

Door Skin Replacement

1		Door Frame Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ belt.
2		Clean Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.
3		Replacement Skin Prep Scuff replacement skin mating flange areas using Scotch-Brite™ hand pad.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.
5		NVH Replacement Apply NVH material at original locations on intrusion beam.
6		Apply Bonding Adhesive Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply bonding adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.
7		Install Door Skin Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)
8		Clamp and Cure Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze-out from hem flange area with a VOC compliant cleaner.
9		Seam Sealing Re-apply seam sealer to hem flange as required following general seam sealing guidelines.

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Product List

3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II File Belt,
grade 80+, PN 33446



Scotch-Brite™ Durable
Flex Belt, CRS, PN 64475



Scotch-Brite™ Durable
Flex Hand Pad, MX-HP,
4-1/2 in. x 9 in., Very Fine,
PN 64659



Scotch-Brite™ 7447 PRO
Hand Pads, Very Fine,
6 in. x 9 in., PN 64926



3M™ NVH Dampening
Material, PN 04274



3M™ Urethane Seam
Sealer, PN 08361



3M™ MSP Seam
Sealer, PN 08370



3M™ Panel Bonding Adhesive,
50mL, PN 38315;
200mL, PN 08115;
200mL, PN 08116;
450mL DMS, PN 58115



3M™ Composite and
Metal Bonding Adhesive,
200mL, PN 08219



3M™ Bare-Metal Seam
Sealer 200mL, PN 08310;
600mL DMS, PN 58310



3M™ EZ Sand Multi-Purpose
Repair Material,
200mL, PN 05887;
600mL DMS, PN 55887



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326

