

# Aluminum Repair Procedures

## Sealing and Coating



### Pre-Made LASD Replacement (Off Body) (Liquid Applied Sound Deadening)

1		<p><b>Pre-Cleaning</b> Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p><b>LASD Removal</b> Remove sound deadener material from affected repair area using a scraper or chisel. Blow off area with compressed air and clean with APCD.</p>
3 <sub>A</sub>		<p><b>Pre-make Patch</b> Apply packaging tape to smooth bench top surface as a release liner. Mask out desired patch size and shape over the top of packaging tape.</p>
3 <sub>B</sub>		<p><b>Pre-make Patch</b> Dispense seam sealer material onto prepared surface.</p>
3 <sub>C</sub>		<p><b>Pre-make Patch</b> Re-create desired appearance and texture of NVH material using tools of the trade (e.g., brushes, scuff pads, compressed air, etc.). Remove perimeter masking following the tooling process and prior to final cure.</p>
4		<p><b>Surface Prep</b> Scuff surface with a maroon Scotch-Brite™ Hand Pad. Blow off area with compressed air and clean with APCD.</p>
5		<p><b>Install Replica (on body)</b> After material cures, remove the LASD replica from the release liner, scuff with maroon Scotch-Brite™ Hand Pad, apply NVH material to the bottom of the replica. Bond in place at the correct location.</p>

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

### Product List

3M™ Car Wash Soap Concentrate,  
1 gallon, PN 38377



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



Scotch® Performance  
Green Masking Tape 233+,  
18mm width (.71 in.), PN 26334



3M™ Heavy-Bodied Seam Sealer,  
200mL, PN 08308



3M™ Heavy-Bodied Seam Sealer,  
600mL DMS, PN 58308



3M™ NVH Dampening  
Material, PN 04274



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



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

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



### 3M Automotive Aftermarket Division

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