

# ANZ Aluminum Repair Procedures

## Sealing and Coating

Properly dress and finish welding areas prior to applying direct to metal seam sealer.

### Aluminium General Seam Sealer Application: Direct to Metal (DTM)

1



#### Surface Prep

Scuff sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air.

2



#### Clean

Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a VOC compliant wax and grease remover. **DO NOT spray or saturate seams with cleaner.**

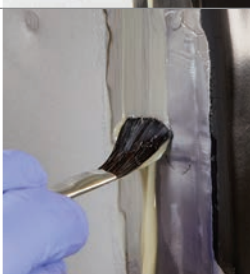
3



#### Apply Tight Coat

Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing of the joint prior to creating the desired appearance.

4



#### Apply Seam Sealer

Apply seam sealer over the prepared seam. Tool to re-create OEM appearance.

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### Product List ANZ

Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 115mm x 230mm, Very Fine, PN 64659  
OR



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine grade 150mm x 230mm, PN 64926



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



3M™ Urethane Seam Sealer, PN 08689, 08684, 08694  
OR



3M™ MSP Seam Sealer, PN 08369 (white) or PN 08370 (grey)  
OR



3M™ Multi Purpose Seam Sealer, PN 50740

### 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-SF



**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.**