






Personal Safety

• Respiratory Protection  • Hearing Protection  • Face Protection  • Reusable Workwear  • Safety Gloves 

Safety First! Always select appropriate personal protective equipment - eyewear, gloves, hearing and respiratory protection for your job and workplace.

Pre-Cleaning		<ul style="list-style-type: none"> Degrease the surface using paint company or other recommended VOC compliant water-based and solvent-based products. Always follow the manufacturer's instructions for surface cleaning instructions. 	
Panel Cutting		<ul style="list-style-type: none"> Identify the OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim the repair area using your preferred cut-off wheel. Use a grade 36 or 60 filebelt in hard-to-reach areas to cut the exterior panel while avoiding damage to the interior panel. 	  <p>3M™ Cut-Off Wheel Tool 3M™ Cubitron™ II Cut-Off Wheel</p>
Sealer / Coating Removal		<ul style="list-style-type: none"> Use a clean and strip disc to remove seam sealer and coatings from large easy-to-access areas. Use a non-woven belt to remove coatings and seam sealers in hard-to-reach areas and along pinch weld flanges to expose spot weld locations. 	   <p>3M™ Pistol Grip Disc Sander 3M™ File Belt Sander Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc</p>
Spot Weld Removal		<ul style="list-style-type: none"> Using a grade 60 or 80 abrasive belt, grind spot welds to remove the weld from the outer panel. Note outer panel thickness. <p>Note: When grinding outer panel only grind the top panel and limit cutting into the host/inner panel. Use belt thickness as a gauge — stop grinding when the back of the belt is flush with the outer panel. An 80-grade belt can be used to remove welds from thinner steels.</p>	   <p>Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc Scotch-Brite™ Durable Flex Belt, CRS 3M™ Cubitron™ II File Belt, grade 60+ and grade 80+</p>
Panel Separation		<ul style="list-style-type: none"> Separate outer panel from the interior panel. <p>Note: DO NOT force separation in areas where the weld isn't completely removed; go back to step 4 and finish weld removal before continuing.</p>	
Surface Preparation		<ul style="list-style-type: none"> Using an 80-grade abrasive belt, remove the remaining weld nugget from the interior panel. 	  <p>3M™ File Belt Sander 3M™ Cubitron™ II File Belt, grade 80+</p>
Surface Preparation		<ul style="list-style-type: none"> Clean and prep remaining mating flanges on the host and the replacement panel with a coarse non-woven belt where necessary. Clean and apply weld-thru primer to all areas requiring welding to ensure proper corrosion protection. 	   <p>3M™ File Belt Sander Scotch-Brite™ Durable Flex Belt, CRS 3M™ Weld Thru II Primer</p>
Mig Plug Weld Dressing		<ul style="list-style-type: none"> Use a 80-grade abrasive belt to dress replacement MIG welds. Grind weld. <p>Note: Use caution to avoid damage to adjacent areas.</p>	  <p>3M™ File Belt Sander 3M™ Cubitron™ II File Belt, grade 80+</p>
Continuous Weld Dressing		<ul style="list-style-type: none"> Use a 3 in. 60-grade grinding disc to dress continuous MIG welds at the sectioning joint. Grind weld. <p>Note: Use caution to limit the amount of grinding done to adjacent areas.</p>	  <p>3M™ Pistol Grip Disc Sander 3M™ Cubitron™ II Roloc™ Fibre Disc, grade 60+, 3 in</p>
Weld Cleaning		<ul style="list-style-type: none"> Use a non-woven belt to clean the weld site in preparation for subsequent operations. 	  <p>3M™ File Belt Sander Scotch-Brite™ Durable Flex Belt, CRS</p>