



ALUMINUM PART REPLACEMENT

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

Sealer/Coating Removal

Based on accessibility, use a belt file tool with Bear-TEX coarse belt or disc sander with Rapid Strip disc to remove seam sealers and coatings where necessary.

Note: Use caution when working with aluminum parts. Dedicated cutting tools and abrasives for aluminum must be used to prevent cross contamination (which could result in galvanic corrosion). Ensure adequate ventilation to eliminate risk of explosion.



DESCRIPTION	PART #
Bear-TEX Portable Belt File - Coarse (Brown)	662610- 55309
2" TR 80 Grit Back-Up Pad	662611- 62324
3" TR 80 Grit Back-Up Pad	662611- 62342
2" TR Blaze Rapid Blend	666233- 38632
3" TR Blaze Rapid Blend	666233- 38633

Panel Preparation

Remove the remaining rivet/spot weld material from the substrate using an 80 grit abrasive belt. Prep remaining mating flanges with a coarse grit Bear-TEX belt.

Tip: Note that when grinding steel rivets or spot welds that are bonded to aluminum, be aware of contamination from metal shavings that must be removed from the repair area to prevent galvanic corrosion. Encouraged practices include vacuuming or wipe down of area.



BLAZE FILE BELTS	PART #
80 Grit Blaze File Belt	699573- 98023
Bear-TEX Portable Belt File - Coarse (Brown)	662610- 55309

Panel Separation

After referring to the OEM's heat range specifications, remove the exterior panel from original substrate. Based on the OEM's recommendations, cut sections off as needed.



MEDALLION CUT-OFF BLADES	PART #
3" x 1/32" x 3/8"	076607- 89032
3" x 1/16" x 3/8"	076607- 89030
3" x 3/16" x 3/8"	076607- 89034

Surface Preparation

To ensure the surface is ready for adhesive/bonding, repeat process as outlined in Aluminum Rivet Bonding poster as necessary.



DESCRIPTION	PART #
80 Grit Blaze File Belt	699573- 98023
Bear-TEX Portable Belt File - Coarse (Brown)	662610- 55309

Part Installation

Follow installation instructions as per OEM recommendations. Part installation may include adhesives.



SPEED-GRIP	PART #
Metal Door Skin Bonding	636425- 06419
Metal Panel/Weld Bonding	636425- 06420
30 Minute Panel Bonder	636425- 06418
90 Minute Panel Bonder	636425- 06421



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