## Standard Operating Procedures

### Weld Sealing

**Host Panel Preparation**
Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.

**Mating Flange Panel Preparation**
Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.

**Clean**
Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.

**Dry Fit Panel**
Dry fit replacement panel and complete any necessary metal straightening at flanges areas.

**Weld-Thru Primer**
Use Scotch-Brite™ belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. **Caution: Do not use Weld-Thru Primer in adhesive bonding areas.**

**Spot Weld Surface Preparation**
Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.

**Pre-Assembly NVH Replacement**
If vehicle construction necessitates, apply NVH material or foams at original locations as required.

**Apply Seam Sealer**
Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.

**Install Replacement Panel**
Install replacement panel to host panel. Clamp in place.

**Spot Weld**
Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.

**Sealer Clean Up**
Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. **Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.**

**Post-Assembly Foam Replacement**
Apply foams at original locations as required.

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### Product List

- **3M™ File Belt Sander**, 18 in., PN 33575
- **3M™ Cubitron™ II File Belt**, grade 80+, PN 33446
- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
- Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552
- Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555
- **3M™ Weld-Thru Coating II**, PN 05917
- **3M™ NVH Dampening Material**, PN 04274
- **3M™ Flexible Foam**, 200mL, PN 08463
- **3M™ Urethane Seam Sealer**, PN 08361; PN 08362
- **3M™ MSP Seam Sealer**, PN 08370
- **3M™ Rigid Pillar Foam**, 200mL, PN 08458

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### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug**, PN P1300
- **3M™ Half Facepiece Respirator**, PN 07182
- **3M™ Virtua™ Protective Eyewear**, PN 11326

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Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.

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Visit 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 3MCollision.com

For product material safety data sheets see 3MCollision.com

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