Standard Operating Procedures Body Repair

Steel Part Replacement **Pre-Cleaning** Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair). **Panel Cutting** Identify OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim repair area using preferred cut-off wheel. Use grade 36 or 60 file belt in hard to reach areas to cut top panel and avoid damage to Sealer/Coating Removal Use Scotch-Brite™ Clean and Strip disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations. **Spot Weld Removal** Using grade 36, 60, or 80 abrasive belt, grind spot weld to remove weld from top panel. Note top panel thickness. Use caution when grinding to only grind top panel and limit cutting into host/interior panel. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. Grade 80 belt can be used to remove welds from thinner steels. **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 4 and finish weld removal before continuing. Surface Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Surface Preparation Clean and prep remaining mating flanges on host and replacement panel with a coarse Scotch-Brite™ Belt where necessary. MIG Plug Weld Dressing Use a grade 80 abrasive belt to dress replacement MIG welds. Grind weld. Use caution to avoid damage to adjacent areas. Continuous Weld Dressing Use a 3 in. grade 60 grinding disc to dress continuous MIG welds at sectioning joint. Grind weld. Use caution to limit amount of grinding done to adjacent areas. Weld Cleaning

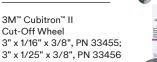
Product List

Meguiar's® Shampoo Plus, 1 gallon, PN D11101

Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701



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





Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552



Scotch-Brite[™] Roloc[™]+ Clean and Strip XT Pro Extra Cut Disc. PN 21555



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



3M™ Cubitron™ II File Belt, grade 36+, PN 33443;



grade 60+, PN 33445; grade 80+, PN 33446

3M™ Pistol Grip Disc

Sander, PN 33577



3M™ Cubitron™ II Roloc™ Fibre Disc, grade 60+, 3 in., PN 33391



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective

Eyewear, PN 11326

Note: Follow High Strength steel heat control recommendations and techniques when necessary.

Visit 3MCollision.com for more SOPs and videos

Use a CRS Scotch-Brite™ Belt to clean weld site in preparation for subsequent operations.

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

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