SEM® PANEL & WELD 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 at low speed for aggressive grind mark. Remove any adhesive or protective coatings.

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**

5 (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) WELD BONDING

Clamp panel in place. Weld panel by using Squeeze Type Resistance Spot Welding (STRSW) or traditional MIG welding per the manufacturer's recommendations during adhesive's working time. Remove clamps after welds have been completed. Wipe away excess material.

ⓘ No gaps are required for weld bonding through epoxy adhesives. Always follow OEM's instructions for guidelines.

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

ⓘ CHECK LOCAL VOC REGULATIONS TO ENSURE COMPLIANCE OF ALL PRODUCTS IN YOUR AREA. ALWAYS WEAR OSHA REQUIRED (PPE) PERSONAL PROTECTION EQUIPMENT TO ENSURE YOUR SAFETY.