

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.**

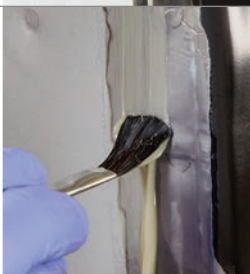
3



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.

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

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)



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.