



### Aluminum Panel Bonding

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

Table 2: [Aluminum Panel Bonding Non Impact Resistant](#)

This information is intended to provide general guidelines for adhesive bonding of aluminum panels. Panel bonding of aluminum 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 aluminum body panels.

Bonding procedures in general are applicable only at factory joints.

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

Rivets, or other mechanical fasteners, may be used in combination with adhesive bonding of aluminum 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 Impact Resistant adhesives available for servicing these joints are considerably stronger once cured than panel bonding adhesives. 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adhesives are non-impact resistant, offer a lower strength rating and can be used in all other joints that are not originally made with Impact Resistant Adhesive .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:

#### Aluminum Panel Bonding Impact Resistant

<b>Manufacturer and Part Number</b>	<b>Description</b>
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Fusor 2098	Fusor 2098 Impact Resistant Adhesive
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	Available from Lord Fusor 800-234-3876
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www.fusor.com

Aluminum Panel Bonding Impact Resistant

**Manufacturer and Part Number**

**Description**

3M 07333

3M Impact Resistant Structural Adhesive

Available from 3M

[www.3MCollision.com](http://www.3MCollision.com)

Pliogrip 5770P Structural Impact Durable Adhesive

Pliogrip 5770P

Available from Ashland 800-PLIOGRIP

[www.ashland.com/products/pliogrip-structural-adhesives](http://www.ashland.com/products/pliogrip-structural-adhesives)

Aluminum 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

GM P/N 12378567 (US)

GM P/N 88901675 (Canada)

Lord Fusor P/N 108B/109B

3M P/N 8116

Ashland Plio Grip Panel 60

Fast Set Panel Bonding Adhesive

Medium Set Panel Bonding Adhesive

Panel Bonding Adhesive

Panel Bonding Adhesive