

Aluminum Panel Removal

1



Clean

Clean the panel prior to disassembly with soap and water followed by a VOC compliant surface cleaner.

2



Sealer/Coating Removal

If necessary, use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas. For hard to reach areas use a CRS grade Scotch-Brite™ Belt.

3



Rivet/Spot Weld Removal — Belt Grinder

Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge (e.g., stop grinding when the back of belt is flush with exterior panel). **Note: During application, follow OEM recommended procedures for removal of rivets and/or other fasteners.**

4



Panel Separation

Separate exterior panel from the host panel. **DO NOT** force separation in areas where the weld isn't completely removed. Go back to Step 3 and finish weld removal before continuing.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378



3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987



Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, 4 in. x 1/2 in., Extra Coarse, PN 07470



Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, 4 in. x 1/2 in., Extra Coarse, PN 07466



3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573



Scotch-Brite™ Durable Flex Belt, 1/2 in. x 18 in., Coarse, PN 64475



3M™ Green Corps™ Reinforced Weld Grinding Wheel, PN 01991



3M™ Cut-Off Wheel Tool, 3 in., PN 33579



3M™ Cubitron™ II File Belt, 1/2 in. x 18 in., grade 80+, PN 33446



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.

Use only tools that have been cleaned properly or are designated for use on aluminum to reduce potential cross contamination. DO NOT re-use abrasives that were previously used on steel repairs.

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.



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