

3M Panel Bonding Adhesive

For use with 50 mL EPX applicator PN 21791

Adhésif pour panneaux

À utiliser avec l'applicateur NP 21791 EPX destiné aux cartouches de 50 ml

Adhesivo para Unir Paneles

Para utilizarse con el aplicador EPX de 50 ml (N. 21791)

38315

- 3M™ Automix™ Epoxy Technology
- Technologie axée sur l'utilisation d'adhésifs époxydes Automix™ 3M™
- Tecnología Epoxi Automix™ de 3M™

- Corrosion Inhibiting
- Heat Cure on Demand
- Bonds Steel, Aluminum, SMC & FRP
- Inhibiteur de corrosion
- Thermdurcissement à la demande
- Lie l'acier, l'aluminium, les SMC et le PRF
- Inhibidora de la Corrosión
- Cura de Calor a Petición
- Pega sobre Acero, Aluminio, SMC y FRP



DIRECTIONS FOR USE

3M™ Panel Bonding Adhesive is a two part epoxy adhesive designed to bond non-structural steel, aluminum, SMC and FRP body panels. When used according to directions, 3M™ 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.

ACCESSORIES:

Applicator Gun: PN 08190

Mixing Nozzle: PN 38193, PN 38191

SURFACE PREPARATION:

1. Wash the surfaces with soap and water to remove water soluble contaminants. Follow the soap and water wash with an appropriate VOC Compliant 3M cleaning product for removal of other surface contaminants. Reference the 3M Automotive Aftermarket Catalog for a suitable product.
2. Remove all rust, primer and paint from the areas to be bonded or welded using a Scotch-Brite® Clean & Strip Disc or 3M grade 50 Grinding Disc.
3. Straighten all metal, and "dry-fit" the parts.
4. Clamp the part in place and check for fit and alignment.
5. Remove the panel from the vehicle. All areas to be welded should be coated with 3M™ Weld-Thru II Coating (PN 05917) according to the directions on the can. Adhesive should not be applied to these areas.

PRODUCT PREPARATION:

6. Place an adhesive cartridge in the applicator gun.
7. Remove cap from cartridge by turning 1/4 turn counter clockwise. Discard cap.
8. Before attaching a nozzle, "equalize" the cartridge by dispensing just enough product to be sure that both parts A and B are present at the outlet.
9. Attach a 3M™ Static Mixing Nozzle to the cartridge and lock in place by turning 1/4 turn clockwise.
10. Dispense a small amount of material through the mixing nozzle onto a disposable surface and discard.

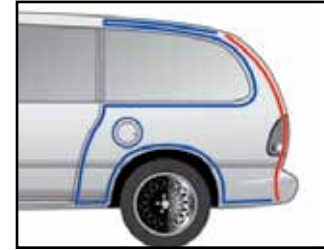
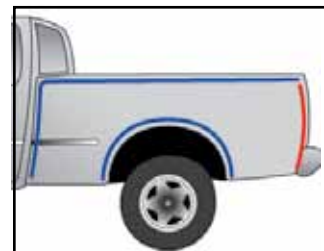
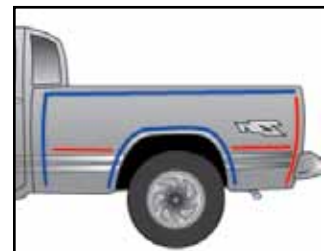
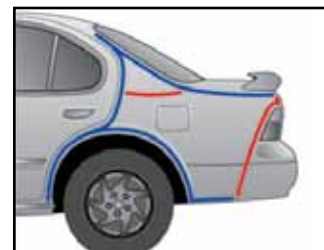
REPAIR PROCESS:

11. Apply an adhesive bead to all bare metal surfaces of both pieces to be bonded. Using a plastic spreader or acid brush, tool out the adhesive to cover all bare metal surfaces.

12. Apply a 1/8" diameter adhesive bead approximately 1/4" from the inside edge of the replacement panel.
 - **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 should be welded. It is acceptable to bond the rear vertical portion of a quarter panel, if recommended by the OEM. Additionally, most OEM's only recommend full panel replacement. Should you perform a belt cut on a sail panel, 3M recommends welding 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. To replace the factory-applied NVH foam/spacer between the roof bow and the roof panel, use one of the following: 3M™ Urethane Seam Sealer (PN 08360, PN 08361 or PN 08364), 3M™ MSP Seam Sealer (PN 08369 or PN 08370), or 3M™ NVH Dampening Material (PN 04274) to the roof bows as needed.
 - **Door Skins:** Adhesive should be applied to the hem flange area. To replace the factory-applied NVH foam/spacer between the intrusion beam/s and the door skin, use one of the following: 3M™ Urethane Seam Sealer (PN 08360, PN08361 or PN 08364), 3M™ MSP Seam Sealer (PN 08369 or PN 08370), or 3M™ NVH Dampening Material (PN 04274) to the intrusion beam/s as needed.
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. 3M suggests welding those areas marked in RED in the accompanying diagram. You may weld as soon as the panel is in place and fixtured securely.
 - **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 quarter panels, interior cavities, and any welded seams with 3M™ Rust Fighter-I (PN 08891 or PN 08892).
17. Clamps may be removed after four hours at 73°F. Parts will need to remain clamped longer if the temperature is below 73°F and/or if there is any tension on the part. The cure time may be accelerated by applying heat with a heat gun or lamps.
18. Allow 24 hours at a minimum of 73°F before returning vehicle to service.

Blue = Adhesive Bonded Areas

Red = Suggested Welded Areas



3M LIFETIME GUARANTEE

3M guarantees to the purchaser that 3M™ Panel Bonding Adhesive PN 08115 will perform to specifications for the life of the vehicle. This Guarantee covers parts, materials, labor and loss of use of the vehicle.

Repair Order # _____

Make/Model/Year _____

VIN# _____

Technician _____ Date _____

GARANTIE À VIE DE 3M

3M garantit à l'acheteur que l'adhésif pour panneaux 08115 3M™ offrira un rendement conforme aux spécifications pendant toute la durée utile du véhicule. La présente garantie couvre les pièces, les matériaux, la main-d'œuvre et la perte d'utilisation du véhicule pendant la réparation.

N° de bon de réparation _____

Marque/Modèle/Année _____

NIV _____

Technicien _____ Date _____

GARANTÍA VITALICIA DE 3M

3M le garantiza al comprador que el Adhesivo para Unir Paneles Automix™ de 3M™ PN 08115 cumplirá con las especificaciones durante toda la vida útil del vehículo. Esta Garantía cubre piezas, materiales, mano de obra y pérdida de uso del vehículo.

Orden de Reparación N° _____

Marca/Modelo/Año _____

VIN N° _____

Técnico _____ Fecha _____

Keep for shop records • Conserver dans les dossiers de l'atelier • Mantener para los registros del negocio

3M Automotive Aftermarket Division

3M Center, Building 223-6N-01

St. Paul, MN 55144-1000

1-877-MMM-CARS (666-2277)

www.3M.com/automotive

Conserver dans les dossiers de l'atelier

Compagnie 3M Canada

C.P. 5757

London (Ontario) N6A 4T1

Importado por:

3M Mexico, S.A. de C.V.

Av. Santa Fe No. 190, Col. Santa Fe

C.P. 01210, Del Alvaro Obregon,

Mexico, D.F.

Made in the USA with US and globally sourced materials.

Fabriqué aux États-Unis avec des matériaux américains et d'origines diverses.

Hecho en EUA con materiales universales y de EUA.

3M, Scotch-Brite and Automix are trademarks of 3M Company.

3M, Scotch-Brite et Automix sont des marques de commerce de la Compagnie 3M.

3M, Scotch-Brite y Automix son marcas comerciales de 3M Company.

Printed in U.S.A.

Imprimé aux É.-U.

Impreso en E.U.A.

© 3M 2011.

All rights reserved.

Tous droits réservés.

Todos los Derechos Reservados.

60-4550-5237-7

34-8705-8434-8

CLEAN-UP:

Prior to curing, PN 08115 may be cleaned from most surfaces using water or with an appropriate VOC Compliant 3M cleaning product. Reference the 3M Automotive Aftermarket Catalog for a suitable product.


STORAGE:

After use, leave the mix nozzle in place to seal the cartridge.

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 and Limited Remedy: 3M warrants that 3M™ Panel Bonding Adhesive PN 08115 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: 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.

3M Automotive Aftermarket Division Creator: Betsy Berge File Name: 34870584348.indd Reference: 38315 Panel Bond Adhesive Structure #: SS-xxxx Date: 3/8//11	Printed Colors - Front: 	Notes To Printer: None. Special Instructions: None.
	Printed Colors - Back:	
	March Colors:	