



## **Info - Metal Panel Bonding #02-08-98-001C - (10/09/2006)**

### **Subject:**

**Models: 2007 and Prior GM Passenger Cars and Trucks (Including Saturn)**

**2003-2007 HUMMER H2**

**2006-2007 HUMMER H3**

**2005-2007 Saab 9-7X**

**2007 and Prior Isuzu Medium Duty Commercial Trucks**

**Attention: This bulletin applies to all models that have published panel bonding procedures in SI.**

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**This bulletin is being revised to update the applicable models and add information. Please discard Corporate Bulletin Number 02-08-98-001B (Section 08 -- Body and Accessories).**

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This bulletin is intended to provide general information for adhesive bonding of Non-Structural exterior panels as an alternative to 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 include the following:

- 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 and provides test and standards information to adhesive manufacturers and suppliers. 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 Non-Structural replacement body panels as an option to welding as the attachment means. Supplier guidelines outline 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 NON-STRUCTURAL EXTERIOR PANELS ONLY, including door skins, tail panels, roof outer panels and quarter panels. While this bonding process has gained popularity, General Motors only supports this process for vehicles which it has published written repair procedures that are found in a Service Manual or Bulletin.

Adhesives currently meeting the performance requirements include General Motors materials, Lord Adhesives, Ashland Plio Grip, and products manufactured by 3M Corporation. At this time, ONLY the adhesive products listed below meet this guideline.

Service information is also available on the web.

- ([www.acdelcotechconnect.com](http://www.acdelcotechconnect.com)) -- This website includes service repair information for the total vehicle and is a subscription based site.
- ([www.techinfo.gmgoodwrench.com](http://www.techinfo.gmgoodwrench.com)) -- This website includes select collision repair information only and is downloadable and free to the user.

<b>Manufacturer and Part Number</b>	<b>Description</b>
GM P/N 12378566 (US)	Fast Set Bonding Adhesive
GM P/N 88901674 (Canada)	
Lord Fusor P/N 110B/111B	
GM P/N 12378567 (US)	Medium Set Panel Bonding Adhesive
GM P/N 88901675 (Canada)	
Lord Fusor P/N 108B/109B	
3M P/N 8116	Panel Bonding Adhesive
Ashland Plio Grip Panel 60	Panel Bonding Adhesive
The dispensing tool may be purchased locally. (Painters Supply Store)	

GM bulletins are intended for use by professional technicians, NOT a "do-it-yourselfer". They are written to inform these technicians of conditions that may occur on some vehicles, or to provide information that could assist in the proper service of a vehicle. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do a job properly and safely. If a condition is described, DO NOT assume that the bulletin applies to your vehicle, or that your vehicle will have that condition. See your GM dealer for information on whether your vehicle may benefit from the information.



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