

ANZ Aluminum Repair Procedures

Body Repair

Door Skin Full Replacement

1		<p>Refer Aluminium door skin removal SOP prior to this procedure</p> <h4>Door Frame Preparation</h4> <p>Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ Belt.</p>
2		<h4>Clean</h4> <p>Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.</p>
3		<h4>Replacement Skin Prep</h4> <p>Scuff replacement skin mating flange areas using Scotch-Brite™ Hand Pad.</p>
4		<h4>Dry Fit Panel</h4> <p>Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove door skin in preparation for adhesive application.</p>
5		<h4>NVH (Noise, Vibration and Harshness) Replacement</h4> <p>Apply Seam Sealer 8369 or 8370 to prevent flutter.</p>
6		<h4>Apply Bonding Adhesive</h4> <p>Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.</p>
7		<h4>Install Door Skin</h4> <p>Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)</p>
8		<h4>Clamp and Cure</h4> <p>Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze out from hem flange area with a VOC compliant cleaner.</p>
9		<h4>Seam Sealing</h4> <p>Re-apply seam sealer to hem flange as required following general seam sealing guidelines.</p>

Visit www.3m.com.au/aad or www.3m.co.nz/aad for SOP's and videos

Product List ANZ

3M™ Cubitron™ II File Belt, grade 80+, PN 33446



Scotch-Brite™ Durable Flex Belt, CRS



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



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



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



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



3M™ Multi Purpose Repair Material, 200mL, PN 05887 can be used as a seam sealer



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07502 and appropriate cartridge



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



Note: Use caution when working on aluminum parts. Use tools that have been cleaned properly or designated for use on aluminum 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