

PERSONAL SAFETY

- Comfort Particle Mask P2
- Hearing Protection
- Face Protection
- Reusable Workwear
- Safety Gloves

1 Replacement Panel Cutting		<ul style="list-style-type: none"> ▶ Identify car manufacturer recommended sectioning location, scribe or mark with tape on the vehicle and replacement panel ▶ Trim repair area using preferred cut-off wheel 	<p>3M™ Cut-Off Wheel Tool ø 75 mm , ø 100 mm</p> <p>3M™ Cubitron™ II Cut-Off Wheels</p>
2 Replacement Panel Preparation		<ul style="list-style-type: none"> ▶ Clean and prep remaining mating flanges on replacement panel with a Scotch-Brite™ Belt or Disc where necessary ▶ Clean and apply weld-thru primer to all areas requiring welding methods for corrosion protection 	<p>3M™ Scotch-Brite™ File Belts</p> <p>3M™ Scotch-Brite™ Roloc™ Disc</p> <p>3M™ File Belt Tool</p> <p>3M™ Pistol Grip Disc Sander</p>
3 Sealer/Coating Removal		<ul style="list-style-type: none"> ▶ Use Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations 	<p>3M™ Scotch-Brite™ File Belts</p> <p>3M™ File Belt Tool</p>
4 Spot Weld Removal		<ul style="list-style-type: none"> ▶ 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 ▶ Separate exterior panel from the host panel after additional pre cut 	<p>3M™ Cubitron™ II File Belts 60+ - 80+</p> <p>3M™ File Belt Tool</p>
5 Final Cut		<ul style="list-style-type: none"> ▶ Identify final cut line at the overlapping area of the pre cutted host and replacement panel ▶ Trim repair area using preferred cut-off 	<p>3M™ Cut-Off Wheel Tool ø 75 mm , ø 100 mm</p> <p>3M™ Cubitron™ II Cut-Off Wheels</p>
6 Weld Surface Preparation		<ul style="list-style-type: none"> ▶ Clean and prep remaining mating flanges on replacement panel with a Scotch-Brite™ Belt or Disc where necessary ▶ Use caution to limit amount of grinding done to adjacent areas in terms of substrate thickness ▶ Clean surface and apply weld-thru primer to all areas requiring welding methods for corrosion protection 	<p>3M™ Scotch-Brite™ File Belts</p> <p>3M™ Scotch-Brite™ Roloc™ Disc</p> <p>3M™ File Belt Tool</p> <p>3M™ Pistol Grip Disc Sander</p>
7 Panel Bonding		<ul style="list-style-type: none"> ▶ Apply adhesive to mating flange areas on host panel and replacement panel as recommended from car manufacturer by covering all bare metal areas ▶ Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness ▶ Note: A new cartridge needs to be calibrated as recommended before the first application, to allow initial equalisation! Any further material from there is good to use 	<p>3M™ Panel Bonding Adhesive</p> <p>3M™ Pneumatic Applicator for 200ml Duopack Cartridge</p> <p>3M™ Manual Applicator for 200ml Duopack Cartridge</p>
8 Welding		<ul style="list-style-type: none"> ▶ Using car manufacturer recommended welding methods at the different areas of the car body lines 	
9 Weld Cleaning		<ul style="list-style-type: none"> ▶ Use 80+ grit to equalize WPS welding spots and MIG brazing joints ▶ Fine sanding of weld site in preparation for subsequent operations ▶ Use caution to limit amount of grinding done to adjacent areas in terms of substrate thickness 	<p>3M™ Cubitron™ II File Belts</p> <p>3M™ Cubitron™ II Roloc™ Discs</p> <p>3M™ File Belt Tool</p> <p>3M™ Pistol Grip Disc Sander</p>