

Aluminum Panel Removal

1



Clean

Clean the panel prior to disassembly with soap and water followed by a VOC compliant surface cleaner.

2



Sealer/Coating Removal

If necessary, use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas. For hard to reach areas use a CRS grade Scotch-Brite™ Belt.

3



Rivet/Spot Weld Removal — Belt Grinder

Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge (e.g., stop grinding when the back of belt is flush with exterior panel). **Note: During application, follow OEM recommended procedures for removal of rivets and/or other fasteners.**

4



Panel Separation

Separate exterior panel from the host panel. **DO NOT** force separation in areas where the weld isn't completely removed. Go back to Step 3 and finish weld removal before continuing.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378



3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987



Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, 4 in. x 1/2 in., Extra Coarse, PN 07470



Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, 4 in. x 1/2 in., Extra Coarse, PN 07466



3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573



Scotch-Brite™ Durable Flex Belt, 1/2 in. x 18 in., Coarse, PN 64475



3M™ Green Corps™ Reinforced Weld Grinding Wheel, PN 01991



3M™ Cut-Off Wheel Tool, 3 in., PN 33579



3M™ Cubitron™ II File Belt, 1/2 in. x 18 in., grade 80+, PN 33446



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872



Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Individual Product Instruction and Safety Information

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

For product material safety data sheets see 3MCollision.com

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Warranty, Limited Remedy and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

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.



3M Automotive Aftermarket Division
3M Center, Building 223-6N-01
St. Paul, MN 55144-1000
U.S.A.

3M, Accuspray, Dynatron, E-A-R, Green Corps, Highland, Hookit, Lexa, Perfect-It, Platinum, Roloc, Scotch, Scotchblok, Scotch-Brite, Skull Screws, Trizact and Virtua are trademarks of 3M Company. Marson is a trademark of Alcoa, Inc. Metton is a trademark of Metton America, Inc.

3MCollision.com

Please recycle. Printed in U.S.A. © 3M 2017. All rights reserved.