

3M Science.
Applied to Life.™



**Trusted and
recommended
for over 20 years.**

3M™ Panel Bonding Adhesive

3M™ Panel Bonding Adhesive

38315 / 08115 / 08116 / 58115



Proven and trusted performance. Provides a continuous bond and seals weld and rivet bonded areas against corrosion.

Designed to meet specific strength requirements for outer sheet metal panel replacement; panel bonding adhesive is typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.

The above is a general description, repairers must always refer to individual automotive manufacturer procedures specific to model year for accurate information.



- Recommended by many OEMs
- Provides corrosion protection with lifetime warranty
- Room temperature curing (accelerated curing with heat)
- Can be weld bonded or rivet bonded within working time
- Adheres to a wide variety of properly prepared steel and aluminum substrates
- May be used on many plastic and composite substrates
- Glass bead technology protects against overclamping and maintains a minimum bond line thickness
- Has excellent shelf life opened or unopened, reducing unused product replacement costs

3M™ Panel Bonding Adhesive

Part No.	Size	Color	Chemistry	Work Time*	Clamp/ Handling Time*	Cure Time
08115	200mL					
38315	50mL	Black	Epoxy	90 min @ 70°F 45 min @ 90°F	4 hrs	24 hrs
58115	450mL DMS					
08116	200mL	Black	Epoxy	2 hrs @ 70°F 1 hr @ 90°F	6 hrs	24 hrs

*May be accelerated with heat.

Following OEM recommendations is very important for several reasons.

Help Ensure Safety: Meet the adhesive standards that have been set by the OEMs to manage crash energy and help protect occupants.

Use Trusted Products: Use products that have been rigorously tested to the OEM's performance requirements for strength and corrosion resistance.

Mitigate Risk: Help protect yourself and your business from potential liability — the vehicle was repaired as directed by the OEM.

Simplify Your Process: Eliminate confusion about which adhesive should be used and where. You're using the OEM recommended adhesive that is specifically called out for that procedure.

Get Reimbursed: OEM recommendations, which include 3M products, enable you to provide documentation to justify correct product usage and procedures needed for safe and responsible repairs.

OEM Recommendations

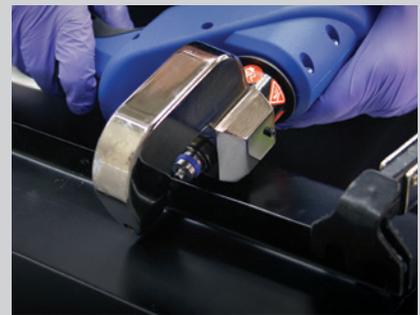
- 3M™ Panel Bonding Adhesive
- 3M™ Impact Resistant Structural Adhesive

Part No.	Fiat/ Chrysler	Ford	General Motors	Honda	Hyundai/ Kia	Jaguar/ Land Rover	Tesla	Toyota	Volvo
08115		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>	
08116	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>						<input checked="" type="checkbox"/>
07333			<input checked="" type="checkbox"/>						

Please reference OEM Repair Procedures: Collision repair shops should follow OEM recommendations. Always reference the OEM repair procedure to make sure the correct adhesive is being selected for that repair.



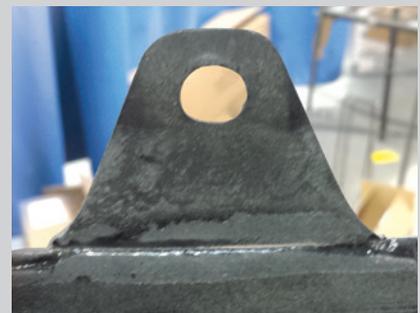
3M™ Panel Bonding Adhesive can be welded through within working time using squeeze-type resistance spot welding to form a weld bonded joint.



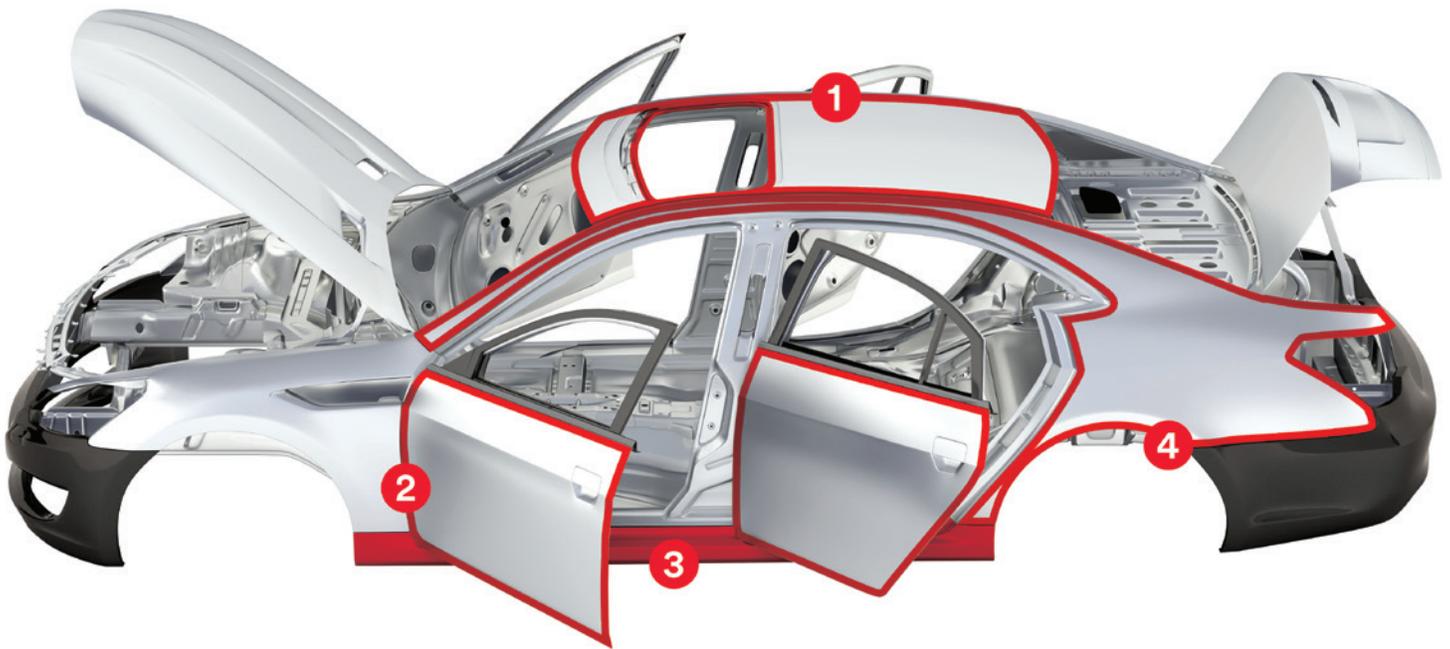
Recommended in OEM procedures for rivet bonding operations.



May be used for bonding door skins, quarter panels, roof skins, box sides, van/utility vehicle sides and rocker panels when recommended by OEMs.



Can be used for bumper cover, composite and plastic repair when recommended by OEMs.



Quick Reference: Areas where 3M™ Panel Bonding Adhesive may be used.

- 1** Roof Skin **2** Door Skin **3** Rocker Panel **4** Quarter Panel/Truck Box/Van Side

Please reference OEM Repair Procedures.

Ordering Information

3M™ Panel Bonding Adhesive			
Part No.	Size	Product	Case Qty.
08115	200mL	3M™ Panel Bonding Adhesive	6/Case
38315	50mL	3M™ Panel Bonding Adhesive	6/Case
58115	450mL DMS	3M™ Panel Bonding Adhesive	4/Case
08116	200mL	3M™ Panel Bonding Adhesive	6/Case

Accessories		
Part No.	Size	Features/Applications
38191	50mL	3M™ Static Mixing Nozzle
38193	50mL	3M™ Static Mixing Nozzle: Bulk pack (50)
08193	200mL, 400mL	3M™ Static Mixing Nozzle: 3/8 in. nozzle
08194	200mL, 400mL	3M™ Static Mixing Nozzle: 3/8 in. nozzle, Bulk pack (50)
09930	200mL	3M™ Performance Pneumatic Applicator: Pneumatic — For 200mL product
08117	200mL	3M™ Performance Manual Applicator: Manual — For 200mL product
08190	50mL	3M™ Performance Manual Applicator: Manual — For 50mL product
08571	200mL	3M™ Standard Manual Applicator: Economy Line Applicator with heavy duty construction
55847	2:1, 1:1	3M™ Dynamic Mixing Nozzles: DMS nozzle for adhesives, sealers and plastic repair products
58207	50:1, 2:1, 1:1	3M™ Dynamic Mixing Nozzle Extension: Use with DMS nozzles to provide a thinner bead and to get into hard to reach areas
05846	All DMS Products	3M™ Dynamic Mixing Applicator: Pneumatic — Professional applicator to dispense DMS products

For more information, visit:
3MCollision.com/PBA



/3MCollision



/3MCollision



/3M_Collision



/3MAutobodyRepair



3M Corporate Headquarters
3M Center, St. Paul, MN 55144 USA

Phone 1-877-666-2277
Web 3MCollision.com

3M is a trademark of 3M Company.
© 3M 2019. All rights reserved.
60-4402-7907-7 Rev. 01/2019

Warranty and Limited Remedy: 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER EXPRESS OR IMPLIED WARRANTIES OR CONDITIONS, INCLUDING ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. If a 3M product does not conform to this warranty, the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential, regardless of the legal or equitable theory asserted.

For health and safety information please refer to product labels and Safety Data Sheets.