425, Silver, 2 in. x 60 yd., 4.6 mil, PN 95072</p>	
<p>Scotch® Performance Green Masking Tape 233+, 48mm width (1.9 in.), PN 26340</p>	
<p>Dynatron™ Fiberglass Mat, 8 sq. ft., PN 00688</p>	
<p>3M™ Fiberglass Mat Adhesive, 400mL, PN 08277</p>	
<p>3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280</p>	
<p>Marson® Yellow Spreaders, PN 20395</p>	

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<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872</p>	
<p>Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	