









Aluminum Dent Repair		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Initial Prep Sand</b> DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Clean the surface with an approved low VOC surface cleaner.</p>
<b>3</b>		<p><b>Final Metal Prep</b> Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N Strip disc. Use a 3 in. grinding disc to remove weld nuggets or other surface imperfections. Clean the surface with an approved low VOC surface cleaner.</p>
<b>4</b>		<p><b>Mix and Apply Filler</b> 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.</p>
<b>5</b>		<p><b>Initial Sand Filler</b> Block shape sand filler with P80. DA rough featheredge area with P80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.</p>
<b>6</b>		<p><b>Final Sand Filler</b> Final block sand filler with P150 abrasive. DA fine featheredge sand the repair area with P180 abrasive and clean the surface with an approved low VOC surface cleaner applied to a clean towel. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Mix and Apply Glaze</b> Mix and apply glaze if required per manufacturer’s recommendation or if using the 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.</p>
<b>8</b>		<p><b>Sand Glaze</b> Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.</p>
<b>9</b>		<p><b>Final Sand and Inspect</b> Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.</p>

The Festool mobile dust extractor is not approved for use with aluminum dust. Adapt sander to a non-vacuum airline. PN 29917.

## 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™ Cubitron™ II Fibre Roloc™ Disc, 3 in., 80+ grade, PN 33392

3M™ Roloc™+ Holder, PN 07500

Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470

Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466

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

3M™ Platinum™ Plus for DMS, 05862

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

3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 80+ grade, PN 34442; 150+ grade, PN 34445; 180+ grade, PN 34446

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

## 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.