







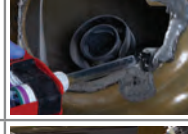










Aluminum Rivet Bonding			Product List	
1	Host Panel Preparation	 Using a grade 80 abrasive belt, remove remaining rivet material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Durable Flex Belt.		<ul style="list-style-type: none"> 3M™ File Belt Sander, PN 28366 3M™ Cubitron™ II File Belt, grade 80+, PN 33446 Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
2	Mating Flange Panel Preparation	 Remove Ecoat from replacement panel mating flange areas using a Scotch-Brite™ Belt or Clean N Strip Disc.		<ul style="list-style-type: none"> Scotch-Brite™ Roloc™ + Clean N Strip XT Disc, PN 07470 Scotch-Brite™ Roloc™ + Clean N Strip TR Disc, PN 07466 3M™ File Belt Sander, PN 28366 Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
3	Dry Fit Panel	 Dry fit replacement panel and complete any necessary metal straightening at flanges areas.		
4	Clean	 Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.		
5	Rivet Preparation	 Identify replacement rivet sites and prepare the surface for the type of rivet recommended by the manufacturer. (For blind or solid rivets, drill all necessary holes.) Remove panel once complete.		<ul style="list-style-type: none"> 3M™ File Belt Sander, PN 28366 Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
6	Pre Assembly NVH Replacement	 If vehicle construction necessitates, apply 3M™ NVH Dampening Material or 3M™ Flexible Foam at original locations as required.		<ul style="list-style-type: none"> 3M™ NVH Dampening Material, PN 04274 3M™ Flexible Foam, 200mL, PN 08463
7	Apply Bonding Adhesive	 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 area to ensure proper bond line thickness		<ul style="list-style-type: none"> 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
8	Install Replacement Panel	 Install replacement panel to host panel taking care to avoid scraping off any adhesive during installation. Clamp in place.		
9	Install Rivets and Welds	 Install replacement rivets to all areas as recommended by the OE manufacturer. Note: Rivets must be installed while adhesive is uncured. Weld cosmetic joints/splices as necessary or recommended by the OE Manufacturer.		
10	Adhesive Clean Up	 Remove clamps and tool excess adhesive squeeze out from repair area prior to curing to seal the repair. An acid brush works well to remove adhesive from between clamps. Note: Grinding to remove excess cured adhesive can expose bare metal, causing corrosion.		
11	Post Assembly Foam Replacement	 Apply foams at original locations as required.		<ul style="list-style-type: none"> 3M™ Flexible Foam, 200mL, PN 08463 3M™ Rigid Pillar Foam, 200mL, PN 08458

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For ordering information, contact your 3M Sales Representative

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



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

