Aluminum GPR

Advanced GPR Techniques for Aluminum

THE 6C's

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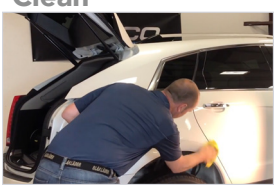
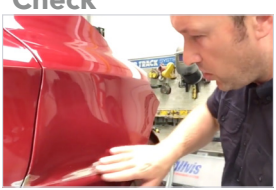
1. Clean
2. Check
3. Choose
4. Coat
5. Correct
6. Continue

1Clean



Start with a polishing compound.
Always start with light polishing compound to ensure the best possible adhesion. Finish cleaning with 99% alcohol as normal.

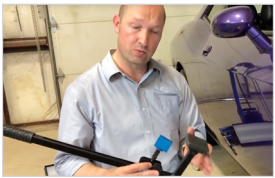
2Check



Warm your panel & tabs.
Always warm the panel to 125°F - 150°F before pulling for maximum adhesion.

Always warm tabs to 110°F - 130°F for maximum adhesion

3Choose



What tabs?

Aluminum is very stiff & does NOT take a permanent set easily when pulling. Therefore, it requires a greater surface area tab for a similar result when compared to steel.

It is best to break the rule of choosing a tab smaller than the crowns of the dent. When covering the crowns, the tab must be a flexible Blue nylon tab that will flex with the crown & not lock it in. The center shaft/neck of the tab then becomes the effective size of the tab. Therefore, it is vital to size the center shaft/neck portion of the tab to stay within the crowns of the dent while the flexible edges of the tab are left to cover the crowns as previously mentioned.

What lifter?

Choose a lifter with large surface area feet if possible to hold down the surrounding aluminum firmly as an aggressive pull is made.

4Coat

More glue is better.
Coat completely. Glue squeezing out on all sides of the tab is recommended.

5Correct

Use aggressive pulls and hard knockdowns.
Technicians must err on the side of over pulling with aluminum because it does not take a permanent set as easily as steel. It tends to spring back to original pre pull condition. The pull should be aggressive enough as to expect to over pull if pulling on normal steel.

Consider warming the panel to 150F to knockdown the high spots.

Use a smaller & harder knockdown than typical for steel.