



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 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adhesives are non-impact resistant, offer a lower strength rating and can be used in all other joints that are not originally made with Impact Resistant Adhesive.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:

Steel Panel Bonding Impact Resistant

**Manufacturer and Part Number**

**Description**

Pliogrip 5770P

Pliogrip 5770P Structural Impact Durable Adhesive

Available from Ashland 800-PLIOGRIP

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

Steel Panel Bonding Impact Resistant

**Manufacturer and Part Number**

**Description**

Fusor 2098

Fusor 2098 Impact Resistant Adhesive

Available from Lord Fusor 800-234-3876

[www.fusor.com](http://www.fusor.com)

3M Impact Resistant Structural Adhesive

3M 07333

Available from 3M

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

Steel Panel Bonding

**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

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