

Joining Techniques

Special Tool(s) / General Equipment

Spherical Cutter
Plasma Cutter
Air Body Saw
8 mm Drill Bit
MIG/MAG Welding Equipment

Materials

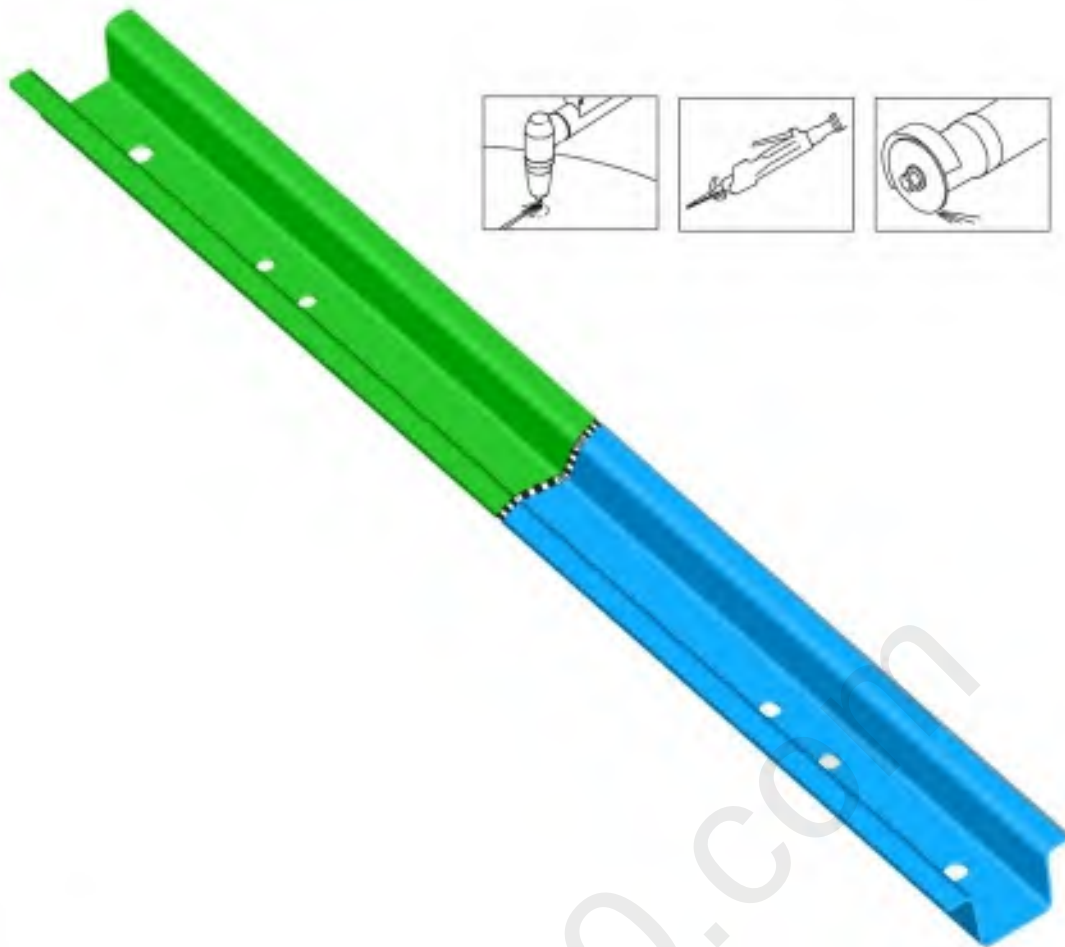
Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B	-

Repair

NOTE: The following provide general joining options for sectioned or sliced components and are not all inclusive. Regardless of component to be joined, whenever possible a backing plate should be used to assure a quality repair.

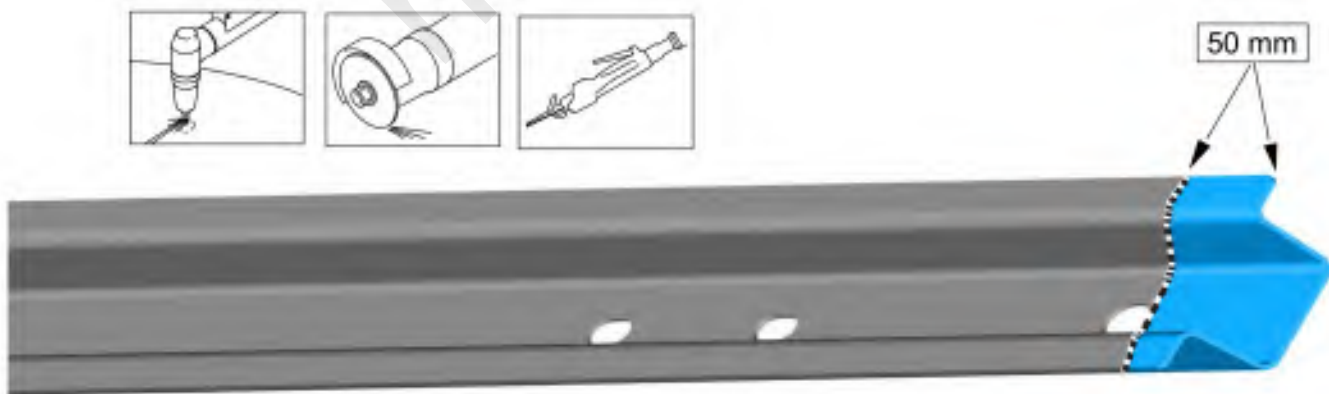
NOTE: Rivet Bonding

1. Determine sectioning point of component and make appropriate cut.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter
Use the General Equipment: Plasma Cutter



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2. Make a 50 mm wide backing plate from an unused portion of the old or new service part.
 Use the General Equipment: Air Body Saw
 Use the General Equipment: Spherical Cutter
 Use the General Equipment: Plasma Cutter

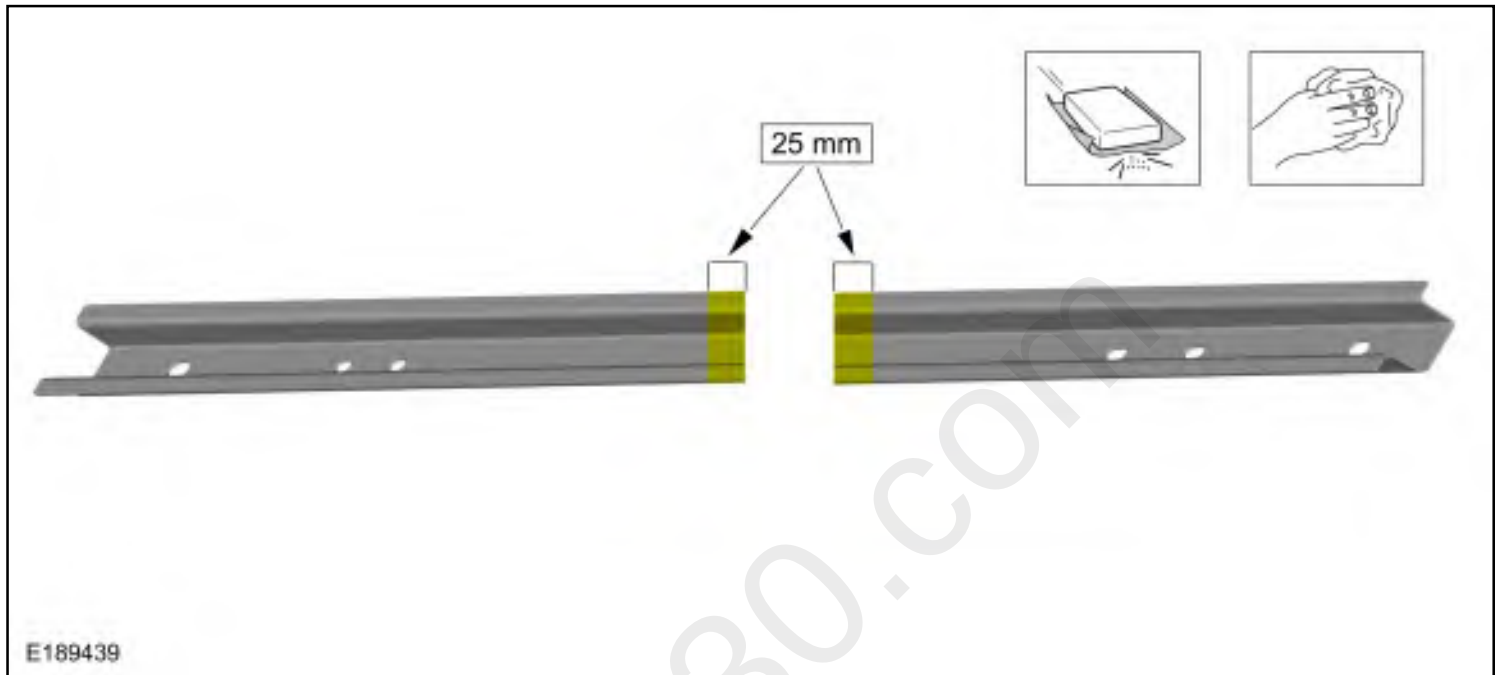


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3. Measure and cut to fit the replacement service component.

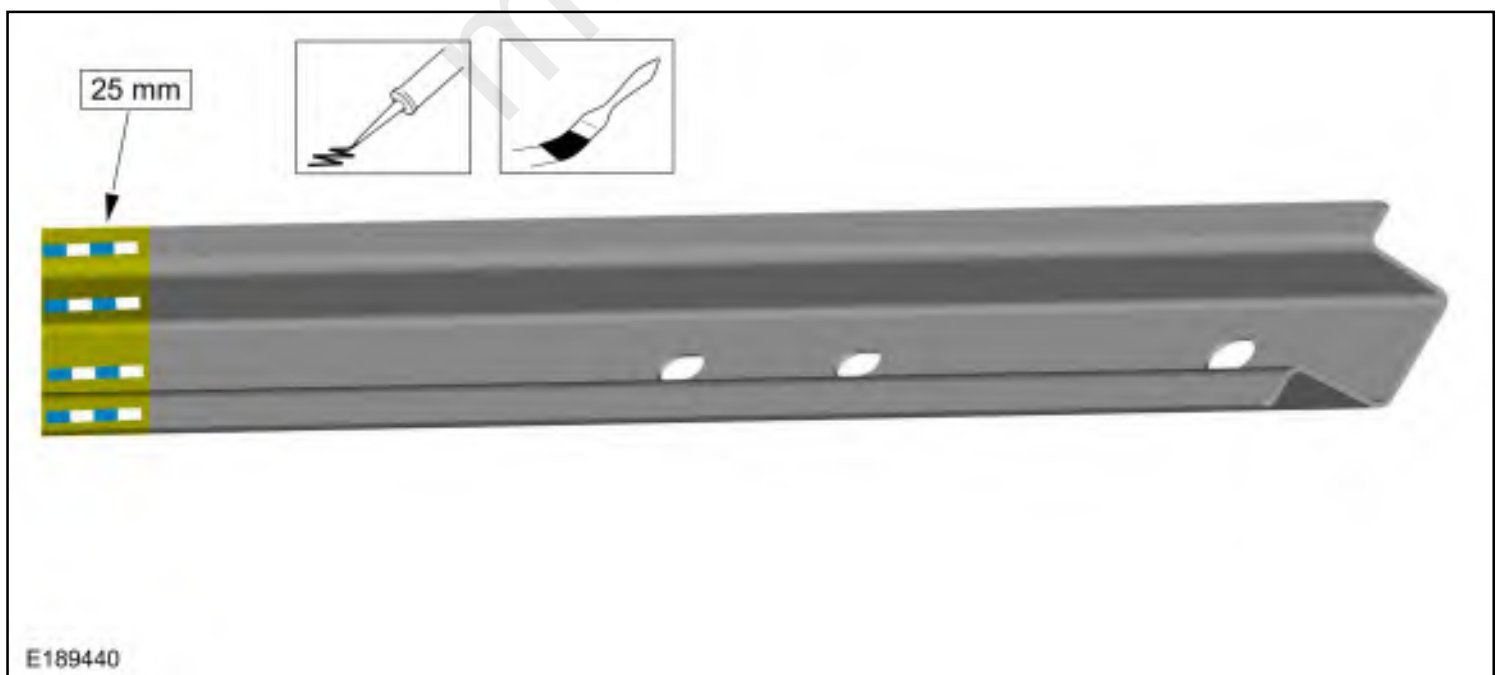
4. **NOTE:** 80 to 125 grit sand papers are the recommended for best adhesion.

Remove old adhesive and e-coat from mating surfaces of the original component and the replacement part measuring 25 mm on each.

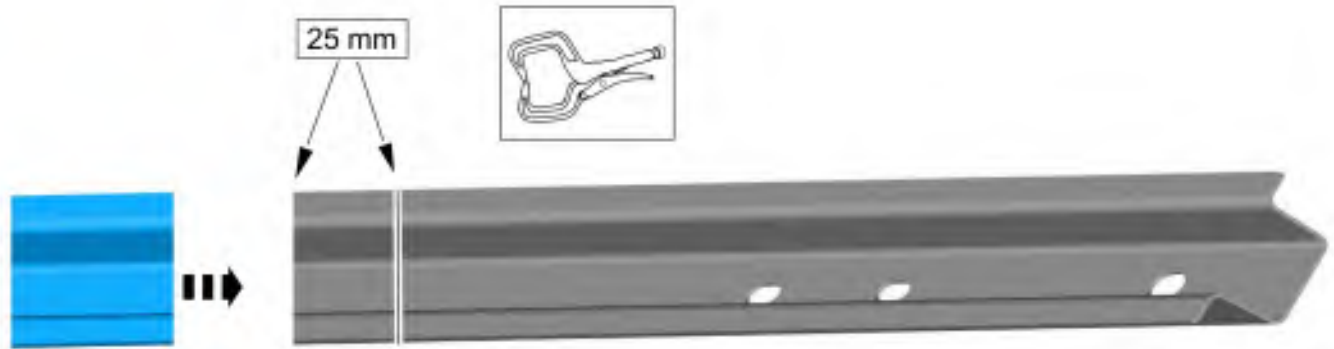


5. Apply adhesive to existing component and evenly spread using a stiff bristle brush.

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



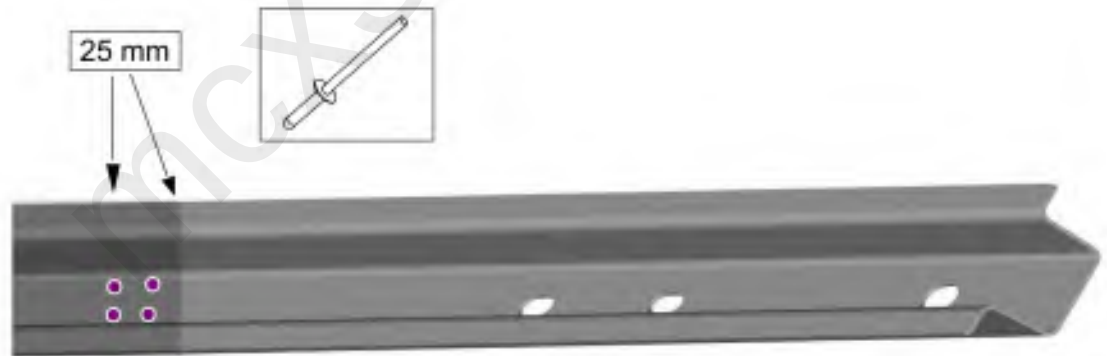
6. Install and clamp backing plate to existing component.



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7. Install appropriate fasteners.

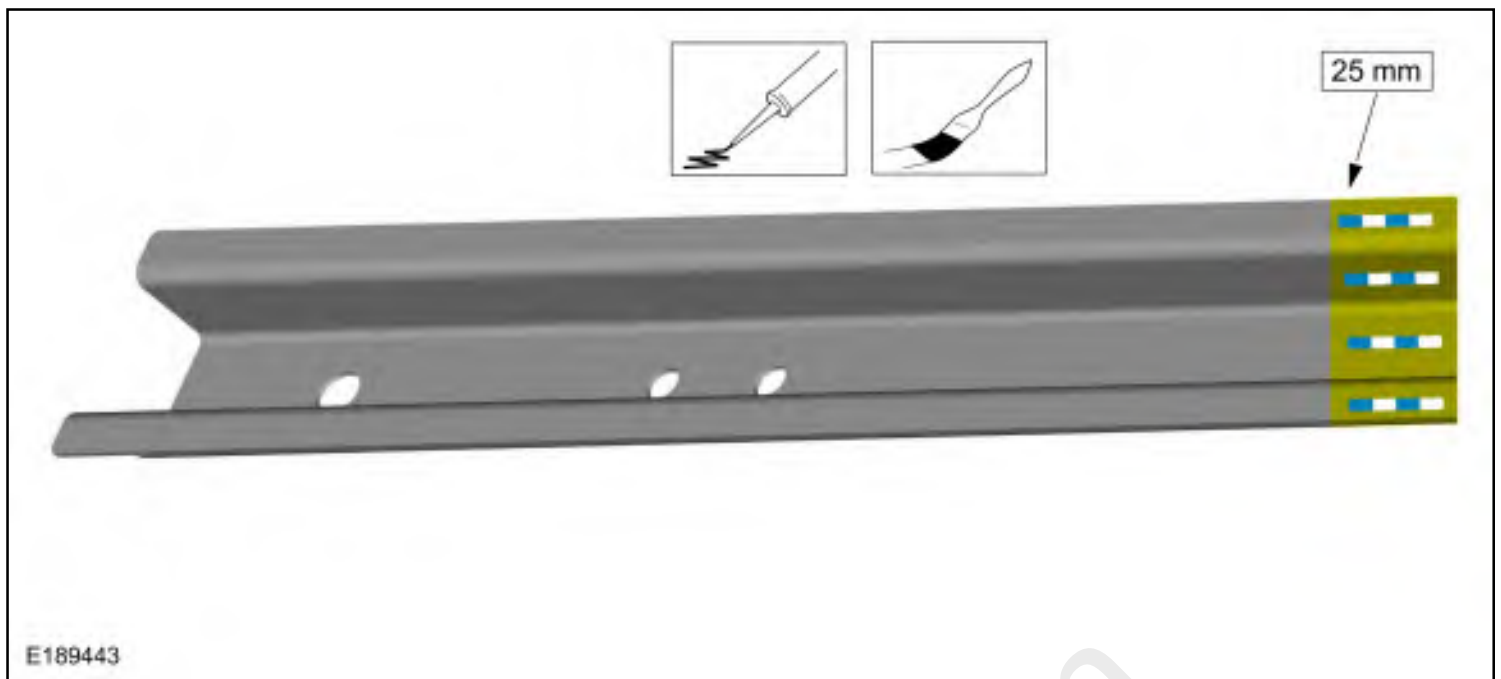
Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).



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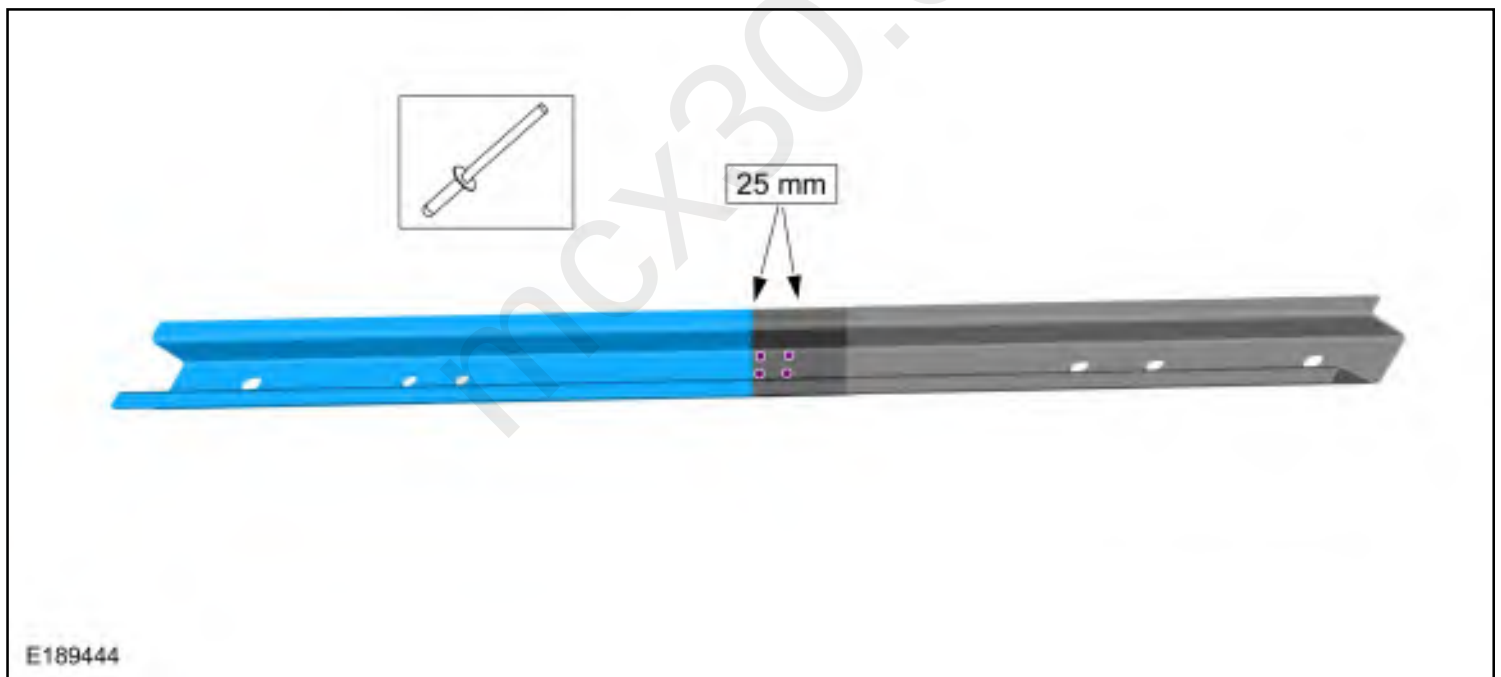
8. Apply adhesive to replacement component and evenly spread using a stiff bristle brush.

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



9. Install service component and appropriate fasteners.

Refer to: [Special Repair Considerations for Aluminum Repairs](#) (501-25 Body Repairs - General Information, Description and Operation).



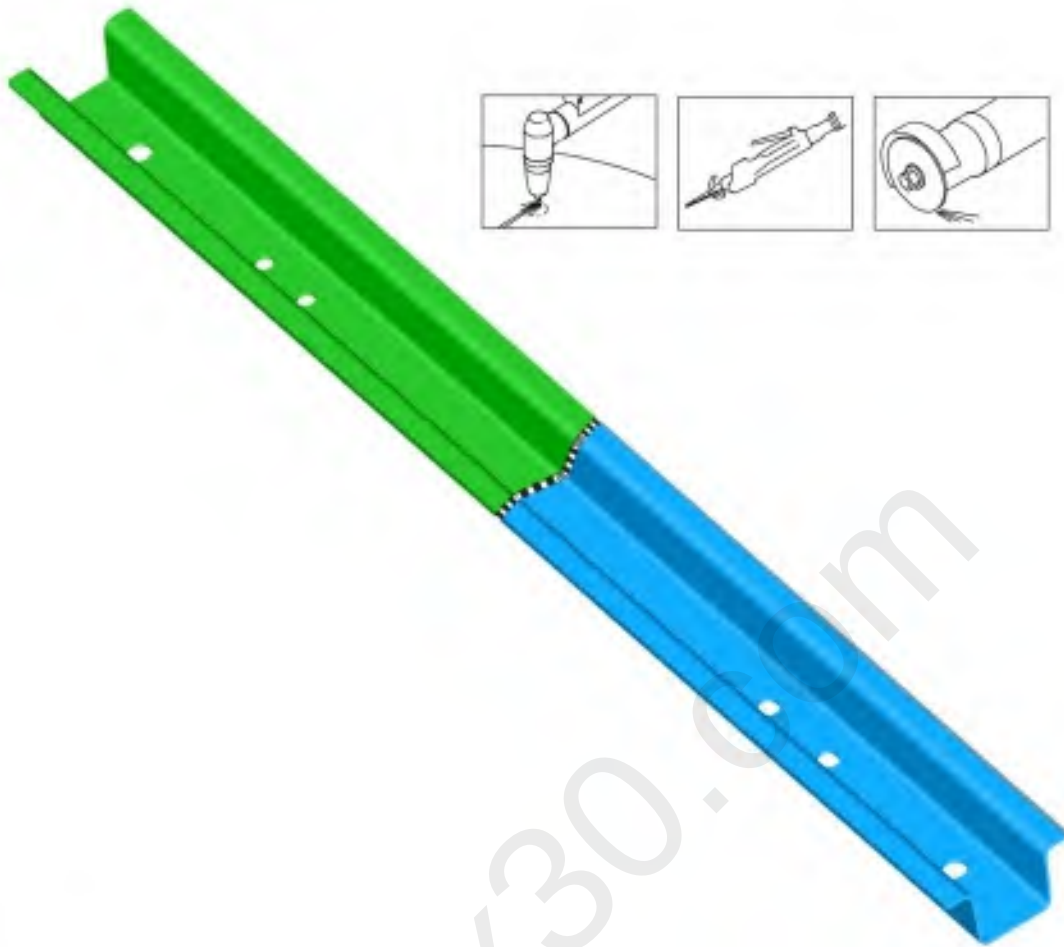
Repair

NOTE: *Welded Method*

1. Determine sectioning point of component and make appropriate cut.
Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

Use the General Equipment: Plasma Cutter



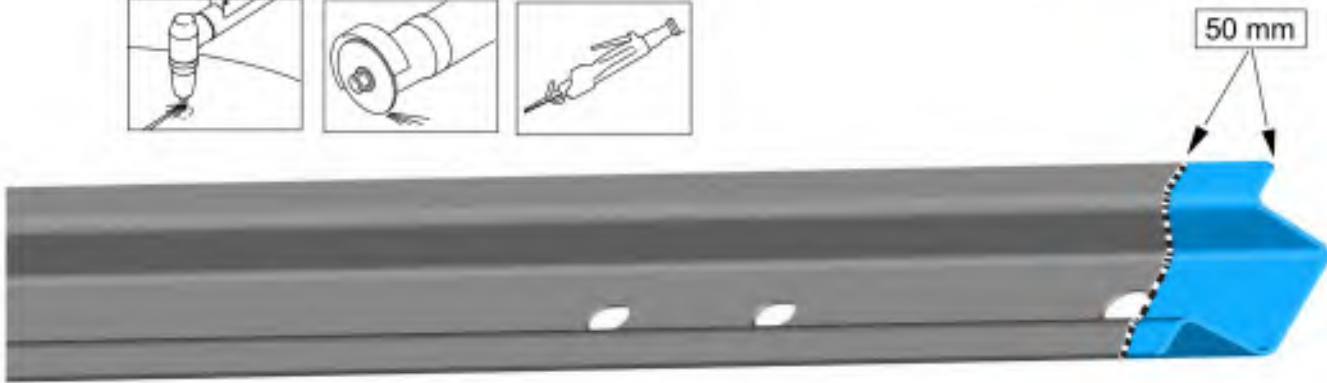
2. After removing the damaged sheet metal panel(s), repair any damaged flanges on the vehicle using a hammer and dolly.

3. Make a 50 mm wide backing plate from an unused portion of the old or new service part.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

Use the General Equipment: Plasma Cutter



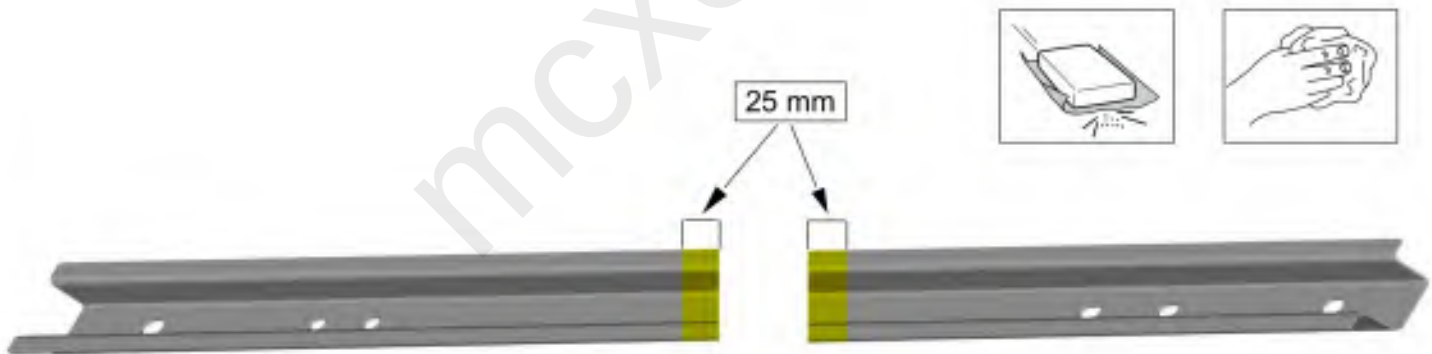
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4. Measure and cut to fit the replacement service component.

5. **NOTE:** 80 to 125 grit sand papers are the recommended for best adhesion.

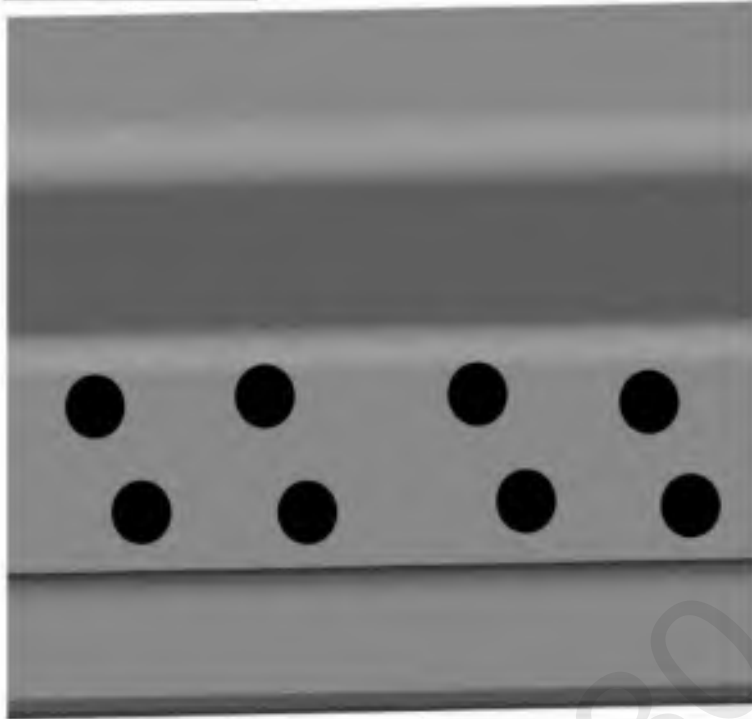
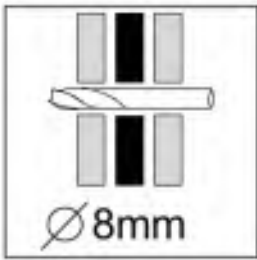
Remove old adhesive and e-coat from mating surfaces of the original component and the replacement part measuring 25 mm on each.



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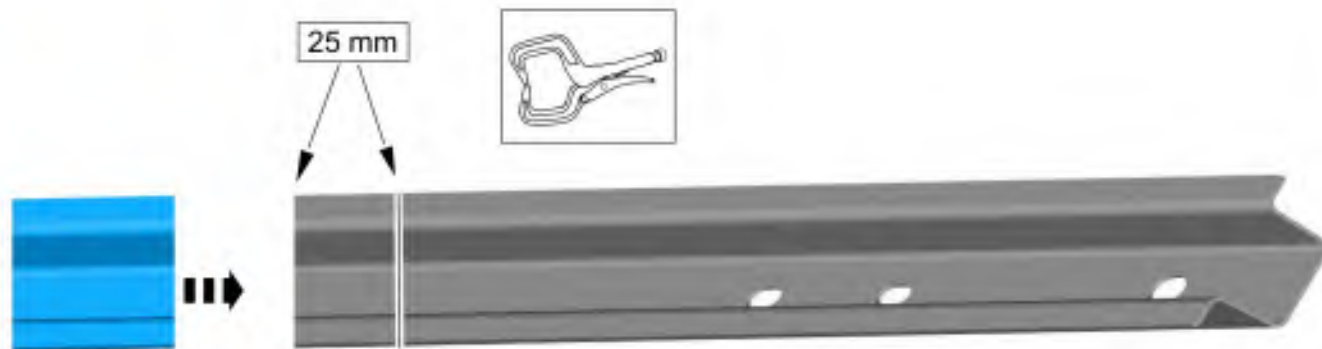
6. Drill plug weld holes in backer plate as indicated.
Use the General Equipment: 8 mm Drill Bit



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7. Install and clamp backing plate to existing component.

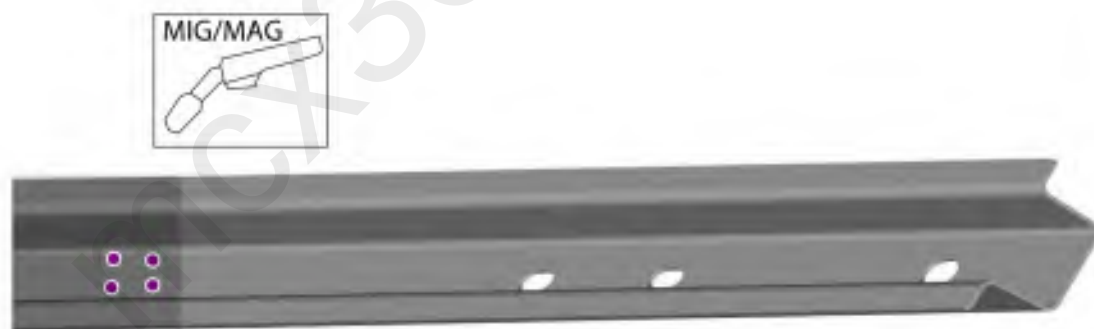


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8. NOTICE: MIG welder must be set up for aluminum application.

Plug weld as indicated.

Use the General Equipment: MIG/MAG Welding Equipment



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9. NOTICE: MIG welder must be set up for aluminum application.

Install service component and plug weld as indicated.

Use the General Equipment: MIG/MAG Welding Equipment



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10. **NOTICE: MIG welder must be set up for aluminum application.**

Seam weld repair area as indicated.

Use the General Equipment: MIG/MAG Welding Equipment



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