**Aluminum Repair Procedures**

**Sealing and Coating**

**Anti-Chip Coating**

1. **Pre-Cleaning**
   Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. **Removal of Heavy Surface Contaminates**
   Clean to remove heavy contaminants from repair area.

3. **OEM Coating Removal**
   Remove OEM coating as needed using Clean and Strip disc. Featheredge using grade 80 abrasive on DA sander. Blow off surface with clean, dry air. Clean surface with all purpose cleaner and degreaser.

4. **Filling/Leveling Surface**
   Use polyester glaze to fill the repair area, bringing it the same level as the surrounding coating.

5. **Sanding and Primer**
   Sand glaze using grade 150 on a hand block. Final featheredge area using grade 320 abrasive on a DA sander. Blow off with clean, dry air. Final clean with VOC compliant wax and degreaser. Apply primer following paint company recommendations.

6. **Sanding Primer**
   Apply 3M guide coat to primed surface. Sand primer using grade 320 on a DA sander with an interface pad. Blow off with clean, dry air. Final clean with VOC compliant wax and degreaser.

7. **Masking**
   Apply soft edge foam masking tape following existing coating edge. Final mask the area using tape and paper to protect from overspray.

8. **Coating Test Panel**
   Apply the coating to a test panel. Always apply a light coat first, allow it to flash, and adjust the spray equipment to deliver the texture required to match the OEM appearance.

9. **Apply Coating**
   Apply anti-chip coating to the repair area using settings from test panel, blending the material into surrounding area as needed.

10. **Blend Sanding**
   Use grade 1000 3M™ Trizact™ Disc on a DA sander to smooth the blend edges. This operation produces a smooth transition without removing chip coating profile.

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**Product List**

- **Meguiar’s® Shampoo Plus**, 1 gallon, PN D1101
- **Meguiar’s® Citrus Power Cleaner Plus**, 1 gallon, PN D10701
- **3M™ General Purpose Adhesive Cleaner**, aerosol, PN 08987; Adhesive Remover, PN 38983
- **Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc**, PN 21555
- **3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc**, 6 in., grade 80+, PN 31075; 6 in., grade 320+, PN 31683
- **3M™ Platinum™ Plus Finishing Glaze**, 30 oz., PN 31180; Glaze for DMS, PN 05862
- **3M™ Hookit™ Sanding Block Dust Free**, 70mm x 127mm, PN 05207
- **3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll**, 70mm x 12m, grade 50+, PN 34445
- **3M™ Dry Guide Coat**, 50 gram applicator kit, PN 05861
- **3M™ Hookit™ Soft Interface Pad**, 6 in., PN 05777
- **3M™ Soft Edge Foam Masking Tape PLUS**, 21mm (.8 in.), PN 06293
- **3M™ Scotchblok™ Masking Paper**, 18 in. x 750 ft., PN 06718
- **Scotch® Performance Green Masking Tape 233+**, width 12.7mm (.5 in.), PN 26332
- **3M™ Waterbased Paintable Undercoating Pouch**, 5.5 fl. oz. (US), PN 08744
- **3M™ Rocker Protector Pouch**, 3 fl. oz. (US), PN 08733; 5.5 fl. oz. (US), PN 08734
- **3M™ Accuspray™ HGP Pressure Spray Gun**, PN 16587
- **3M™ PPS™ Type H/O Pressure Cup**, 28 oz., PN 16124; 6 oz., PN 16121
- **3M™ Trizact™ Hookit™ Blending Disc**, 6 in., grade PI00D, PN 02090

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**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™ Virtua™ Protective Eyewear**, PN 11326
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

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