

# ANZ Aluminum Repair Procedures

## Body Repair

### Aluminum Rivet Bonding

1		<p>Refer Aluminium Part Replacement SOP prior to commencing this SOP</p> <p><b>Host Panel Preparation</b> Using a grade 80 abrasive belt, remove remaining rivet material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Durable Flex Belt.</p>
2		<p><b>Mating Flange Panel Preparation</b> Remove Ecoat from replacement panel mating flange areas using a Scotch-Brite™ Belt or Clean N Strip Disc.</p>
3		<p><b>Dry Fit Panel</b> Dry fit replacement panel and complete any necessary metal straightening at flanges areas.</p>
4		<p><b>Clean</b> Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
5		<p><b>Rivet Preparation</b> Identify replacement rivet sites and prepare the surface for the type of rivet recommended by the manufacturer. (For blind or solid rivets, drill all necessary holes.) Remove panel once complete.</p>
6		<p><b>Pre Assembly NVH Replacement</b> If vehicle construction necessitates, apply 3M™ NVH Dampening Material or 3M™ Flexible Foam at original locations as required.</p>
7		<p><b>Apply Bonding Adhesive</b> Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange area to ensure proper bond line thickness.</p>
8		<p><b>Install Replacement Panel</b> Install replacement panel to host panel taking care to avoid scraping off any adhesive during installation. Clamp in place.</p>
9		<p><b>Install Rivets and Welds</b> Install replacement rivets to all areas as recommended by the OE manufacturer. <b>Note: Rivets must be installed while adhesive is uncured.</b> Weld cosmetic joints/splices as necessary or recommended by the OE Manufacturer.</p>
10		<p><b>Adhesive Clean Up</b> Remove clamps and tool excess adhesive squeeze out from repair area prior to curing to seal the repair. An acid brush works well to remove adhesive from between clamps. <b>Note: Grinding to remove excess cured adhesive can expose bare metal, causing corrosion.</b></p>
11		<p><b>Post Assembly Foam Replacement</b> Apply foams at original locations as required.</p>

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### Product List ANZ

3M™ Cubitron™ II File Belt, grade 80+, PN 33440



Scotch-Brite™ Durable Flex Belt, CRS



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



3M™ Panel Bonding Adhesive, 200mL, PN 08115;



3M™ Flexible Foam, 200mL, PN 08463



3M™ Rigid Pillar Foam, 200mL, PN 08458



### Think About Your Health

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



3M™ Half Facepiece Respirator, PN07502 with appropriate cartridge



3M™ Lexa™ Protective Eyewear, PN 15200 or 3M Secure Fit SF401AF-AS



**Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.**  
**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