

3M Panel Bonding Process

PERSONAL SAFETY

Comfort Particle Mask P2



Hearing Protection



• Face Protection



File Belts

Reusable Workwear



Safety Gloves







► Remove remaining material and contminants from host panel. Prep remaining mating flanges on host panel with a Scotch-Brite™ Belt or Disc







Roloc™ Disc



Cleaning of the surface



► Degreasing host panel mating flange areas



3M™ General Purpose Adhesive Cleaner



3M™ Professional Panel Wipes





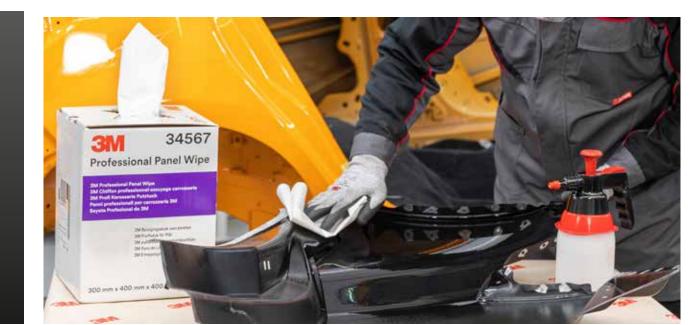
▶ Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt



3M™ Scotch-Brite™ File Belts



Cleaning of the surface



► Degreasing replacement panel mating flange areas



3M™ General Purpose Adhesive Cleaner



3M™ Professional Panel Wipes





Apply weld-thru primer to all areas on host panel and replacement panel requiring welding operations, exept the areas for bonding

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



Primer





- ► Insert the 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 of extruded material, to remove any improperly mixed material

Note: The previous step is only necessary when using a new cartridge.



3M™ Panel Bonding Adhesive



3M™ Pneumatic Applicator for 200ml **Duopack Cartridge**



for 200ml Duopack Cartridge





- 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 and all voids are filled



Adhesive Clean Up



- ► Install replacement panel to host panel by clamping in place
- ► Apply required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use from the car manufacturer

Note: Follow recommended adhesive clamp times: ~ after 4h @ 23°C ambient temperature



► 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





Adhesive Cleaner

Please recycle. Printed in the UK.

aadenquiries.uk@mmm.com

3M Ireland Limited Automotive Aftermarket

The Iveagh Building, The Park Carrickmines, Dublin 18

Phone: +353 12160301