

**Review OEM procedures for recommended procedures.**

**Review Manufacturer's instructions for the application of adhesive (pay close attention to wet/work time).**



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- **Get necessary PPE needed for the repair**
- **Measure the thickness of both panels and calculate the correct blind rivet for the panels if the correct rivets are not specified in the repair procedures.**

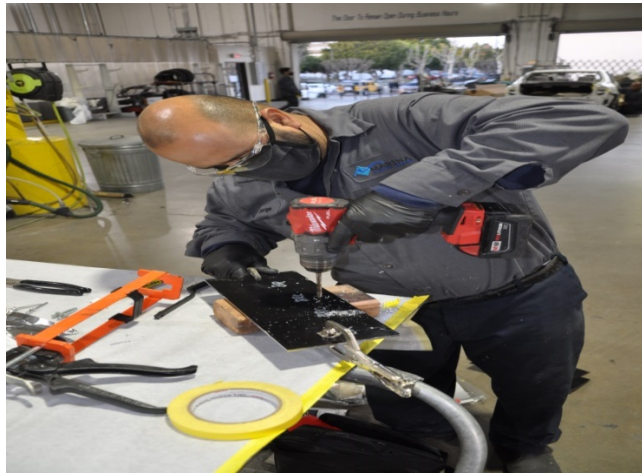


- **Mark the location of the rivets and types as per the OEM repair procedures.**

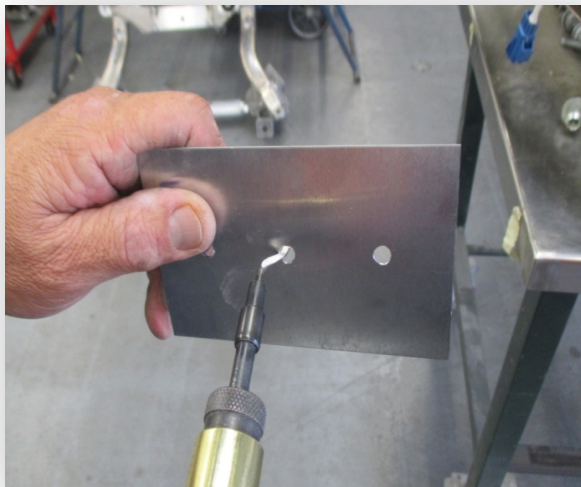
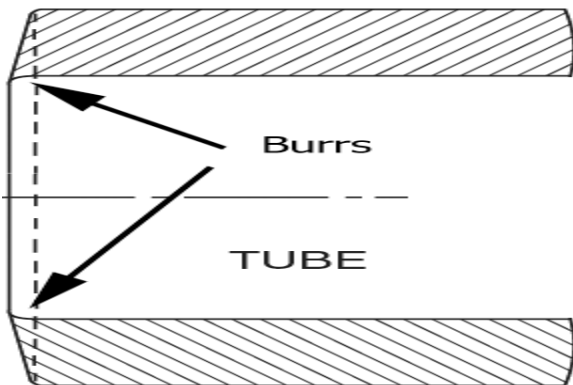


- **Drill holes using correct and recommended by the procedures. This installation called for a 6.5 MM drill.**





- **Deburr the holes (for the rivet to seat flush on the panel).**



- **Remove E-coat from matting surfaces with scotch-brite disc or DA sander (low speed) with 80 grit or finer. Follow OE recommendations for this process.**



- **Clean with a stainless steel brush (to prevent galvanic corrosion) followed by a good wax and grease remover or 99% alcohol.**



- **Read the label on the adhesive to determine the work time, clamp time and cure time. Note that the times are for 70 degrees fahrenheit. If temp is 90 degrees, work time will be half.**





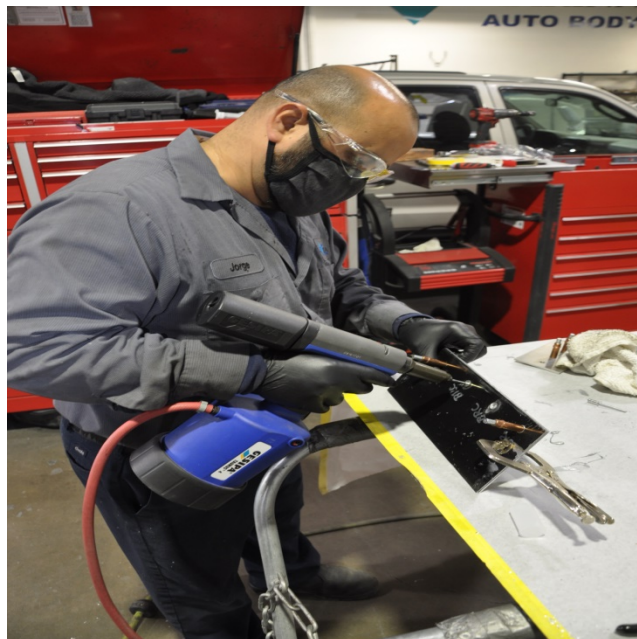
- **Prepare 2-part adhesive by equalizing the cartridge (make sure both products are coming out equally).**



- **Apply adhesive to both mating surfaces, spread, cover all bare metal and apply another bead for a proper bond line thickness.**



- **Use Clecos or blind rivets to align the panel and clamp. Check to make sure that the correct blind rivet will fit into all of the drilled holes in the panels.**
- **Set blind rivets with the recommended pressure for that particular rivet.**



- **Clean up excess adhesive on panel and tools.**