




Aluminum Repair Procedures

Sealing and Coating

Anti Chip Coating

1		<p>Pre-Cleaning Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p>Removal of Heavy Surface Contaminates Clean to remove heavy contaminants from repair area.</p>
3		<p>OEM Coating Removal Remove OEM coating as needed using Clean N Strip disc. Featheredge using grade 80 abrasive on DA sander. Blow off surface with clean, dry air. Clean surface with all purpose cleaner and degreaser.</p>
4		<p>Filling/Leveling Surface Use polyester glaze to fill the repair area, bringing it the same level as the surrounding coating.</p>
5		<p>Sanding and Primer Sand glaze using P150 on a hand block. Final featheredge area using P320 abrasive on a DA sander. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover. Apply primer following paint company recommendations.</p>
6		<p>Sanding Primer Apply 3M guide coat to primed surface. Sand primer using P320 on a DA sander with an interface pad. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover.</p>
7		<p>Masking Apply soft edge foam masking tape following existing coating edge. Final mask the area using tape and paper to protect from overspray.</p>
8		<p>Coating Test Panel Apply the coating to a test panel. Always apply a light coat first, allow it to flash, and adjust the spray equipment to deliver the texture required to match the OEM appearance.</p>
9		<p>Apply Coating Apply anti chip coating to the repair area using settings from test panel, blending the material into surrounding area as needed.</p>
10		<p>Blend Sanding Use P1000 3M Trizact™ Disc on a DA sander to smooth the blend edges. This operation produces a smooth transition without removing chip coating profile.</p>

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

3M™ General Purpose Adhesive Cleaner, aerosol, PN 08987; Adhesive Remover, PN 38983

Scotch-Brite™ Roloc™ + Clean N Strip XT Disc, PN 07470; TR Disc, PN 07466

3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 80+ grade, PN 31371

3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180; Glaze for DMS, PN 05862

3M™ Hookit™ Purple Clean Sanding Sheet Roll, 150 grade, 70mm x 12m, PN 30710; Disc 334U, 6 in., P320 grit, PN 01812

3M™ Hookit™ Sanding Block Dust Free, 70mm x 127mm, PN 05207

3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861

3M™ Hookit™ Soft Interface Pad, 6 in. x 1/2 in. x 3/4 in., PN 05777

3M™ Soft Edge Foam Masking Tape PLUS, 21mm (.8 in.), PN 06293

3M™ Smooth Transition Tape, 1/4 in. (6.4mm), PN 06800

3M™ Scotchblok™ Masking Paper, 18 in. x 180 ft., PN 06738

Scotch® Performance Green Masking Tape 233+, 12mm width (.47 in.), PN 26332

3M™ Rocker Protector Pouch, 3 fl. oz. (US), PN 08733; 5.5 fl. oz. (US), PN 08734

3M™ Paintable Undercoating, — Waterbased — Pouch, 5.5 fl. oz. (US), PN 08744

3M™ Trizact™ Hookit™ Blending Disc, 6 in., P1000 grit, PN 02090

Think About Your Health

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

3M™ Respirator Assembly/Organic Vapor N95 Dual Cartridge, PN 07192

3M™ Lexa™ Protective Eyewear, PN 15200



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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