

# 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.

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

2000-2018 Chevrolet Corvette Collision Repair Manual



## Metal 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 <a href="http://www.ashland.com/products/pliogrip-structural-adhesives">www.ashland.com/products/pliogrip-structural-adhesives</a>
Fusor 2098	Fusor 2098 Impact Resistant Adhesive Available from Lord Fusor 800-234-3876 <a href="http://www.fusor.com">www.fusor.com</a>
3M 07333	3M Impact Resistant Structural Adhesive Available from 3M <a href="http://www.3MCollision.com">www.3MCollision.com</a>

### Steel Panel Bonding

Manufacturer and Part Number	Description
GM P/N 12378566 (US)	Fast Set Panel Bonding Adhesive
GM P/N 88901674 (Canada)	
Lord Fusor P/N 110B/111B	
GM P/N 12378567 (US)	Medium Set Panel Bonding Adhesive
GM P/N 88901675 (Canada)	
Lord Fusor P/N 108B/109B	
3M P/N 8116	Panel Bonding Adhesive
Ashland Plio Grip Panel 60 ©2015 General Motors. All rights reserved.	Panel Bonding Adhesive

## PLIOGRIP® OEM ADHESIVE APPLICATIONS

### Automotive

PLIOGRIP® is the preferred adhesive for the Automotive manufacturers listed below and has been used in applications, including but not limited to...

<b>Fender</b> <b>Hood</b> <b>Removable Hardtop</b> <b>Deck Lid</b> <b>Spoiler</b> <b>Window Clip</b> <b>Valve-Cover Assembly</b>	<b>Bumper</b> <b>Lift Gate</b> <b>Grill</b> <b>Tail Gate</b> <b>Roof</b> <b>Roof Hatch</b> <b>Quarter Panels</b>
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#### GENERAL MOTORS COMPANY – US Brands

PROGRAM	MODEL YEAR(S)
<b>Pontiac Fiero</b>	<b>1984-1987</b>
<b>GM 200 Vans (GM Lumina, Pontiac Transam, Olds Silhouette)</b>	<b>1988-1993</b>
<b>Chevrolet Camaro CFIV</b>	<b>1994-2002</b>
<b>Pontiac Firebird CFIV</b>	<b>1994-2002</b>
<b>Chevrolet Corvette C1 – C4</b>	<b>1984-2004</b>
<b>Military (H1) Hummer (Original: AMGeneral)</b>	<b>1983-2004</b>
<b>H2 Hummer SUV</b>	<b>2002-2004</b>
<b>Pick-Up/Utility Trucks</b>	
<b>GMT 530 Med. Duty Truck</b>	<b>1993-2003</b>
<b>Buick Rendezvous Van</b>	<b>2002-2004</b>
<b>Buick Ranier</b>	<b>2004</b>
<b>GMT 802 C/K Chevrolet Avalanche Truck</b>	<b>2003-2004</b>
<b>Cadillac Escalade SUV</b>	<b>2003-2004</b>
<b>Cadillac XLR Roadster</b>	<b>2004</b>

#### GENERAL MOTORS COMPANY – Opel

PROGRAM	MODEL YEAR(S)
<b>Frontera</b>	
<b>Vectra GTS</b>	

## PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS

### Automotive

#### FORD MOTOR COMPANY – US BRANDS

PROGRAM	MODEL YEAR(S)
Mustang	2000-2004
Ranger Truck/Explorer SUV)	1995-2001
Excursion SUV	2000-2004
F-150 Truck	2000-2003
Windstar Van	1996-1998
Bronco Truck	1978-1992
Thunderbird	2001-2004
Bronco II Truck	1984-1994
Lincoln Continental	1996-2000
Aerostar Van	1986-1994

#### FORD MOTOR – Premium Automotive Group, Volvo Car

PROGRAM	MODEL YEAR(S)
V70	2000-2004
XC90	2004
Street Ka	2004

#### FORD MOTOR- Premium Automotive Group, Aston Martin

PROGRAM	MODEL YEAR(S)
V12 Vanquish	2002-2004

#### Daimler-Chrysler – Chrysler US Brands

PROGRAM	MODEL YEAR(S)
Dodge Viper	1995-2004
Jeep Wrangler	1982-2004
Jeep Liberty	2003-2004
Jeep Cherokee	1984-1998
Dodge Stratus	2003-2004
Dodge Neon	2003-2004
Prowler	2000-2001
PT Cruiser	2000-2004
Dodge DR Ram	2004



## PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS

### Automotive

#### Daimler-Chrysler – Mercedes Benz

PROGRAM	MODEL YEAR(S)
SLR230	2000-2004

#### Daimler-Chrysler - MCC Group

PROGRAM	MODEL YEAR(S)
Smart Roadster	2005 Prototype

#### BMW

PROGRAM	MODEL YEAR(S)
Z3	1997-2003
Z4	2004
M3 CSL	2002-2004
Z8	2003-2004
3 Series Touring	2002
5 Series Touring	2004
X3 SUV	
X5 SUV	2003-2004

#### VOLKSWAGEN --Audi Group

PROGRAM	MODEL YEAR(S)
A4	2002-2004
A2	2004

#### VOLKSWAGEN

PROGRAM	MODEL YEAR(S)
Lupo GTI	2001-2004
Polo GTI	2001-2004
Tuareg SUV	2004

#### PORSCHE

PROGRAM	MODEL YEAR(S)
Cayenne SUV	2003-2004

<b>911 GT2</b>	<b>2004</b>
<b>Carrera 4S</b>	<b>2004</b>

**PLIOGRIP® OEM ADHESIVE APPLICATIONS**  
**Automotive**

**FERRARI**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>F355</b>	<b>2000</b>
<b>F360 Modena</b>	<b>2002</b>
<b>F360 Evo</b>	<b>2004</b>

**ALFA ROMEO**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>146</b>	
<b>156</b>	
<b>GTV Spider</b>	<b>1999-2004</b>

**MASERATI**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>GT3200</b>	

**RENAULT**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Clio V6</b>	

**PEUGEOT**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>807</b>	
<b>306</b>	

**CITREON**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>C8</b>	

**FIAT**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Ulyssee</b>	

<b>Multipla</b>	
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**PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS**  
**Automotive**

**LANCIA**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Phedra</b>	

**MGF**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Spider</b>	<b>2002-2004</b>

## PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS HEAVY TRUCK

PLIOGRIP<sup>®</sup> is also the preferred adhesive for the Heavy Truck manufacturers listed below and has been used in applications, including but not limited to...

**Structural Assembly of Cab**  
Hood  
Storage Doors  
Door Panel

**Front Grill**  
Roof  
Fenders  
High Roof

### PACCAR – KENWORTH

PROGRAM	MODEL YEAR(S)
T2000	1998-2004
T600/T800	1994-2004
T603	1996-2004
GENERAL	1994-2004

### PACCAR – PETERBILT

PROGRAM	MODEL YEAR(S)
Model 387	2000-2004
Model P2100	2001-2004
Model 357	1993-2004

### PACCAR- DAF

PROGRAM	MODEL YEAR(S)
XF95	2002-2004

### PACCAR-ERF

PROGRAM	MODEL YEAR(S)
Various	2002-2004

## PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS HEAVY TRUCK

### Daimler-Chrysler: Commercial Vehicles, FREIGHTLINER Corp

PROGRAM	MODEL YEAR(S)
Century P2	1998-2004
Columbia	2001-2004
Business, M	2002-2004
Coronado	2002-2004
Classic/Classic XL	2002-2004
FLD	1990-2004

### FREIGHTLINER - STERLING (formerly Ford Motor Heavy Truck)

PROGRAM	MODEL YEAR(S)
HN-80	1994-2004
PHN-177	1998-2004
PHN-180	2000-2004

### NAVISTAR / International

PROGRAM	MODEL YEAR(S)
8100	
8200	
9200/9400	
Low Pro	
ProSleeper	
3000 IC bus	
Proline	
4000 series	

### VOLVO TRUCK

PROGRAM	MODEL YEAR(S)
VN L-4 & L-5 (US)	1997-2004
Model 2287 (US)	2002-2004
WG	1992-1999
Prevost Bus (Canada)	
GENERAL (US)	
FH (Europe)	



**PLIOGRIP<sup>®</sup> OEM ADHESIVE APPLICATIONS  
HEAVY TRUCK****VOLVO TRUCK--MACK Group**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Ultraliner</b>	<b>1986-1988</b>
<b>W, MD, CL</b>	<b>1988-1998</b>
<b>CH</b>	<b>1997-2004</b>
<b>Vision</b>	<b>2004</b>

**SCANIA**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Various</b>	<b>1990's+</b>

**FIAT --IVECO Truck**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Eurostar</b>	
<b>Stralis</b>	<b>2003</b>

**Case New Holland**

<b>PROGRAM</b>	<b>MODEL YEAR(S)</b>
<b>Tractor JXU</b>	<b>2004</b>