


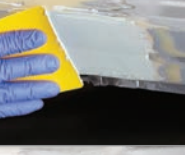








Aluminum Repair Procedures

Sealing and Coating

Anti Chip Coating

1		<p>Pre-Cleaning Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p>Removal of Heavy Surface Contaminates Clean to remove heavy contaminants from repair area.</p>
3		<p>OEM Coating Removal Remove OEM coating as needed using Clean N Strip disc. Featheredge using grade 80 abrasive on DA sander. Blow off surface with clean, dry air. Clean surface with all purpose cleaner and degreaser.</p>
4		<p>Filling/Leveling Surface Use polyester glaze to fill the repair area, bringing it the same level as the surrounding coating.</p>
5		<p>Sanding and Primer Sand glaze using P150 on a hand block. Final featheredge area using P320 abrasive on a DA sander. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover. Apply primer following paint company recommendations.</p>
6		<p>Sanding Primer Apply 3M guide coat to primed surface. Sand primer using P320 on a DA sander with an interface pad. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover.</p>
7		<p>Masking Apply soft edge foam masking tape following existing coating edge. Final mask the area using tape and paper to protect from overspray.</p>
8		<p>Coating Test Panel Apply the coating to a test panel. Always apply a light coat first, allow it to flash, and adjust the spray equipment to deliver the texture required to match the OEM appearance.</p>
9		<p>Apply Coating Apply anti chip coating to the repair area using settings from test panel, blending the material into surrounding area as needed.</p>
10		<p>Blend Sanding Use P1000 3M Trizact™ Disc on a DA sander to smooth the blend edges. This operation produces a smooth transition without removing chip coating profile.</p>

Visit www.3MCollision.com for more SOPs and videos

Product List

3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377

3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350

3M™ General Purpose Adhesive Cleaner, aerosol, PN 08987; Adhesive Remover, PN 38983

Scotch-Brite™ Roloc™ + Clean N Strip XT Disc, PN 07470; TR Disc, PN 07466

3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 80+ grade, PN 31371

3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180; Glaze for DMS, PN 05862

3M™ Hookit™ Purple Clean Sanding Sheet Roll, 150 grade, 70mm x 12m, PN 30710; Disc 334U, 6 in., P320 grit, PN 01812

3M™ Hookit™ Sanding Block Dust Free, 70mm x 127mm, PN 05207

3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861

3M™ Hookit™ Soft Interface Pad, 6 in. x 1/2 in. x 3/4 in., PN 05777

3M™ Soft Edge Foam Masking Tape PLUS, 21mm (.8 in.), PN 06293

3M™ Smooth Transition Tape, 1/4 in. (6.4mm), PN 06800

3M™ Scotchblok™ Masking Paper, 18 in. x 180 ft., PN 06738

Scotch® Performance Green Masking Tape 233+, 12mm width (.47 in.), PN 26332

3M™ Rocker Protector Pouch, 3 fl. oz. (US), PN 08733; 5.5 fl. oz. (US), PN 08734

3M™ Paintable Undercoating, — Waterbased — Pouch, 5.5 fl. oz. (US), PN 08744

3M™ Trizact™ Hookit™ Blending Disc, 6 in., P1000 grit, PN 02090

Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

3M™ Respirator Assembly/Organic Vapor N95 Dual Cartridge, PN 07192

3M™ Lexa™ Protective Eyewear, PN 15200

