

Aluminum Repair Procedures

Aluminum Frequently Asked Questions

Questions and Answers

1	Do I need special sandpaper? No. You don't need special sandpaper, but you do need dedicated sandpaper to avoid cross-contamination between steel and aluminum surfaces. Commonly accepted repair practices for steel repairs will translate to aluminum specific repairs. Traditional 3M Abrasives are well suited for aluminum repairs, but abrasives and tools previously used on steel must be kept away from aluminum repair areas and vice versa.
2	What adhesives do we use? Commonly accepted repair practices and products for steel repairs will translate to aluminum specific repairs. 3M Adhesives will work on aluminum, but it's always a good idea to follow OEM repair recommendations for preferred products and processes.
3	What seam sealers are best? Commonly accepted repair practices and products for steel repairs will translate to aluminum specific repairs.
4	Are the 3M body fillers and glazes going to stick? Yes. 3M premium body fillers and glazes are applicable to aluminum repairs.
5	Do I need to take special care to help maintain proper air quality within the work area? Yes. Follow all OSHA guidelines and use approved vacuum system for your specific requirements when repairing aluminum.
6	How long can bare aluminum be exposed before corrosion begins? Oxidation will begin once aluminum is exposed to atmosphere. Oxidation should be removed throughout the repair by re-abrading and cleaning the surface after each hour of exposure.
7	Do 3M panel bonding adhesives still retain lifetime warranties with aluminum? Yes, provided all proper procedures are followed.
8	Do I need special air tools? It is highly recommended to use separate air tools dedicated to aluminum repairs OR tools that have been thoroughly cleaned with compressed air to remove any steel particles. Use caution not to cross contaminate work surfaces.
9	Do I need special tools or clamps? Yes. Use separate hand tools designed for aluminum repairs (e.g., hammers, dolleys, clamps, files, drill bits, saw blades, etc.). These tools are usually either non-metallic, or have a highly polished surface to ensure that steel particles will not transfer while being used.
10	What aluminum welder do you recommend? Welder technology has improved greatly in the last few years for aluminum. There are many great models, but it's best that you explore models that meet OEM recommendations for the types of vehicles that you work on.
11	Can 3M coatings be applied direct to aluminum (e.g., 3M™ No Cleanup Rocker Gard™ Coating, undercoating, etc.)? Commonly accepted repair practices and products for steel repairs will translate to aluminum specific repairs. Direct to metal coatings may be applied as such.
12	Can I use the same piece of abrasive on steel and aluminum substrates? No. It is very important to use a new piece of abrasive and thoroughly clean tools or use separate tools when going between work surfaces to avoid cross contamination of work surfaces. Contamination of one substrate from another causes galvanic corrosion and will eventually lead to paint failure.

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



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

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

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.



3M Automotive Aftermarket Division

3M Center
Building 223-6N-01
St. Paul, MN 55144-1000
U.S.A.
www.3MCollision.com

Please recycle. Printed in U.S.A.
© 3M 2015. All rights reserved.
(Rev 9/2015)

3M, Accuspray, Body Schutz, Cubitron, E-A-R, Hookit, Lexa, Platinum, PPS, Rocker Gard, Roloc, Scotch, Scotchblok, ScotchBlue, Scotch-Brite, Skull Screws and Trizact are trademarks of 3M Company