

Joining Techniques

Special Tool(s) / General Equipment

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

Materials

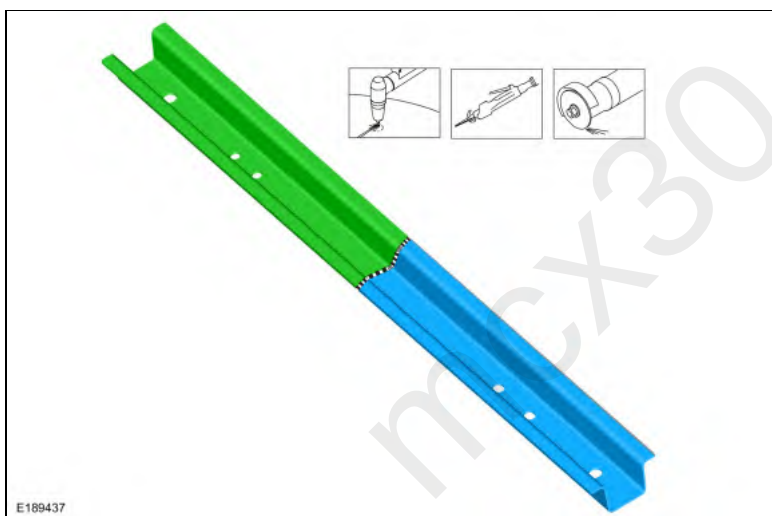
Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] 08115, LORD Fusor [®] 108B	-

Repair

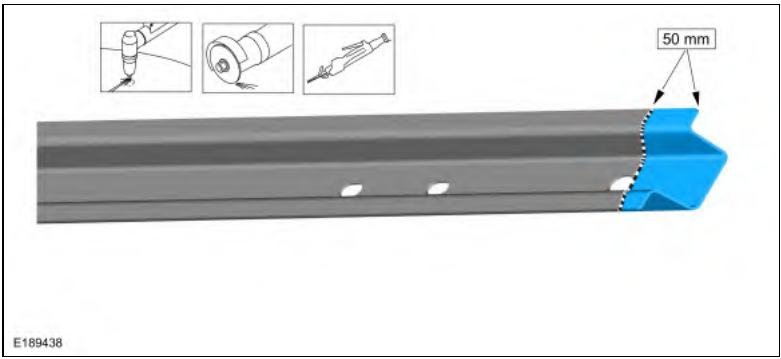
NOTE: The following provide general joining options for sectioned or sliced components and are not all inclusive. Regardless of component to be joined, whenever possible a backing plate should be used to assure a quality repair.

NOTE: Rivet Bonding

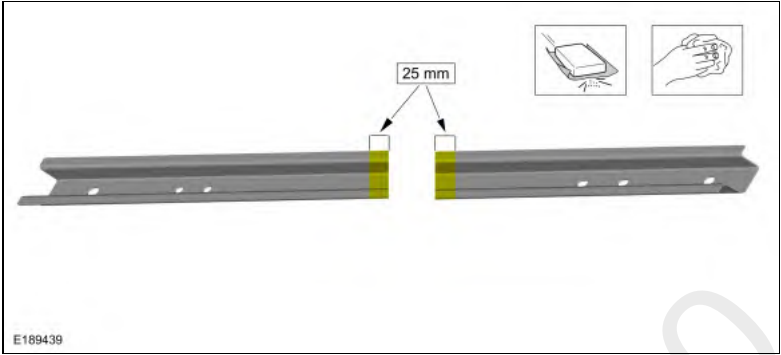
1. Determine sectioning point of component and make appropriate cut.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter
Use the General Equipment: Plasma Cutter



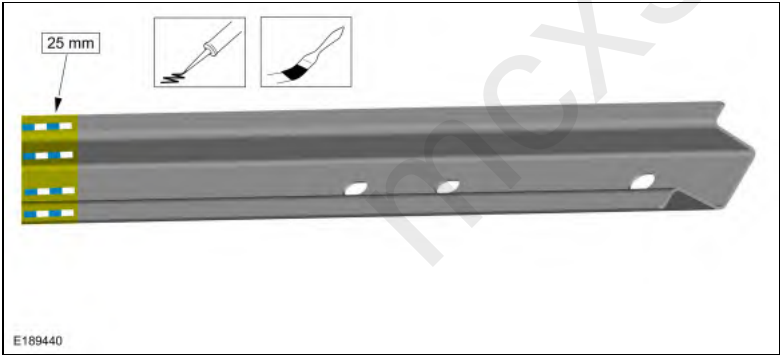
2. Make a 50 mm wide backing plate from an unused portion of the old or new service part.
Use the General Equipment: Air Body Saw
Use the General Equipment: Spherical Cutter
Use the General Equipment: Plasma Cutter



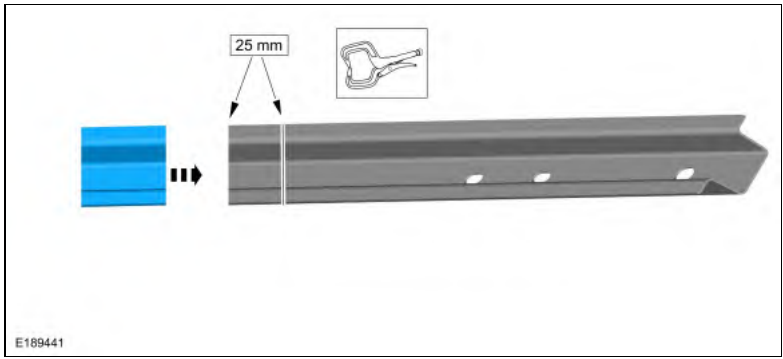
3. Measure and cut to fit the replacement service component.
4. **NOTE:** 80 to 125 grit sand papers are the recommended for best adhesion.
- Remove old adhesive and e-coat from mating surfaces of the original component and the replacement part measuring 25 mm on each.



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

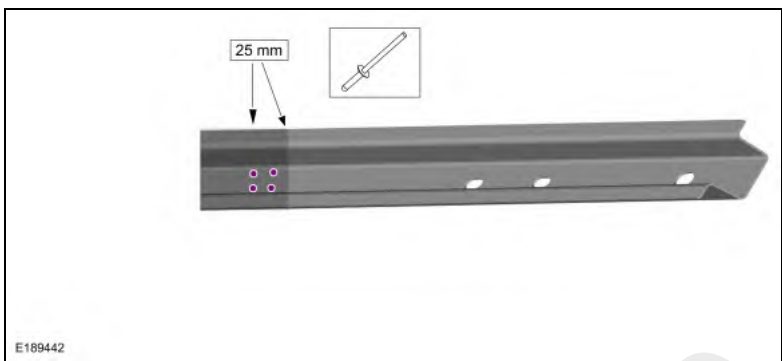


6. Install and clamp backing plate to existing component.



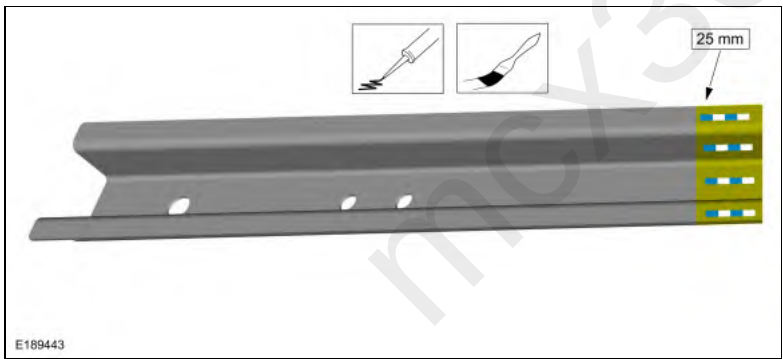
7. Install appropriate fasteners.

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



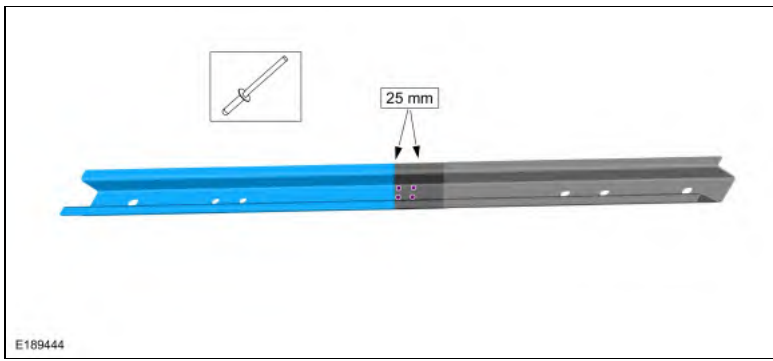
8. Apply adhesive to replacement component and evenly spread using a stiff bristle brush.

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



9. Install service component and appropriate fasteners.

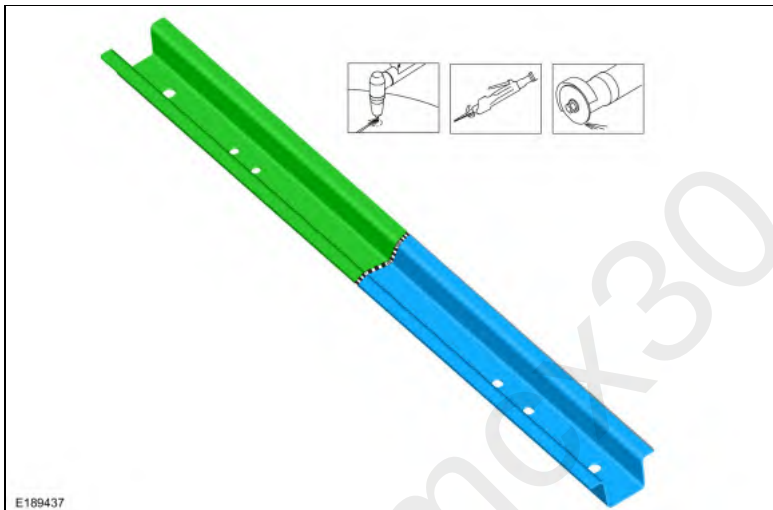
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).



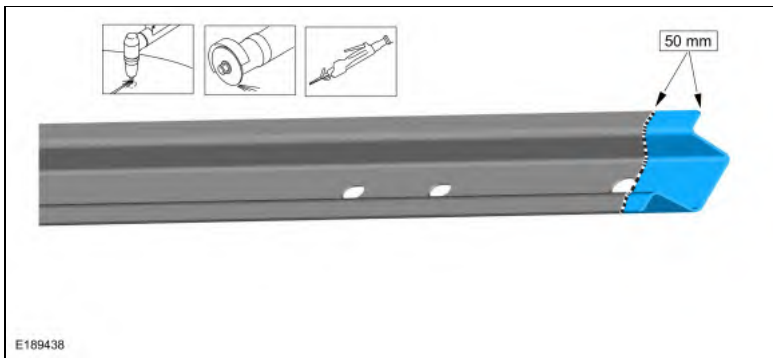
Repair

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

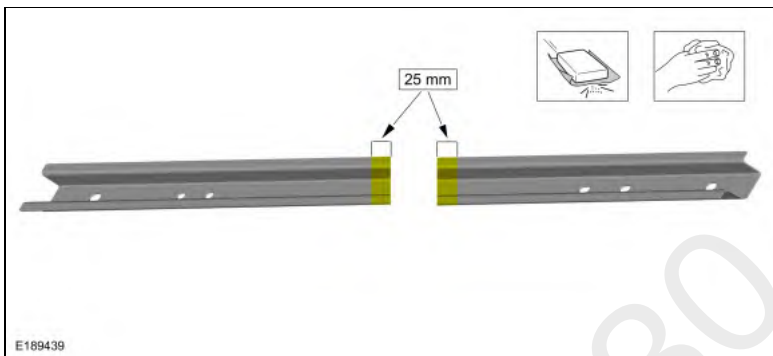


2. After removing the damaged sheet metal panel(s), repair any damaged flanges on the vehicle using a hammer and dolly.
3. Make a 50 mm wide backing plate from an unused portion of the old or new service part.
 Use the General Equipment: Air Body Saw
 Use the General Equipment: Spherical Cutter
 Use the General Equipment: Plasma Cutter

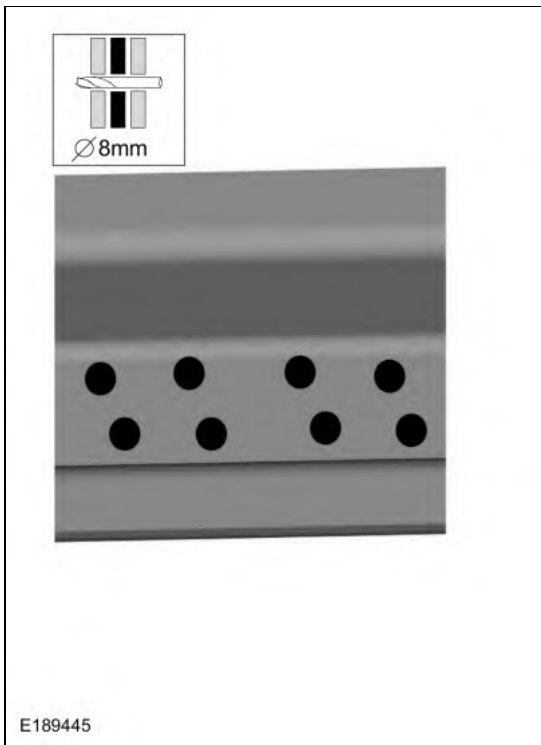


4. Measure and cut to fit the replacement service component.
5. **NOTE:** 80 to 125 grit sand papers are the recommended for best adhesion.

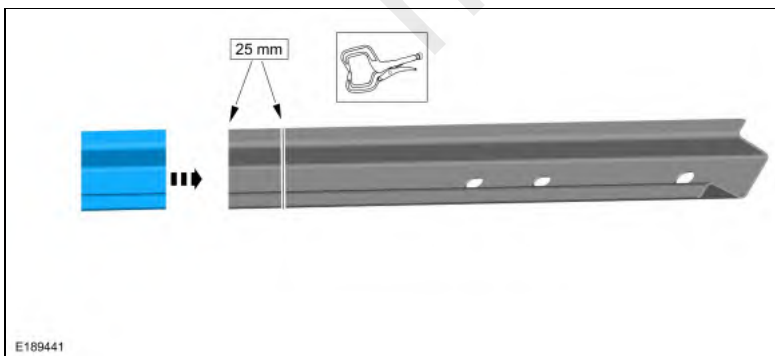
Remove old adhesive and e-coat from mating surfaces of the original component and the replacement part measuring 25 mm on each.



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



7. Install and clamp backing plate to existing component.



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

Plug weld as indicated.

Use the General Equipment: MIG/MAG Welding Equipment

