

Aluminum Repair Procedures

Body Repair

Aluminum Part Replacement

1



Pre-Cleaning

Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

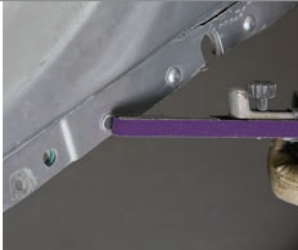
2



Sealer/Coating Removal

Use Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.

3



Rivet/Spot Weld Removal

Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. **Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.**

4



Panel Separation

Separate exterior panel from the host panel. **DO NOT force separation in areas where the weld isn't completely removed, go back to step 3 and finish weld removal before continuing.**

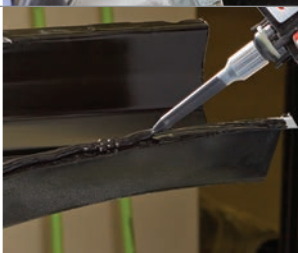
5



Surface Preparation

Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean N Strip Disc.

6



Panel Installation

Follow OEM recommendations where applicable. Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc.

Visit www.3MCollision.com for more SOPs and videos

Product List

3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377



3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350



Scotch-Brite™ Roloc™ + Clean N Strip, XT Disc, PN 07470



Scotch-Brite™ Roloc™ + Clean N Strip TR Disc, PN 07466



3M™ File Belt Sander, PN 28366



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



3M™ Cubitron™ II File Belt, grade 80+, PN 33446



3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



Note: Use caution when working on aluminum parts. Use tools that have been cleaned properly or designated for use on aluminum to reduce potential cross contamination. Do not re-use abrasives that were previously used on steel repairs.



Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at www.3MCollision.com

For product material safety data sheets see www.3MCollision.com

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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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