

3M Science.
Applied to Life.™



**Trusted and
recommended
for over 15 years.**

3M™ Panel Bonding Adhesive

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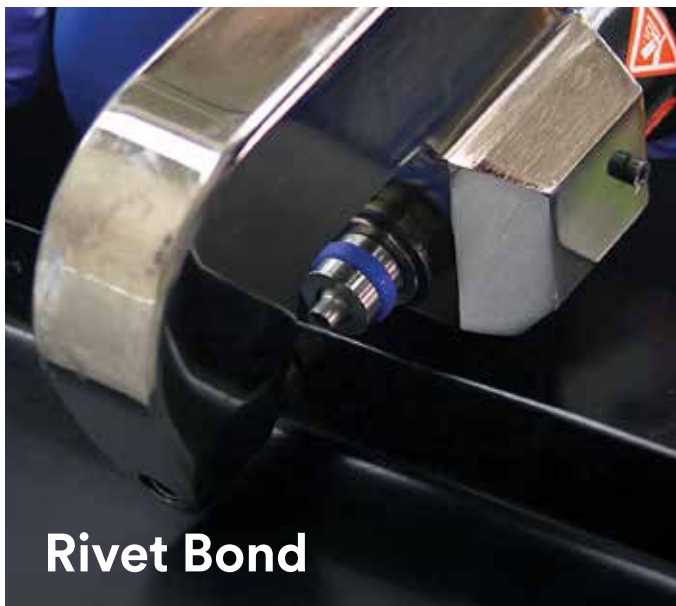
- Lifetime warranty (when used according to 3M's directions for use)
- OEM and third party referenced for use in repairs
- Room temperature curing (accelerated curing with heat)
- Can be weld bonded or rivet bonded through prior to curing
- Corrosion inhibiting formula
- Two-part epoxy technology



- Excellent adhesion to cold rolled steel, aluminum, sheet molded compound (SMC), fiber reinforced plastic (FRP) and more

Part No.	Size	Color	Chemistry	Work Time	Clamp/Handling Time	Cure Time
08115	200mL					
38315	50mL	Black	Epoxy	90 min @ 70°F / 45 min @ 90°F (may be accelerated with heat)	4 hrs (may be accelerated with heat)	24 hrs
58115	450mL DMS					
08116	200mL	Black	Epoxy	2 hrs @ 70°F / 1 hr @ 90°F (may be accelerated with heat)	6 hrs (may be accelerated with heat)	24 hrs

3M Panel Bonding Adhesive provides a continuous bond and seals weld and rivet bonded areas against corrosions.



Rivet Bond



Weld Bond

Proven and trusted performance.

This two-part epoxy adhesive has been used in replacement of outer body panels for well over 15 years. It is accepted and recommended industry wide as a bonding solution that technicians have come to rely on daily when making quality repairs.

Applications

- Door skins
- Quarter panels
- Truck box sides
- Roof skins
- Bumper cover and plastic repair (under certain conditions)

Product Usage

OEM's and third parties often call for the use of adhesive in outer panel replacements. In many cases the use of adhesive alone is specified, or its use in conjunction with weld bonding or rivet bonding is recommended. 3M™ Panel Bonding Adhesive is intended to provide additional bond strength to the replaced outer panel while also providing corrosion resistance. It is supported with a lifetime warranty against corrosion when used in accordance with 3M's directions for use.

Areas of typical usage*

Blue Adhesive bonded areas

Red Suggested welded areas

*NOTE: This product is not intended to bond structural components of a vehicle such as pillars, rockers or frame members. If doubt exists as to whether a particular component is structural, then that component should be welded. For structural based repairs consider 3M™ Impact Resistant Structural Adhesive.



Door skin



Quarter panel



Truck box side assembly



Truck box side panel



Roof skin



Van side

3M™ Impact Resistant Structural Adhesive

	Part No.	Size	Color	Chemistry	Work Time	Clamp/ Handling Time	Cure Time
	07333	200mL	Dispenses Silver, Cures Purple	Epoxy	60 min @ 70°F 30 min @ 175°F (may be accelerated with heat)	8 hrs (may be accelerated with heat)	24 hrs
	57333	450mL DMS					

How are you inhibiting corrosion today?

Corrosion

The use of 3M™ Panel Bonding Adhesive with corrosion inhibitors completely seals weld or rivet bonded joints, preventing corrosion.

3M Warranty

3M guarantees that 3M Panel Bonding Adhesive (PNs 08115 and 08116) will perform to specifications for the life of the vehicle. This warranty covers parts, materials, labor and loss of use of the vehicle when used in accordance with 3M's directions for use.

Save Valuable Time & Process Steps for Shops

Within a process, when 3M Panel Bonding Adhesive is used the number of components that need to be removed and potentially broken declines, thereby reducing time and increasing returns to the shop. Interior disassembly as well as possible interior damage, due to the welding process, can be greatly minimized when using 3M Panel Bonding Adhesive.

Noise Vibration Harshness (NVH)

The use of 3M Panel Bonding Adhesive provides an added layer of noise and vibration damping protection.



Corrosion



Roof Panel Bonding

Welding vs. Adhesive Bonding

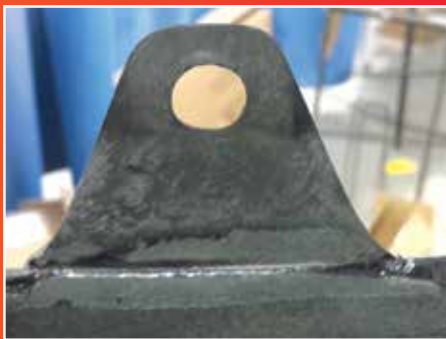
	Welding	Adhesive Bonding
Permanence	Permanent	Permanent
Stress Distribution	Local stress points in structure	Good uniform load distribution (except in peel)
Appearance	Usually acceptable (some dressing may be required)	No surface marking and joint almost invisible
Materials Joined	Limited to similar material groups (generally)	Ideal for most dissimilar materials
Corrosion Resistance	Accelerates corrosion	Excellent fatigue and electrical resistance reduces corrosion



Weld Bond



Rivet Bond



Plastic Repair

Did you know?

You can weld through uncured 3M™ Panel Bonding Adhesive (PN 08115) using squeeze-type resistance spot welding to form a weld bonded joint.

3M Panel Bonding Adhesive (PN 08115) is approved by Ford for F-150 Aluminum rivet bonding and bonding operations. Numerous OEMs and third parties recommend 3M Panel Bonding Adhesive. Learn more at [3MCollision.com/Adhesives](https://www.3M.com/Collision.com/Adhesives).

3M Panel Bonding Adhesive (PN 08115) can be “heat set” in as little as 15 minutes to handling strength.

3M Panel Bonding Adhesive has excellent adhesion to cold rolled steel, aluminum, sheet molded compound (SMC), fiber reinforced plastic (FRP) and more.

3M Panel Bonding Adhesive (PN 08115) works very well to repair many plastic substrates without the application of adhesion promoter.

Training Video



Scan QR Code for more information about PNs 08115 and 08116



For training videos and more
[3MCollision.com/Adhesives](https://www.3M.com/Collision.com/Adhesives)

3M™ Panel Bonding Adhesive

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	08115	200mL			90 min @ 70°F		
	38315	50mL	Black	Epoxy	45 min @ 90°F (may be accelerated with heat)	4 hrs (may be accelerated with heat)	24 hrs
	58115	450mL DMS					
	08116	200mL	Black	Epoxy	2 hrs @ 70°F 1 hr @ 90°F (may be accelerated with heat)	6 hrs (may be accelerated with heat)	24 hrs

Applicators

	Part No.	Size
3M™ Dynamic Mixing Applicator	05846	All DMS Products
3M™ Performance Pneumatic Applicator	09930	200mL
3M™ Performance Manual Applicator	08117	200mL
3M™ Manual Cartridge Applicator	08571	200mL
3M™ Performance Manual Applicator	08190	50mL

Accessories

	Part No.	Size
3M™ Dynamic Mixing Nozzles	55847	2:1, 1:1
3M™ Dynamic Mixing Nozzle Extension	58207	50:1, 2:1, 1:1
3M™ Static Mixing Nozzle	38191	50mL
	38193	
	08193	200mL,
	08194	400mL
3M™ Bulk Nozzle Rack	02576	200mL
3M™ Shop Rack	02530	200mL, 400mL

Substitution

3M™ Panel Bonding Adhesive can be used in outer body panel bonding applications, including weld bonding or rivet bonding of non-structural vehicle components. OEM's have called out both products, and where specified by an OEM, 3M recommends following that particular recommended product use or practice. Where non-structural bonding is being conducted and an OEM has not provided specific guidance on the use of a panel bond adhesive, 3M would recommend the use of PN 08115 or PN 08116 in the repair (including weld bonding or rivet bonding applications) following stated 3M directions for use, given they both serve as outer body panel bonding adhesives. For best results, 3M recommends referencing the OEM recommendations, where provided or available, in a repair situation in addition to the 3M directions for use. While it is the responsibility of the repairer to evaluate the overall situation in order to decide which product is fit for the specific use, 3M supports the use of 3M Panel Bonding Adhesive for panel replacements in cold repair, rivet bonded and weld bonded applications. Subject to the conditions described above, 3M Panel Bonding Adhesive should be appropriate for use in all outer panel bonding applications when directions for use are followed, where the following products are recommended: 3M™ Scotch-Weld™ Epoxy Adhesive DP490 or OEM Self-Branded Adhesives used in exterior panel attachment.

For videos and more, visit: 3MCollision.com/Adhesives



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