



# PANEL & RIVET BONDING

## STANDARD OPERATING PROCEDURE

1

### REMOVE PART



Remove spot welds with spot weld cutter. Remove rivets by drilling or grinding. Remove damaged panel and straighten bent flanges with a hammer and dolly.

2

### DRY FIT



Dry fit all panels to ensure proper alignment. Drill holes for replacement rivets or mark locations of self-piercing rivets.

3

### PREP AND GRIND



Clean with **SEM Solve** or **XXX Universal Surface Cleaner**

Grind mating flanges with a 36-80 grit grinding disc, per product TDS, at low speed for an aggressive grind mark. Remove any adhesive or protective coatings.

ⓘ If rivet bonding, manufacturers may recommend leaving OEM e-coat on the surface of the new panel. If so, scuff with a red scuff pad.

4

### APPLY ADHESIVE



Apply 3/8" – 1/2" bead of **Dual-Mix™ Multi-Purpose Panel Adhesive** or **Structural Impact Resistant Adhesive** per OEM recommendation to both surfaces. Use enough material to completely fill the joint when parts are clamped. Tool with a spreader or acid brush. Cover all exposed bare metal.

ⓘ For smaller parts use **Dual-Mix™ Door Skin & SMC Adhesive**

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### (OPTION 1) PANEL BONDING



Clamp panel into place. Do not over clamp. Wipe away excess material.

ⓘ Surfaces must be mated during adhesive's working time.

### (OPTION 2) RIVET BONDING



Clamp panel in place. Install rivets per manufacturer's recommendations during adhesive's working time. Remove clamps after rivets have been installed. Wipe away excess material.

## PRODUCT LIST



### PREP

Part	Product	Size
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



### ADHESIVE

Part	Product	Size
39337	Dual-Mix Door Skin & SMC Adhesive	7 oz. Cartridge
39747	Dual-Mix Multi-Purpose Panel Adhesive	7 oz. Cartridge
39757	Dual-Mix Structural Impact Resistant Adhesive	7 oz. Cartridge



### ABRASIVES

Part	Product	Size
SA25036	36 grit QLock Grinding Disc	2" Disc
SA25050	50 grit QLock Grinding Disc	2" Disc
SA25080	80 grit QLock Grinding Disc	2" Disc

Other sizes available on [semproducts.com](http://semproducts.com)

### SEM Products

Rock Hill, SC 29730  
 Tech Support: 1-800-831-1122  
 Customer Care: 1-866-327-7829  
[semproducts.com](http://semproducts.com)