

## CUBITRONII

## 3M Steel Panel Replacement Process

## **PERSONAL SAFETY**

• Comfort Particle Mask P2



Hearing Protection



• Face Protection



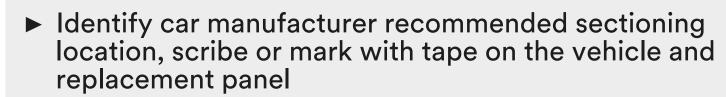
Reusable Workwear



• Safety Gloves







► Trim repair area using preferred cut-off wheel



**Cut-Off Wheels** 

Replacement Panel Preparation



► Clean and prep remaining mating flanges on replacement panel with a Scotch-Brite™ Belt or Disc where necessary

► Clean and apply weld-thru primer to all areas requiring welding methods for corrosion protection









Sealer/Coating Removal



► Use Scotch-Brite<sup>™</sup> Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations



File Belts

3M™ Scotch-Brite™





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► 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

► Separate exterior panel from the host panel after additional pre cut









► Identify final cut line at the overlapping area of the pre cutted host and replacement panel

► Trim repair area using preferred cut-off



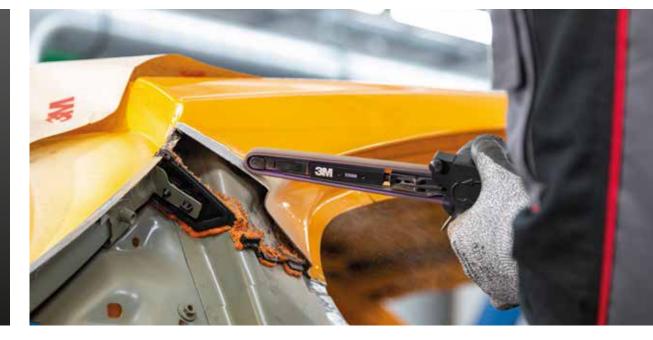
File Belts 60+ - 80+

3M™ Cut-Off Wheel Tool ø 75 mm, ø 100 mm



3M™ Cubitron™ II **Cut-Off Wheels** 





► Clean and prep remaining mating flanges on replacement panel with a Scotch-Brite™ Belt or Disc where necessary

► Use caution to limit amount of grinding done to adjacent areas in terms of substrate thickness

► Clean surface and apply weld-thru primer to all areas requiring welding methods for corrosion protection



File Belts



Roloc™ Disc



3M™ File Belt Tool



Panel Bonding



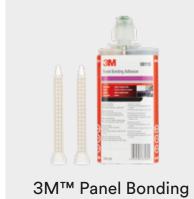
► Apply adhesive to mating flange areas on host panel and replacement panel as recommended from car manufacturer by covering all bare metal areas

► Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness

► Note: A new cartridge needs to be callibrated as recommended before the first application, to allow initial equalisation! Any further material from there is good to use

► Using car manufacturer recommended welding methods

at the different areas of the car body lines



3M™ Pneumatic Applicator for 200ml Adhesive

**Duopack Cartridge** 



Cartridge

Welding



► Use 80+ grit to equalize WPS welding spots and MIG brazing joints

► Fine sanding of weld site in preparation for subsequent operations

► Use caution to limit amount of grinding done to adjacent areas in terms of substrate thickness







3M™ File Belt Tool

