

ANZ Aluminum Repair Procedures

Body Repair

Aluminum Part Replacement

1



Pre-Cleaning

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

2



Sealer/Coating Removal

Use Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.

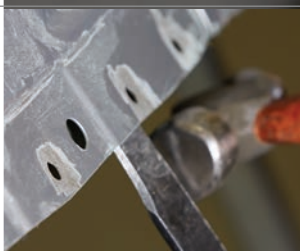
3



Rivet/Spot Weld Removal

Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. **Follow OEM recommended procedures for removal of rivets and/or other fasteners, when they apply.**

4



Panel Separation

Separate exterior panel from the host panel. **DO NOT force separation in areas where the weld isn't completely removed, go back to step 3 and finish weld removal before continuing.**

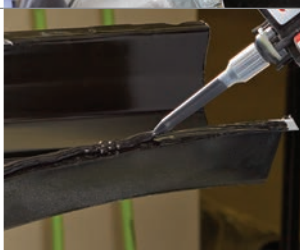
5



Surface Preparation

Prepare surfaces of host and replacement panel for bonding adhesive by using a Scotch-Brite™ Belt or Clean N Strip Disc.

6



Panel Installation

Follow OEM recommendations where applicable. Attachment methods may include panel bonding adhesive, self piercing rivets, huck rivets, etc.

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



Scotch-Brite™ Clean N Strip Disc, PN57016
OR
Scotch-Brite™ Roloc™ + Clean N Strip TR Disc, PN 07466



Scotch-Brite™ Durable Flex Belt, CRS.



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



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



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

