

## Overlap/Backing Plate Sectioning (Bonding/Backer Plate)

**Caution:** Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

**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.
2. Fabricate a 50 mm (2 in) maximum backing plate at the sail panel.
3. Fabricate a 100 mm (4 in) backer plate at the rocker panel.
4. Bevel the roof and service panel edges at the sectioned area to approximately 10 degrees.
5. Grind a 25 mm (1 in) area of the outer surface on the vehicle to remove any corrosion, E-coat, primers, coatings and galvanizing that may be present.
6. At the section area 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.
7. Clean the mating surfaces.

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

8. Apply a 6.4-9.8 mm (1/4-3/8 in) bead of metal panel bonding adhesive to both of the mating surfaces.
9. 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 joined together. Slide the panels against each other to realign the panels.

10. Apply adhesive to the sail panel and rocker panel of the backer plates.
11. Use screws to install the backer plate to the roof.
12. Position the service panel to the vehicle. Clamp the panels together.
13. Use screws to install the backer plate to the service panel.
14. Allow the adhesive to cure. Remove the screws from the backer plate.
15. Remove any remaining adhesive where the body filler will be applied.

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

16. Apply a fiberglass-filled body filler for the backer plate area and screw holes for the first coat.
17. Apply a lightweight body filler to the backer plate area for the second coat.