



Steel Part Replacement		
1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		Panel Cutting Identify OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim repair area using preferred cut-off wheel. Use grade 36 file belt in hard to reach areas to cut top panel and avoid damage to host panel.
3		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.
4		Spot Weld Removal Using grade 36 or 60 abrasive belt, grind spot weld to remove weld from top panel. Note top panel thickness. Use caution when grinding to only grind top panel and limit cutting into host/interior panel. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. Grade 80 belt can be used to remove welds from thinner steels.
5		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 4 and finish weld removal before continuing.
6_A		Surface Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel.
6_B		Surface Preparation Clean and prep remaining mating flanges on host and replacement panel with a coarse Scotch-Brite™ Belt where necessary.
7_A		MIG Plug Weld Dressing Use a grade 80 abrasive belt to dress replacement MIG welds. Grind weld. Use caution to avoid damage to adjacent areas.
7_B		Continuous Weld Dressing Use a 75mm grade 60 grinding disc to dress continuous MIG welds at sectioning joint. Grind weld. Use caution to limit amount of grinding done to adjacent areas.
8		Weld Cleaning Use a CRS Scotch-Brite™ Belt to clean weld site in preparation for subsequent operations.

Product List	
3M™ Car Wash Soap Concentrate, 3.7L, PN 38377	
3M™ All Purpose Cleaner and Degreaser Concentrate, 3.7L, PN 38350	
3M™ Green Corps™ Cut-Off Wheel, 75mm x 0.8mm, PN 01989; 75mm x 1.6mm x 9.5mm, PN 01990	
Scotch-Brite™ Roloc™ Clean N Strip XT Disc CX-DR	
Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, 100mm, PN 07466	
3M™ Mini File Belt Sander, 330mm, PN 33573	
Scotch-Brite™ Durable Flex Belt, CRS	
3M™ Cubitron™ II File Belt, grade 36+, PN 33437 grade 60+, PN 33439 grade 80+, PN 33440	
3M™ Pistol Grip Disc Sander, PN 33577	
3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 75mm, PN 33391	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Face Welding Respirator Kit, PN 6228	
3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS	
Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.	

Note: Follow High Strength steel heat control recommendations and techniques when necessary.