

**Weld Bonding (Excluding Door Skin)**

<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 to remove all adhesive, corrosion and coatings.</p>
<b>2</b>		<p><b>Mating Flange Panel Preparation</b></p> <p>Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N 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.</p>
<b>6</b>		<p><b>Spot Weld Surface Preparation</b></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>
<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 Bonding Adhesive</b></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>
<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 adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.</p>
<b>11</b>		<p><b>Adhesive 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 adhesive 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>
<p>Visit <a href="http://www.3MCollision.com">www.3MCollision.com</a> for more SOPs and videos</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 

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

## Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at [www.3MCollision.com](http://www.3MCollision.com)

For product material safety data sheets see [www.3MCollision.com](http://www.3MCollision.com)

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**Product Use:** Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

**Warranty, Limited Remedy and Disclaimer:** Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

**IMPORTANT NOTE:** There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



3M Automotive Aftermarket Division  
3M Center, Building 223-6N-01  
St. Paul, MN 55144-1000  
U.S.A.

3M, Accuspray, Body Schutz, Cubitron, E-A-R, Green Corps, Hookit, Lexa, Perfect-It, Platinum, PPS, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, SUN GUN and Trizact are trademarks of 3M. All other trademarks are property of their respective owners.

Web: [www.3MCollision.com](http://www.3MCollision.com)

Please recycle. Printed in U.S.A. © 3M 2016. All rights reserved. (Rev 5/2016)