

Aluminum Repair Procedures

Body Repair

Aluminum Metal Working

1



Pre-Cleaning

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

2



Surface Prep

Use a Scotch-Brite™ Roloc™ + Clean N Strip Disc or a Scotch-Brite™ Belt to remove paint/coating in low points of damage in preparation for dent pulling.

3



Dent Pulling

Pull low spots of dent using preferred dent pulling method and equipment. Pulling equipment that allows continued pulling pressure while heating may be necessary to avoid stretching or cracking the aluminum. First in, last out and hammer-off-dolly technique is suggested.

4



Final Prep

Use a grade 80 3M™ Roloc™ Disc to remove remaining studs from dent pulling operation. **Caution: Avoid thinning the aluminum.**

5



Clean and Inspect

Clean with 3M™ All Purpose Cleaner and Degreaser Concentrate. Blow off with clean, dry air. Inspect damage area to determine if additional metal straightening is required before applying body fillers.

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 Fibre Roloc™ Disc, grade 80+, 3 in., PN 33392



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: It will be necessary to apply cavity wax to back side of panel at heat affected areas to restore corrosion protection.

Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

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 go.3M.com/SDS

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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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