

Aluminum Repair Procedures

Body Repair

Large Damage Repair

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| 1 | | Pre-Cleaning Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair). |
| 2 | | Initial Prep Sand DA sand the repair area using grade 80 abrasive, removing paint beyond damage by 2 in.–4 in. Blow off with clean, dry air and re-clean with surface cleaner. |
| 3 | | Final Metal Prep Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N Strip Disc. Use a 3 in. grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner. |
| 4 | | Mix and Apply Filler Mix and apply filler per manufacturer’s recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F. |
| 5 | | Initial Sand Filler Block shape sand filler with P80 abrasive. DA rough featheredge area with P80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary. |
| 6 | | Final Sand Filler Final block sand filler with P150 abrasive. DA fine featheredge sand the repair area with P180 abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. |
| 7 | | Mix and Apply Glaze Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer’s recommendation or using 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F. |
| 8 | | Sand Glaze Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections. |
| 9 | | Final Sand and Inspect Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality. |

Visit 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™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+ grade, PN 31361; 6 in., 80+ grade, PN 31371



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 80+, 3 in., PN 33392



3M™ Scotch-Brite™ Roloc™ + Clean N Strip, 4" x 1/2", extra coarse, XT Disc, PN 07470; TR Disc, PN 07466



3M™ Roloc™ + Holder, PN 07500



3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863



3M™ Hookit™ Purple Clean Sanding Sheet Roll, 70mm x 12m, 80 grade, PN 30713; 150 grade, PN 30710; 180 grade, PN 30709



3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861



3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374



3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180



3M™ Platinum Glaze for DMS, PN 05862



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.



Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

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 go.3M.com/SDS

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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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