

Aluminum Repair Procedures

Body Repair

Door Skin Removal

1



Pre-Cleaning

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

2



Parts Removal

Remove associated trim and parts. Use molding removal tool to remove and save side moldings and emblems.

3



Hem Flange Grinding

Use grade 60 fiber backed abrasive disc to grind outer edge and separate door skin from door frame.

4



Hem Flange Spot Weld Removal

Use grade 36 file belt to remove any spot welds attaching hem flange to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.** Separate hem flange material from backside of door.

5



Door Skin Spot Weld Removal

Use grade 36 file belt to remove any spot welds attaching door skin to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.**

6



Door Skin Removal

Separate door skin from door frame. Use a putty knife to help separate skin from adhesive and NVH material on intrusion beam. Heat may be used when required for softening. (Maintain original NVH material whenever possible.)

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™ Side Molding and Emblem Removal Tool, PN 08978



3M™ Disc Sander, PN 28408

3M™ Cubitron™ II Abrasive Fibre Disc, grade 60+, 5 in., PN 33415



3M™ File Belt Sander, PN 28366



3M™ Cubitron™ II File Belt, grade 36+, PN 33443



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



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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