



Metal Panel Bonding (Steel)

Table 1: [Steel Panel Bonding Impact Resistant](#)

Table 2: [Steel Panel Bonding](#)

This information is intended to provide general guidelines for adhesive bonding of steel panels. Panel bonding of steel is only recommended when the panel is originally bonded to the vehicle.

The adhesives listed in this document are known to meet the General Motors specifications and requirements for bonding of steel body panels.

Bonding procedures in general are applicable only at factory joints.

The use of adhesive to section steel panels is not recommended by General Motors.

Rivets, or other mechanical fasteners, may be used in combination with adhesive bonding of steel panels. The specified rivets, or fasteners, should be used with adhesive, when replacing the original panel.

Two types of adhesives are listed here. Impact Resistant Adhesive is used in joints in frame rail assemblies and strut tower assemblies and other body structure joints that have critical strength requirements. The factory applied Impact Resistant Adhesive is purple in color when cured. The other bonding adhesives are non-impact resistant, offer a lower strength rating and can be used in all other joints that are not originally made with Impact Resistant Adhesive.

Note: Always follow the adhesive manufacturer's instructions for application, handling, and curing for the specific product.

Adhesives currently meeting the performance requirements include the adhesive products listed below meet these guidelines:

Steel Panel Bonding: Impact Resistant	
Manufacturer and Part Number	Description
Fusor 2098	Fusor 2098 Crash Durable Adhesive Available from Lord Fusor www.fusor.com
3M PN07333	3M™ Impact Resistant Structural Adhesive Available from 3M www.3MCollision.com

Steel Panel Bonding: Non-Impact Resistant	
Manufacturer and Part Number	Description
GM P/N 12378566 (US) GM P/N 88901674 (Canada) Lord Fusor P/N 110B/111B	Fast Set Panel Bonding Adhesive
GM P/N 12378567 (US) GM P/N 88901675 (Canada) Lord Fusor P/N 108B/109B	Medium Set Panel Bonding Adhesive
3M PN08116	3M™ Panel Bonding Adhesive
Ashland Plio-Grip Panel 60	Panel Bonding Adhesive