

Aluminum Repair Procedures

Body Repair

Small Damage Repair

1



Pre-Cleaning

Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Initial Prep Sand

DA sand the repair area using grade 80 abrasive, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.

3



Mix and Apply Filler

Mix and apply filler per manufacturer's recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F.

4



Sand Filler

Using a hand block, shape sand the body filler with P80 abrasive. Apply dry guide coat and finish block sanding with P150 abrasive. DA featheredge the repair area with P180 abrasive disc. Inspect the repair for quality, if glaze is not required, continue to Step 7.

5



Mix and Apply Glaze

Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer's recommendation or using 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.

6



Sand Glaze

Sand polyester glaze with P180. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7



Final Sand and Inspect

Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.

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™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+ grade, PN 31361; 6 in., 80+ grade, PN 31371



3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863



3M™ Hookit™ Purple Clean Sanding Sheet Roll, 70mm x 12m, 80 grade, PN 30713; 150 grade, PN 30710; 180 grade, PN 30709



3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180



3M™ Platinum Glaze for DMS, PN 05862



3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374



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



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



Note: Use caution when working on aluminum parts. Use tools that have been cleaned properly or designated for use on aluminum to reduce potential cross contamination. Do not re-use abrasives that were previously used on steel repairs.

Protect Your Repairs

Corrosion protection is recommended for this type of repair.

Protect repairs with a self-healing, non-hardening formula

- 3M Cavity Wax Plus, PN 08852
- 3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851



All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax.

Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at www.3MCollision.com

For product material safety data sheets see go.3M.com/SDS

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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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