# Standard Operating Procedures

## Truck Repair

### Aluminum Panel Installation: Adhesive

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td><strong>Clean</strong>&lt;br&gt;Wash the truck and repair area prior to disassembly with soap and water followed by a VOC compliant surface cleaner.</td>
</tr>
<tr>
<td>2</td>
<td><strong>Dry Fit Panel</strong>&lt;br&gt;Dry fit all parts to ensure a good fit before dispensing and applying adhesive. <strong>Note:</strong> Use 1-1/2 in. tape for alignment markings to determine proper placement and attachment.</td>
</tr>
<tr>
<td>3</td>
<td><strong>Remove Panel</strong>&lt;br&gt;Cut tape between the two panels and remove panel. Use rubber gloves to prevent contamination.</td>
</tr>
<tr>
<td>4</td>
<td><strong>Apply Adhesive</strong>&lt;br&gt;Apply adhesive to the sanded replacement panel flange. Use rubber gloves to prevent contamination.</td>
</tr>
<tr>
<td>5</td>
<td><strong>Fit Panel</strong>&lt;br&gt;Fit panel to the existing truck side panel and slide if necessary to align to 1-1/2 in. tape. <strong>Note:</strong> Always slide panel and never pick up panel away from bonding surface. Apply clamps.</td>
</tr>
</tbody>
</table>

### Product List

- **3M™ Car Wash Soap Concentrate,** 5 gallons, PN 38378
- **3M™ Specialty Adhesive Remover,** 15 oz. aerosol, PN 38987
- **Scotch® Performance Green Masking Tape** 233+, 36mm width (1.41 in.), PN 26338
- **3M™ SMC/FRP Repair – 90,** 400mL, PN 08274

### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug,** PN P1300
- **3M™ Half Facepiece Respirator,** PN 07182
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket,** PN 11872

*Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.*

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For ordering information, contact your 3M Sales Representative

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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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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.