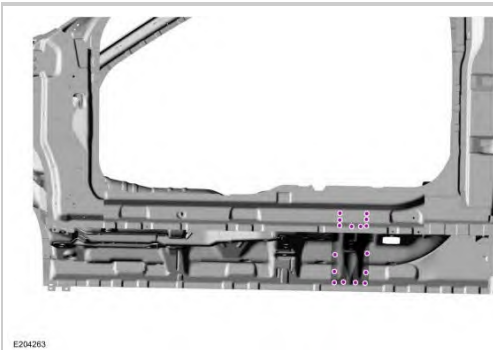


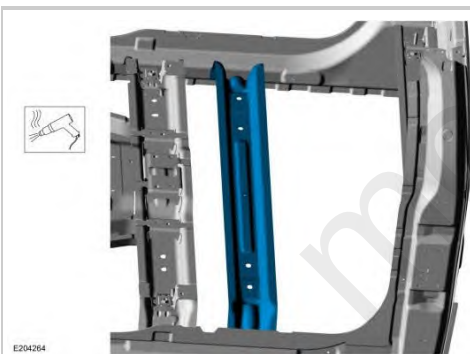


6.

 **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

Break the adhesive bond and remove the floor panel reinforcement.

Use the General Equipment: Hot Air Gun



REMOVAL AND INSTALLATION > FLOOR PANEL REINFORCEMENT > INSTALLATION

 **NOTE:** Floor panel reinforcements may be sectioned providing sectioning does not take place within 50 mm of weld nut or component mounting points. The following procedure assumes full component replacement.

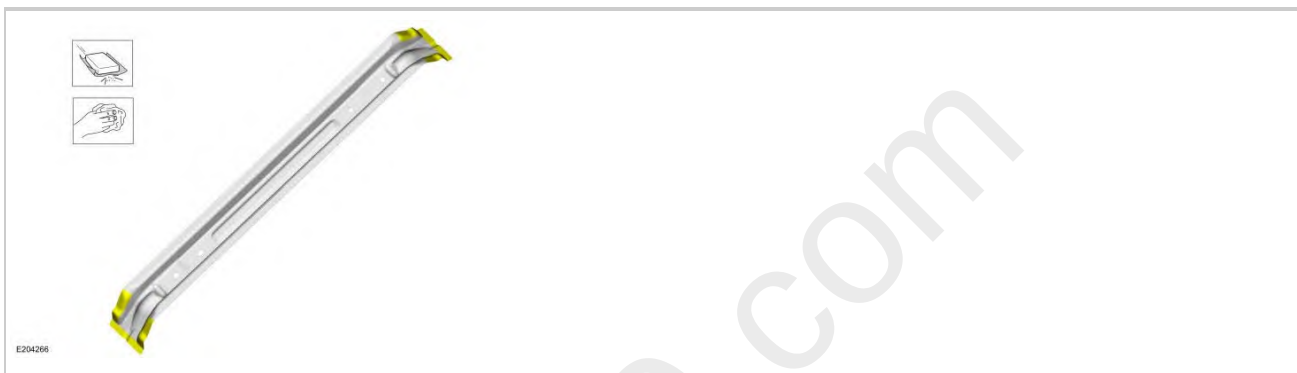
1.

Sand using 80 grit sand paper to remove old adhesive and clean (both sides).



2.

Sand using 80 grit sand paper to remove e-coat and clean.



3.

If sectioning: Refer to: Joining Techniques .

4.

Apply adhesive (both sides)

Material

: Metal Bonding Adhesive / TA-1, 3M™ 08115, Fusor® 108B



5.

Install the reinforcement and clamp in position.

Use the General Equipment: Locking Pliers



6.

Drill 6.5 mm holes for blind rivet installation (both sides).

Use the General Equipment: 6.5 mm Drill Bit



7.

 **NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

 **NOTE:** Blind rivet or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

 **NOTE:** Specific technical details including, but not limited to, fastener and adhesive information is included in the Instruction Sheet for each service part (found in the service part packaging). Instruction Sheets can also be found on the PTS (Professional Technician Society) located under the Service Tips tab for this vehicle.

Install blind rivet fasteners (both sides). Refer to: Joining Techniques .