

# Aluminum Repair Procedures

## Paint Prep

### E-Coat Panel Prep

1



#### Cleaning

Clean part with soap and water, followed by a recommended VOC compliant surface cleaner.

2A



#### Surface Prep Hand

Sand edges and other hard to reach areas using P400 flexible abrasive sheet or Scotch-Brite™ Hand Pad until the surface is matte and all sheen has been removed.

2B



#### Surface Prep Machine

Sand remaining surfaces using P400 abrasive on a DA sander until the surface is matte and all sheen has been removed. **Note: Use 3M™ Hookit™ Hard E-coat Disc on hard to sand aftermarket parts.**

3



#### Re-Clean

Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

4



#### Apply Top Coats

Seal and paint following paint company recommendations.

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



3M™ Flexible Abrasive Hookit™ Sheet, 5.5 in. x 6.8 in., P400, PN 34337



3M™ Flexible Abrasive Hookit™ Foam Pad, PN 34349



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™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P400 grit, PN 01811



3M™ Hookit™ Hard E-Coat Disc, 320 Grit, PN 30695



3M™ Accuspray™ Spray Gun Model HG14 Kit, 1.4mm, PN 16577



### Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



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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