



ALUMINUM DAMAGE REPAIR

BEST PRACTICE

Clean the Vehicle

Prior to disassembly, wash and clean vehicle, and power wash near repair if needed.

Objective: Eliminate contaminants, discover additional damage to up-sell the repair and prevent unjustified claims.



RECOMMENDED PRODUCTS

DESCRIPTION	PART #
Mothers Auto Wash 1 Gallon	078175- 80138
Mothers Auto Wash 5 Gallon	078175- 80145
Mothers All Purpose Cleaner 1 Gallon	078175- 87138
Mothers All Purpose Cleaner 5 Gallon	078175- 87145

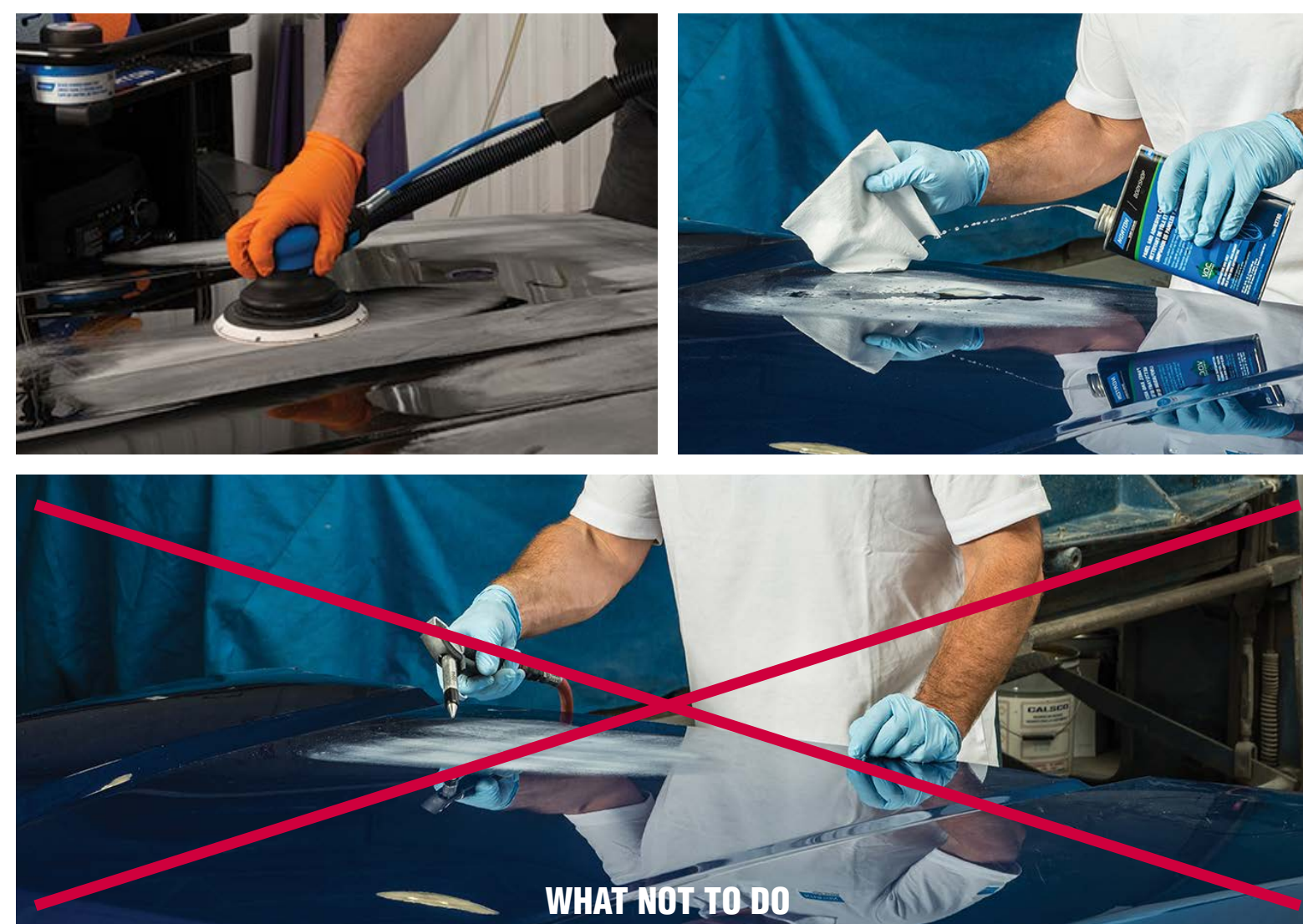
Initial Prep Sand

Sand repair area with an 80 grit abrasive, removing the paint beyond the damage by 1-2 inches.

Remove coating using Norton Vortex Rapid Blend Disc

Using a DeVilbiss lint-free wipe, clean the panel after sanding using Norton Panel Adhesive Cleaner.

Objective: Round off the coarse grit scratch on the bare aluminum to prevent bridging. This will eliminate primer shrinking into scratches and reduce pinholes. It will also prepare the paint edge to receive premium filler.



DESCRIPTION	PART #
Multi-Air Cyclonic 6"	776960- 07770
Norton Panel and Adhesive Cleaner	076607- 82780
DeVilbiss Lint-Free Wipe	803657
2" Norton Vortex Rapid Blend Disc	666233- 34782
3" Norton Vortex Rapid Blend Disc	666233- 34783
Norton Vac Rack	699573- 12400
6" Norton Orbital Sander 6mm throw	699573- 12633
6" Norton Orbital Sander 3mm throw	699573- 12636

Mix and Apply Filler

Mix filler on a non-porous mixing board using recommended hardener ratio. Slice and fold in hardener. Do not stir or flip rapidly. Pull out dent, apply filler to panel being careful to keep the body filler within the bare metal area.

Objective: Smooth mixing and application will help eliminate or reduce pinholes.



DESCRIPTION	PART #
Mixing Spreader	636425- 06396

Block or Sand the Body Filler

Apply guide coat then begin sanding with 80 grit file, block or DA. Finish sand the body filler to eliminate any pinholes and low spots. Wipe off the excess debris.

Objective: To level the filler and improve the surface finish.

Tip: Reapply guide coat as needed to identify pin holes and low spots.



2-3/4" 80 GRIT PRODUCTS	PART #
PSA BlueFire Body File	662611- 23608
Clip-On BlueFire Body File	662611- 23620
NorGrip BlueFire Body File	662611- 23614
PSA Dry Ice A975 Sheet Roll	662611- 49566
NorGrip Dry Ice A975 Sheet Roll	636425- 06261
P80C 16-1/2" (Vacuum) Body File Sheet	699573- 94463
P80C 8" (Vacuum) Body File Sheet	699573- 94470
P80C 5" (Vacuum) Body File Sheet	699573- 94456
16-1/2" (Vacuum) Multi-Air Hand Blocks	699573- 94448
8" (Vacuum) Multi-Air Hand Blocks	699573- 96646
5" (Vacuum) Multi-Air Hand Blocks	699573- 96645
NorGrip Sanding Board	636425- 52836
Black Powder Coat with Applicator	666233- 34772
Carbon Guide Coat	076607- 21938

Feather Edge and Apply Putty or Glaze

Feather edge the filler and surrounding paint with a DA using 180 grit. Sand from high toward low areas / from center toward outer edge. Clean off with lint-free wipe. Apply a skim coat of Putty or Glaze over the repair area, overlapping the paint feather edge. Sand the glaze with 180 grit, apply guide coat and continue sanding to remove any pinholes or high spots. Finish sanding with 320 grit (or the grit recommended as per the paint manufacturer's guidelines) then wipe off debris and examine for coarse sand scratches, pinholes or low spots.

Objective: Improve finish and eliminate solvent penetration under the edge of the repair area.



DESCRIPTION	PART #
PSA P180 Disc Roll	662611- 40508
NorGrip 6" P180	662611- 40528
NorGrip 6" Multi-Air Cyclonic P180	776960- 07775
PSA P320 Disc Roll	662611- 55374
NorGrip 6" P320	662611- 49543
NorGrip 6" Multi-Air Cyclonic P320	776960- 07781