

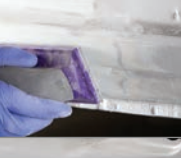







# ANZ Aluminum Repair Procedures

## Sealing and Coating

### Anti Chip Coating

1		<b>Pre-Cleaning</b> Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		<b>Removal of Heavy Surface Contaminates</b> Clean to remove heavy contaminants from repair area.
3		<b>OEM Coating Removal</b> Remove OEM coating as needed using Clean N 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		<b>Filling/Leveling Surface</b> Use polyester glaze to fill the repair area, bringing it the same level as the surrounding coating.
5		<b>Sanding and Primer</b> Sand glaze using P150 on a hand block. Final featheredge area using P320 abrasive on a DA sander. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover. Apply primer following paint company recommendations.
6		<b>Sanding Primer</b> Apply 3M guide coat to primed surface. Sand primer using P320 on a DA sander with an interface pad. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover.
7		<b>Masking</b> Apply soft edge foam masking tape following existing coating edge. Final mask the area using tape and paper to protect from overspray.
8		<b>Coating Test Panel</b> 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		<b>Apply Coating</b> Apply anti chip coating to the repair area using settings from test panel, blending the material into surrounding area as needed.
10		<b>Blend Sanding</b> Use P1000 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 ANZ

3M™ Car Wash Soap Concentrate, 3.78 litre, PN 38377

3M™ All Purpose Cleaner and Degreaser Concentrate, 3.78 litre, PN 38350

3M™ General Purpose Adhesive Cleaner, aerosol, PN 08987 OR 700 Adhesive Cleaner Solvent

Scotch-Brite™ Clean N Strip Disc, PN 57016 or Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466

3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 150mm, 80+ grade, PN 31371

3M™ Advanced Finishing Glaze, 710ml, PN05821 or 3M™ Flowable Finishing Glaze, 710ml, PN05824 or 3M™ Platinum Plus Glaze, 476g, PN03080 or 3M™ Platinum Plus Glaze, 476g, PN03080

3M™ Hookit™ Purple Clean Sanding Sheet Roll, P120 or P180, 70mm x 12m, PN 30709; Disc 334U, 150mm, P320, PN 01812

3M™ Hookit™ Sanding Block Dust Free, 70mm x 127mm, PN 05207

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

3M™ Hookit™ Soft Interface Pad, 150mm x 10mm, PN 05777 or PN 50544

3M™ Soft Edge Foam Masking Tape PLUS, 21mm (.8 in.), PN 06293 or PN 06293

3M™ Smooth Transition Tape, 6.4mm, PN 06800

3M™ Scotchblok™ Masking Paper, 457mm x 228m, PN 06718

Scotch® Performance Green Masking Tape 233+, 12mm width,

3M™ Rocker Protector Pouch, 162 ml, PN 08747

3M™ Trizact™ Hookit™ Blending Disc, 150mm, P1000, PN 02090 or PN 50341

### Think About Your Health

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

3M™ Half Facepiece Respirator, PN 07502 with appropriate cartridge

3M™ Lexa™ Protective Eyewear, PN 15200 or 3M Secure Fit AF401SF-AS

**Note:** Use caution when working on aluminium parts. Use tools that have been cleaned properly or designated for use on aluminium to reduce potential cross contamination. Do not re-use abrasives that were previously used on steel repairs.

For ordering information, contact your 3M Sales Representative

