

ANZ Aluminum Repair Procedures

Body Repair

Aluminium Door Skin Removal

1



Pre-Cleaning

Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Parts Removal

Remove associated trim and parts. Use a molding removal tool to remove and save side moldings and emblems.

3



Hem Flange Grinding

Use grade 60 fiber backed abrasive disc to grind outer edge and separate door skin from door frame.

4



Hem Flange Spot Weld Removal Use grade 60 file belt to remove any spot welds attaching hem flange to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.** Separate hem flange material from backside of door.

5



Door Skin Spot Weld Removal Use grade 60 file belt to remove any spot welds attaching door skin to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.**

6



Door Skin Removal

Separate door skin from door frame. Use a putty knife to help separate skin from adhesive and NVH material on intrusion beam. Heat may be used when required for softening. (Maintain original NVH material whenever possible.)

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 Abrasive Fibre Disc, grade 60+, 100mm, PN 33397



3M™ Cubitron™ II File Belt, grade 60+, PN 33439



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.