

ANZ Aluminum Repair Procedures

Body Repair

Aluminium Small Damage Repair

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 50 -100mm
Blow off with clean, dry air and re-clean with surface cleaner.

3



Mix and Apply Filler

Mix and apply filler per manufacturer's recommendation. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 24°C. Caution: Do not apply filler over existing paint/e-coat to prevent repair mapping

4



Sand Filler

Using a hand block, shape sand the body filler with P80 abrasive. Apply dry guide coat and finish block sanding with P150 abrasive. DA featheredge the repair area with P180 abrasive disc. Inspect the repair for quality, if glaze is not required, continue to Step 7.

5



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. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 24°C. Caution: Do not apply filler over existing paint/e-coat to prevent repair mapping

6



Sand Glaze

Sand polyester glaze with P180. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7



Final Sand and Inspect

Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.

Visit www.3m.com.au/aad or www.3m.co.nz/aad for more SOPs and videos

Product List ANZ

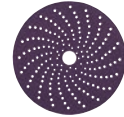
3M™ Car Wash Soap Concentrate, 3.78 litre, PN 38377



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



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



3M™ Platinum™ Plus Body Filler, 3 litre, PN 01131



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



3M™ Advanced Finishing Glaze, 710ml, PN05821
OR



3M™ Flowable Finishing Glaze, 710ml, PN05824
OR

3M™ Platinum Plus Glaze, 476g, PN03080



3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 150mm, 180+ grade, PN 31374



3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861 or 09560 and 09561



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 SF401AF-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