

## Description and Operation

### Metal Panel Bonding

This is intended to provide general guidelines for adhesive bonding of exterior panels as an alternative to Metal-Inert Gas (MIG) welding. Panel bonding may be seen as an alternative to MIG welding to provide full panel replacement in regards to collision repair procedures. The benefits of panel bonding is:

- No heat or burn damage when additional welding is not required
- Corrosion protection
- Can act as a sealant
- Improved process for complicated shapes (wheelhouse area)

The General Motors specification for metal bonding adhesives is GM 6449G. The scope of this specification is intended to provide the performance guidelines of structural adhesive systems used to repair (metallic) automotive bodies in the aftermarket. These types of adhesives are intended for use when bonding replacement body panels as an option to welding as the attachment means. GM information outlines the use of room temperature cure acrylic adhesives that contain glass bead technology.

Bonding procedures in general are applicable only to a factory seams type approach.

Sectioning or partial paneling of full panels is not supported by General Motors unless specifically documented in a Service Bulletin or Manual.

Applicable components for this technology are EXTERIOR PANELS ONLY, including door skins, tail panels, roof outer panels and quarter panels.

**Important:** Do not use adhesives for vehicle underbody or upper body structure type repairs such as structural rails, shock/strut towers, floor pans, upper fender rails, body side pillars, door rings—side or rear, rocker panels, unless specifically documented in a GM Service Bulletin or Manual. If in doubt, use only the procedures referenced in the Service Manual for the specific vehicle being repaired.

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

Adhesives currently meeting the performance requirements include General Motors materials and products manufactured by Lord Adhesives. At this time, ONLY the adhesive products listed below meet this guideline:

GM Goodwrench®	GMSP0 of Canada	Lord Fusor	Product Type
12378567	88901675	108B/109B	Medium Set
12378566	88901674	110B/111B	Fast Set

Canadian applications may use U.S. part numbers. Refer to your GM Dealer Parts Department for the correct part number applications.