

Aluminum Part Replacement	
<b>1</b>	 <p><b>Pre-Cleaning</b> Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>	 <p><b>Sealer/Coating Removal</b> Use Scotch-Brite™ Clean and Strip Disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.</p>
<b>3</b>	 <p><b>Rivet/Spot Weld Removal</b> 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 — stop grinding when back of belt is flush with exterior panel. <b>Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.</b></p>
<b>4</b>	 <p><b>Panel Separation</b> Separate exterior panel from the host panel. <b>DO NOT force separation in areas where the weld isn't completely removed, go back to step 3 and finish weld removal before continuing.</b></p>
<b>5</b>	 <p><b>Surface Preparation</b> Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean and Strip Disc.</p>
<b>6</b>	 <p><b>Panel Installation</b> <b>Follow OEM recommendations where applicable.</b> Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc.</p>

Visit [3MCollision.com](http://3MCollision.com) for more SOPs and videos

### Product List

Meguiar's® Shampoo Plus,  
1 gallon, PN D11101



Meguiar's® Citrus Power  
Cleaner Plus, 1 gallon,  
PN D10701



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™ File Belt Sander,  
18 in., PN 33575



Scotch-Brite™ Durable Flex  
Belt, CRS, PN 64475



3M™ Cubitron™ II File Belt,  
grade 80+, PN 33446



3M™ Panel Bonding Adhesive,  
50mL, PN 38315;  
200mL, PN 08115;  
200mL, PN 08116;  
450mL DMS, PN 58115



3M™ Impact Resistant  
Structural Adhesive  
200mL, PN 07333;  
450mL DMS, PN 57333



### 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



## 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](http://3MCollision.com)

For product material safety data sheets see [3MCollision.com](http://3MCollision.com)

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