

Sheet Molded Compound (SMC) Panel Bonding

This is intended to provide general guidelines for sheet molded compound (SMC) and carbon fiber adhesive bonding of full panel replacement in regards to collision repair procedures.

Sectioning, partial panel of full panels, is not supported by General Motors unless specifically documented in a Service Bulletin or Manual.

Important:

- Prepare the surfaces to be bonded according to adhesive manufacturer's recommendations. Many adhesive manufacturers have different preparation methods. Do not intermix adhesive manufacturers systems. Mixing materials from different manufacturers can produce unsatisfactory results.
- DO NOT top coat any adhesive bonding mating surface. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations for priming applications.

Adhesives currently meeting the performance requirements include General Motors materials and products manufactured by Ashland and Lord Fusor. At this time, ONLY the adhesive products listed below meet this guideline:

GM Goodwrench®	GMSPPO of Canada	Ashland Pliogrip Structural Adhesives Crest Industries, Inc. 1-800-822-4100	Lord Fusor Structural Adhesive	Product Type
89020330	8902332	7770B	127 EZ	Medium Set
N/A	N/A	7779B	N/A	Fast Set

Canadian applications may use U.S. part numbers. Refer to your GM Dealer Parts Department for the correct part number applications.