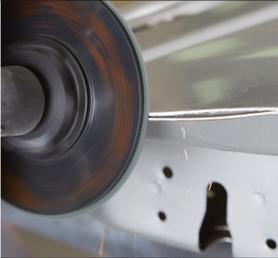


**Door Skin Removal**

|          |   |   |
|----------|---|---|
| <b>1</b> |    | <p><b>Pre-Cleaning</b><br/>Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>   |
| <b>2</b> |    | <p><b>Parts Removal</b><br/>Remove associated trim and parts. Use molding removal tool to remove and save side moldings and emblems.</p>  |
| <b>3</b> |   | <p><b>Hem Flange Grinding</b><br/>Use grade 60 fiber-backed abrasive disc to grind outer edge and separate door skin from door frame.</p>   |
| <b>4</b> |  | <p><b>Hem Flange Spot Weld Removal</b><br/>Use grade 60 file belt to remove any spot welds attaching hem flange to door frame. <b>Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.</b> Separate hem flange material from backside of door.</p> |
| <b>5</b> |  | <p><b>Door Skin Spot Weld Removal</b><br/>Use grade 60 file belt to remove any spot welds attaching door skin to door frame. <b>Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.</b></p>   |
| <b>6</b> |  | <p><b>Door Skin Removal</b><br/>Separate door skin from door frame. Use a putty knife to help separate skin from adhesive and NVH material on intrusion beam. Heat may be used when required for softening. (Maintain original NVH material whenever possible.)</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



3M™ Side Molding  
and Emblem Removal  
Tool, PN 08978



3M™ Disc Sander,  
PN 28408



3M™ Cubitron™ II  
Abrasive Fibre Disc,  
grade 60+, 5 in.,  
PN 33415



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



3M™ Cubitron™ II  
File Belt, grade 60+,  
PN 33445



**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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