

*3M™ Automix™ Panel Bonding Adhesive is a two part adhesive designed to bond steel, aluminum, SMC and FRP. When used according to directions, 3M™ Automix™ Panel Bonding Adhesive may be used in the replacement of automotive doorskins, quarter panels, box sides, van sides, roofs, and other outer body sheet metal.*

***DO NOT USE on structural components such as rails, pillars, rocker panels, core supports, etc..***

1. Remove all paint and rust from surfaces to be bonded using a 36 or 50 grit 3M™ Abrasive Disc.
2. Straighten all metal, and “dry-fit” part.
3. Clamp part in place and check for fit and alignment.
4. Remove panel from vehicle.
5. Use 3M™ General Purpose Adhesive Cleaner (PN 08984, 08986 or 08987) to remove any grease, wax and/or tar from surface to be bonded. Read manufacturer’s hazard communication and follow manufacturer’s recommended guidelines for safe handling of the above chemical products.\*
6. Place adhesive cartridge in applicator gun.
7. Remove end seal cap from adhesive cartridge.
8. Dispense just enough adhesive to be sure that both parts A and B are present.
9. Attach 3M™ Mixing Nozzle (PN 08193) to cartridge and lock in place with retaining collar.
10. You may cut end of mixing nozzle to provide desired bead size.
11. Apply adhesive to all areas to be bonded (all bare metal surfaces). Using a plastic spreader, tool out the adhesive to cover all bare metal surfaces.
12. Apply an adhesive bead approximately 1/4” from the inside edge of the replacement panel.

\*Local air quality regulations may regulate or prohibit the use of surface preparation and cleanup materials based on VOC content. Consult your local air quality regulations.

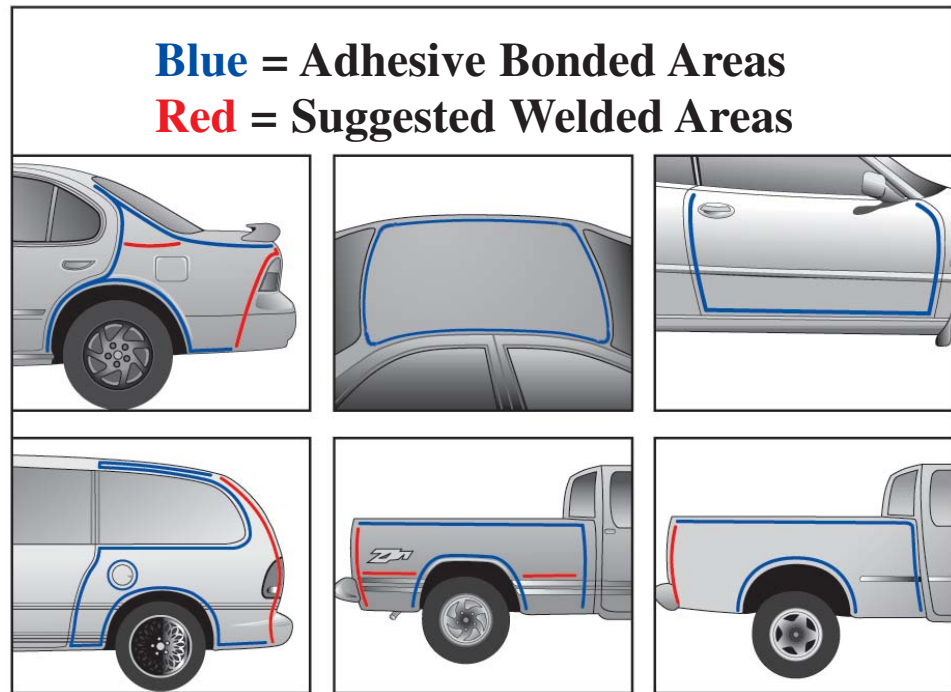
**Quarter Panels:** Adhesive should be applied to the lower edge, the wheel opening, the door jamb areas of the quarter, and at the factory seam of the sail panel. 3M suggests that the rear vertical portion of a quarter panel be welded.

It is acceptable to bond the rear vertical portion of a quarter panel if recommended by the OEM. In addition, most OEM's only recommend full panel replacement. Should you perform a belt cut on a sail panel, 3M recommends to weld the belt cut to ensure optimal cosmetic appearance. All areas to be welded should be sprayed with 3M™ Weld-Thru II (PN 05917). Do not apply adhesive to these areas.

**Roof Panels:** Adhesive should be applied around the perimeter of the roof panel. Apply 3M™ Urethane Seam Sealer (PN 08360 or 08361), 3M™ Ultrapro MSP Seam Sealer (PN 08369 or 08370), or 3M™ Duramix™ NVH Damping Material (PN 04274) to the roof bows if needed

**Door Skins:** Adhesive should be applied to the hem flange area. Apply spots of 3M™ Urethane Seam Sealer (PN 08360 or 08361) or 3M™ Ultrapro MSP Seam Sealer (PN 08369 or 08370) at the intrusion beam, if needed. 3M™ Automix™ Flexible Foam (PN 08463) or 3M™ Duramix™ NVH Damping Material (PN 04274) may also be used.

13. Clamp the panel in its proper position.
14. Tool any adhesive “squeeze out” to seal the outside of the seam all along the bonded edge of the panel.
15. It is suggested to weld the areas marked in red (see specific panels after step 12). You may weld as soon as the panel is in place and fixtured.



**Caution:** The adhesive is combustible. Keep any MIG welding a minimum of two inches from the adhesive. As with any welding operation, keep the appropriate fire extinguisher within reach, and be alert to any smoke or flame that may be present. Resistance spot welding through uncured adhesive is acceptable.

16. Spray the inside of the quarter and welded seams with 3M™ Rust Fighter-I (PN 08891 or 08892).
17. Clamps may be removed after six hours at 73°F. Part will need to remain clamped longer if temperature is below 73°F and/or if there is any tension on the part. Cure time may be accelerated by applying heat with a heat gun or lamps (Do not exceed 250°F at 45 minutes). Allow 24 hours before returning vehicle to service.

**Warranty and Limited Remedy:** 3M warrants that 3M™ Automix™ Panel Bonding Adhesive PN 08116 will meet 3M's specifications for the life of the vehicle if the 3M product is applied as described in 3M's Directions For Use. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. If any 3M product fails to meet 3M's specifications during the life of the vehicle and as a result the panel bond fails, 3M's entire liability and purchaser's exclusive remedy will be the reimbursement of the cost of the parts, materials and labor needed to reattach the panel(s) plus reimbursement of the cost of a comparable rental vehicle during the repair time period within a reasonable time after written notification of the defect and return of the defective product to 3M, if requested by 3M.

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

### 3M Automotive Aftermarket Division

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