

Aluminum Repair Procedures

Sealing and Coating

Properly dress and finish welding areas prior to applying direct to metal seam sealer.

General Seam Sealer Application: Direct to Metal

1



Surface Prep

Scuff sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air.

2



Clean

Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a VOC compliant wax and grease remover. **DO NOT spray or saturate seams with cleaner.**

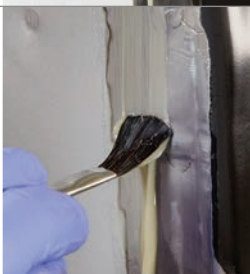
3



Apply Tight Coat

Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing of the joint prior to creating the desired appearance.

4



Apply Seam Sealer

Apply seam sealer over the prepared seam. Tool to re-create OEM appearance.

Visit www.3Mcollision.com for more SOPs and videos

Product List

Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine grade, 6 in. x 9 in., PN 64926



3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350



3M™ Urethane Seam Sealer, PN 08361; PN 08362



3M™ MSP Seam Sealer, PN 08370

3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Respirator Assembly/Organic Vapor N95 Dual Cartridge, PN 07192



3M™ Lexa™ Protective Eyewear, PN 15200



Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at www.3MCollision.com

For product material safety data sheets see www.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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