



Mack Chassis - Model MRU - Inner and Outer Door Panel Repair Procedure; Outer Door Surface Separating From The Inner Door Surface



> Internal Content





Refer to the steps below for the inner and outer door panel repair procedure.

Surface Preparation

1. Wash the surfaces with soap and water to remove water soluble contaminants.
Follow the soap and water wash with an appropriate VOC Compliant cleaning product for removal of other surface contaminants.
2. Remove all rust, primer and paint from the areas to be bonded using a Clean & Strip Disc or a Grade 50 Grinding Disc.
3. Straighten all metal and "dry-fit" the parts.
4. Clamp the part in place and check for fit and alignment.
5. Remove the panel from the vehicle.

Product Preparation

6. Place an adhesive cartridge in the applicator gun.
7. Remove the retaining collar and plug from the end of the cartridge.
Discard plug, but save the retaining collar.
8. Before attaching a nozzle, "equalize" the cartridge by dispensing just enough product to be sure that both parts A and B are present at the outlet.
9. Attach a 3M™ Static Mixing Nozzle to the cartridge and lock in place with the retaining collar.
10. Dispense a small amount of material through the mixing nozzle onto a disposable surface and discard.

 Live UI

repair Process

11. Apply an adhesive bead to all bare metal surfaces of both pieces to be bonded. Using a plastic spreader.

12. Apply a 1/8" diameter adhesive bead approximately 1/4" from the inside edge of the replacement panel.

Door Skins: Adhesive should be applied to the hem flange area. To replace the factory-applied NVH foam/spacer between the intrusion beam/s and the door skin, use one of the following: 3M™ Urethane Seam Sealer (PN 08360, PN08361 or PN 08364), 3M™ MSP Seam Sealer (PN 08369 or PN 08370), or 3M™ NVH Dampening Material (PN 04274) to the intrusion beam/s as needed.

13. Clamp the panel in its proper position.

14. Tool any adhesive "squeeze out" to seal the outside of the seam all along the bonded edge of the panel.

Caution: The adhesive is combustible. Keep any MIG welding a minimum of two inches from the adhesive. As with any welding operation, keep the appropriate fire extinguisher within reach, and be alert to any smoke or flame that may be present. Resistance spot welding through uncured adhesive is acceptable.

15. Clamps may be removed after four hours at 73°F. Parts will need to remain clamped longer if the temperature is below 73°F and/or if there is any tension on the part. The cure time may be accelerated by applying heat with a heat gun or lamps.

16. Allow 24 hours at a minimum of 73°F before returning vehicle to service.

Clean - Up

Prior to curing, 3M™ PN 08115 may be cleaned from most surfaces using water or with an appropriate VOC Compliant 3M™ cleaning product. Reference the 3M™ Automotive Aftermarket Catalog for a suitable product.

Warranty

- Use labor code [8311-03-02-18 shell, Cab single door](#).
- Use the part number for the door repaired as the causal part.

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