

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 E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and 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. Caution: Do not use Weld-Thru Primer in adhesive bonding areas.</p>
6		<p>Spot Weld Surface Preparation</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>
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, 18 in., PN 33575

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

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

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

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

3M™ Weld-Thru Coating II, PN 05917

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™ Impact Resistant Structural Adhesive 200mL, PN 07333; 450mL DMS, PN 57333

3M™ Composite and Metal Bonding 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™ Virtua™ Protective Eyewear, PN 11326



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