

# Aluminum Repair Procedures

## Body Repair

### Express Damage Repairs

1



#### Clean the Damaged Area

Clean the repair area with soap and water, followed by a recommended VOC compliant surface cleaner.

2



#### Initial Prep Sand

DA sand the repair using 3 in. P180 DA disc, being careful to not sand through the clear coat. Blow off with clean dry air and reclean with a surface cleaner.

3



#### Mix and Apply Glaze

Mix and apply polyester glaze per manufacturer's recommendation or use the 3M™ Dynamic Mixing System. Cure 15–20 minutes at 75°F.

4



#### Apply Dry Guide Coat

Apply 3M™ Dry Guide Coat over cured glaze. Re-apply as often as necessary during sanding process.

5



#### Sand Glaze

Hand block or DA sand glaze completely removing 3M™ Dry Guide Coat using a P320 abrasive disc/sheet.

6



#### Final Sand and Inspect

Blow off repair area and re-apply 3M™ Dry Guide Coat. Finish sanding the repair area and the surrounding area using a 3 in. P320 abrasive disc. Inspect the repair for quality.

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

### Product List

3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 3 in., 180+ grade, PN 31364



3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P320, PN 30275



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™ Hookit™ Purple Clean Sanding Sheet Roll, 320 grade, 70mm x 12m, PN 30705



### 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



**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.**

## 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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(Rev 9/2015)

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