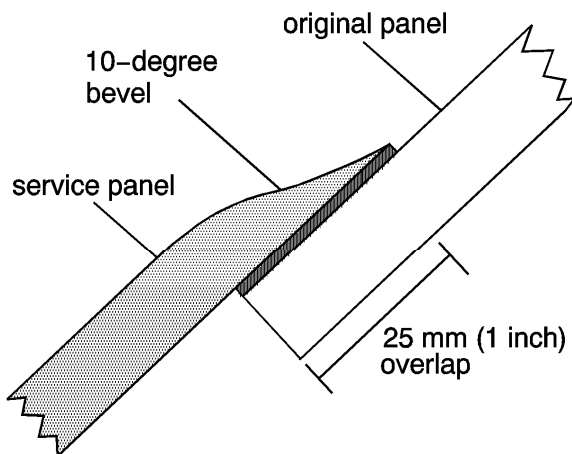


Overlap/Backing Plate Sectioning (Bonding/Overlap)



Important: Before starting the repair, refer to [Metal Panel Bonding](#) for proper adhesive applicator preparations and general information.

1. Fit the service panel to the vehicle to ensure a proper fit of a maximum 25 mm (1 in) overlap.
2. Grind a 25 mm (1 in) area of the outer surface on the vehicle panel to remove any corrosion, E-coat, primers, coatings and galvanizing that may be present.
3. At the section joint on the service panel, grind a 25 mm (1 in) area of the back side to remove any corrosion, E-coat, primers, coatings and galvanizing that may be present.
4. Bevel the service panel at the section edge to approximately 10 degrees.
5. Clean the mating surfaces.

Important: The adhesive has a 40-50 minute working time.

6. Apply a 3-6 mm (1/8-1/4 in) bead of metal panel bonding adhesive to both of the mating surfaces.
7. Using small acid brush, spread a coat of adhesive to cover all the bare metal surfaces to ensure corrosion protection.

Important: DO NOT pull the service panels apart after the panels have been joined together. Slide the panels against each other to realign the panels.

8. Apply a 9-13 mm (3/8-1/2 in) bead of metal panel bonding adhesive to the sectioning part mating surfaces.
9. Position the service panel to the body. Clamp the service panel into position.
10. Install the screws or clamp the overlap sectioning location.
11. Using lacquer thinner, remove the excess adhesive from the overlap section.
12. Allow the adhesive to cure. Remove the screws or clamps from the overlap section.
13. Remove any remaining adhesive where body filler will be applied.
14. Recess the screw holes with a punch and hammer as necessary.

Important: Always follow the system manufacturer's instructions for application, handling, and curing.

15. Apply a fiberglass-filled body filler for the overlap section and screw holes for the first coat.
16. Apply a lightweight body filler to the overlap section for the second coat.