

3M™ Automix™ Panel Bonding Adhesive Repair Procedure

Remove Damaged Panel



1 Grind off all exposed welds or raised metal on the body frame that will interfere with a good fit of the new panel. Use 3M™ Roloc™ Coated Abrasive Discs on a right angle grinder.
Tech Tip: Always wear personal safety gear such as gloves, hearing protection and eyewear when grinding.



2 Clean all areas to be bonded, removing any primer, old adhesive or factory E-Coat. Use either a 3M™ Clean N Strip Disc or 3M™ Roloc™ Surface Conditioning Disc.



3 Dry fit the part and clamp check by attaching clamps every 200mm. Ensure good fit and alignment before continuing.



4 **Replacement Panel**
Remove factory E Coat along the bond line using 3M™ Clean N Strip Disc or 3M™ Scotch-Brite™ Surface Conditioning Disc.



5 Thoroughly clean all metal surfaces to be bonded with 3M™ Spray 700 Cleaner. Do not use any other solvent as it may leave an oily residue.
** Failure to use 3M™ Spray 700 Cleaner will invalidate 3M's Lifetime Guarantee.*



6 Apply a very light coat of 3M™ 5913 Weld Thru Coating to areas that require welding.
Alternative Method
Adhesive can be applied in a thin primer coat to both surfaces and may be spot welded through while wet.



7 Place the 3M™ Automix™ 8115 Panel Bonding Adhesive dual cartridge into the 3M™ 8117 Applicator Gun. Remove the end cap and dispense enough adhesive to ensure both components emerge equally.



8 Cut the nozzle to the desired bead size. Once the adhesive has passed through the nozzle, it will be totally mixed and ready to use. After use leave original nozzle attached to cartridge.
Tech Tip: Wear suitable protective gloves when using adhesive.



9 Apply an adhesive bead along the bond line. Tool out a thin layer using a putty rubber or similar. This application of adhesive will act as a primer coat. Ensure that all bare metal surfaces are completely covered in order to maintain the vehicle's corrosion protection.



10 Apply a second bead of adhesive set back approx 5mm from the panel edge to minimise excessive squeeze out. Lift panel into position.
** This step is not necessary for door skin replacement. A thin primer coat of adhesive to both surfaces is adequate.*



11 Apply 3M™ MSP Seam Sealer to side intrusion bars and anti flutter frames after dry fitting the replacement panel, as per original application. 3M MSP Seam Sealer will not shrink or sink back.

★ Use 3M™ MSP Seam Sealer



12 Clamp the replacement panel every 200mm. Place the clamps firstly in corner positions, panel end points and any position where tension is present in the fit. Use screws where clamping is not possible.



13 Tool any excess adhesive that squeezes out of the bond line to provide a seal along the outside edges of the seam.

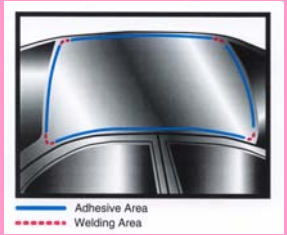


14 Weld the replacement panel in the appropriate areas. Remember: 3M™ 8115 Panel Bonding Adhesive can be spot welded through when wet. Use only the single "primer" layer of adhesive in areas to be spot welded.

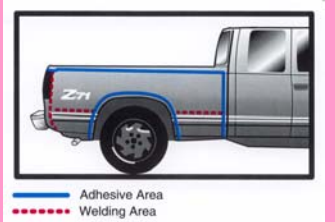


15 Allow at least 24hrs @ 23°C before returning the vehicle to full service. Prime and paint as per paint manufacturers instructions. Finally, apply 3M™ Rust Fighter I to inner panels to restore original cavity protection

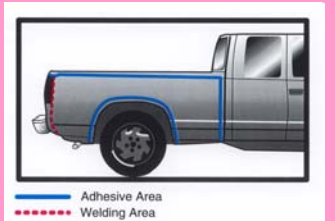
Roof / Turret



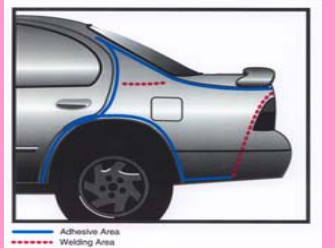
Ute Box Panel Inner



Ute Box Panel Outer

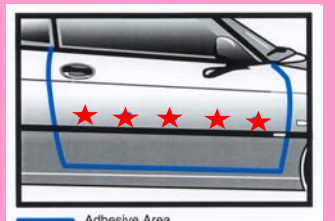


Quarter Panel



Remember to weld quarter panel if a belt cut has been made.

Door Skin



Van Side Panel

