

ANZ Aluminum Repair Procedures

Body Repair

Aluminium Large 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 to 100mm. Blow off with clean, dry air and re-clean with surface cleaner.
3		Final Metal Prep Remove remaining paint/coatings in "low spots" using a Scotch-Brite™ Clean N Strip Disc. Use a 76mm grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.
4		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-coatto prevent repair mapping
5		Initial Sand Filler Block shape sand filler with P80 abrasive. DA rough featheredge area with P80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.
6		Final Sand Filler Final block sand filler with P180 abrasive. DA fine featheredge sand the repair area with P180 abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.
7		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-coatto prevent repair mapping
8		Sand Glaze Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.
9		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™ Cubitron™ II Fibre Roloc™ Disc, grade 80+, 75mm, PN 33392

3M™ Roloc™ + Holder, PN 07500

3M™ Scotch-Brite™ Clean N Strip Disc, PN 57016 or Roloc™ Clean N Strip TR disc, PN 07466

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

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

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

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

3M™ Platinum Plus Glaze, 476g, PN03080

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

