### Aluminum Part Replacement

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<th>Step</th>
<th>Description</th>
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| 1 | **Pre-Cleaning**  
  Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair). |
| 2 | **Sealer/Coating Removal**  
  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. |
| 3 | **Rivet/Spot Weld Removal**  
  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. **Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.** |
| 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.** |
| 5 | **Surface Preparation**  
  Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean and Strip Disc. |
| 6 | **Panel Installation**  
  Follow OEM recommendations where applicable. Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc. |

### 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

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Note: Use caution when working on aluminum parts. Use tools that have been cleaned properly or 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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