## Aluminum Repair Procedures

### Body Repair

### Express Damage Repair

<table>
<thead>
<tr>
<th>Step</th>
<th>Task Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td><strong>Clean the Damaged Area</strong>&lt;br&gt;Clean the repair area with soap and water, followed by a recommended VOC compliant surface cleaner.</td>
</tr>
<tr>
<td>2</td>
<td><strong>Initial Prep Sand</strong>&lt;br&gt;DA sand the repair using 3 in. grade 180 DA disc, being careful to not sand through the clear coat. Blow off with clean dry air and re-clean with a surface cleaner.</td>
</tr>
<tr>
<td>3</td>
<td><strong>Mix and Apply Glaze</strong>&lt;br&gt;Mix and apply polyester glaze per manufacturers recommendation or use the 3M™ Dynamic Mixing System. Cure 15–20 minutes at 75°F.</td>
</tr>
<tr>
<td>4</td>
<td><strong>Apply Dry Guide Coat</strong>&lt;br&gt;Apply 3M™ Dry Guide Coat over cured glaze. Re-apply as often as necessary during sanding process.</td>
</tr>
<tr>
<td>5</td>
<td><strong>Sand Glaze</strong>&lt;br&gt;Hand block or DA sand glaze completely removing 3M™ Dry Guide Coat using a grade 320 abrasive disc/sheet.</td>
</tr>
<tr>
<td>6</td>
<td><strong>Final Sand and Inspect</strong>&lt;br&gt;Blow off repair area and re-apply 3M™ Dry Guide Coat. Finish sanding the repair area and the surrounding area using a 3 in. grade 320 abrasive disc. Inspect the repair for quality.</td>
</tr>
</tbody>
</table>

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

---

### Product List

- **3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc,** 3 in., grade 180+, PN 31364; 3 in., grade 320+, PN 31463
- **3M™ Platinum™ Plus Finishing Glaze, 30 oz. container,** PN 31180
- **3M™ Platinum™ Glaze for DMS, 10.3 oz. cartridge,** PN 05862
- **3M™ Dry Guide Coat, 50 gram applicator kit,** PN 05861
- **3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll,** 70mm x 12m, grade 320+, PN 34449
- **3M™ Dynamic Mixing Applicator — Pneumatic,** PN 05846
- **3M™ E-A-R™ Skull Screws™ Ear Plug,** PN P1300
- **3M™ Half Facepiece Respirator,** PN 07182
- **3M™ Virtua™ Protective Eyewear,** PN 11326

---

**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.

---

**Always follow OEM procedures | For ordering information, contact your 3M Sales Representative**
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

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer’s application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.