

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™ Cubitron™ III Cut-Off Wheels</p> <p>3M™ Cut-Off Wheel Tool ø 75 mm , ø 100 mm</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 pinchweld 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™ Scotch-Brite™ File Belts</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 precut host and replacement panel. Trim repair area using preferred cut-off method. 	  <p>3M™ Cubitron™ III Cut-Off Wheels</p> <p>3M™ Cut-Off Wheel Tool ø 75 mm , ø 100 mm</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 by the OEM 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 after equalisation is good to use. 	   <p>3M™ Panel Bonding Adhesive</p> <p>3M™ Manual Applicator for 200ml Duopack Cartridge</p> <p>3M™ Pneumatic Applicator for 200ml Duopack Cartridge</p>
8 Welding		<ul style="list-style-type: none"> Use OEM recommended welding methods on the different areas of the car body lines. 	
9 Weld seam cleaning		<ul style="list-style-type: none"> Use 80+ grit to flatten welding spots and MIG brazing joints. Fine sand the weld side to prepare for subsequent operations. Use caution to limit amount of grinding done to adjacent areas in terms of substrate thickness. Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly. It is recommended to apply cavity wax to back side of panel at heat effected areas to restore corrosion protection. 	    <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>