

Personal Safety

• Comfort Particle Mask P2



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



1 Replacement Panel Cutting



- Identify the vehicle manufacturers recommended sectioning location. Scribe with a marker or mark with tape on the vehicle and replacement panel.
- Trim repair area using preferred cut-off wheel



3M™ Cubitron™ II Cut-Off Wheels



3M™ Cut-Off Wheel Tool
ø 75 mm

2 Replacement Panel Preparation



- 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



3M™ Scotch-Brite™ File Belts



3M™ File Belt Tool



3M™ Scotch-Brite™ Roloc Disc



3M™ Pistol Grip Disc Sander

3 Sealer/Coating Removal



- Use a Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.



3M™ Scotch-Brite™ File Belts



3M™ File Belt Tool

4 Spot Weld Removal



- Grind spot welds to remove welds from top panel. Note top panel thickness
- Use caution when grinding, limiting cutting into the host/interior panel
- Separate exterior panel from the host panel after additional pre cut



3M™ Cubitron™ II File Belts 60+ - 80+



3M™ File Belt Tool

5 Final Cut



- Identify final cut line at the overlapping area of the precut host and replacement panel
- Trim repair area using preferred cut-off tool



3M™ Cubitron™ II Cut-Off Wheels



3M™ Cut-Off Wheel Tool
ø 75 mm

6 Weld Surface Preparation



- 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 Zinc Rich weld-thru coating to all areas requiring welding methods for corrosion protection



3M™ Scotch-Brite™ File Belts



3M™ File Belt Tool



3M™ Scotch-Brite™ Roloc Disc



3M™ Pistol Grip Disc Sander

7 Panel Bonding



- Apply a bead of adhesive to the mating flange areas on host panel and replacement panel as recommended by the vehicle manufacturer. Spread and cover all bare metal areas using an acid brush or plastic applicator.
- 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!



3M™ Panel Bonding Adhesive



3M™ Manual Applicator for 200ml Duopack Cartridge



3M™ Pneumatic Applicator for 200ml Duopack Cartridge

8 Welding



- Use vehicle manufacturers recommended welding methods at the different areas of the vehicle body lines

9 Weld Cleaning



- Use 80+ grit to equalize 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
- Note: Follow recommended internal corrosion protection processes prior to final vehicle assembly. It is recommended to apply cavity wax to restore corrosion protection on the backside of heat affected panels.



3M™ Cubitron™ II File Belts 60+ - 80+



3M™ File Belt Tool



3M™ Scotch-Brite™ Roloc Disc



3M™ Pistol Grip Disc Sander