

# Aluminum Alloy Repair

## List of "Dos" and "Don'ts"

### 1. Sanding work

- 1) Don't use the same sanding tools or sandpaper for both aluminum alloy sheets and steel plates.
- 2) Do operate the sanding tool at a low speed; don't operate continuously as this heats the surface of the metal.
- 3) Don't use clogged sanding tools or sandpaper.
- 4) Do use a stainless steel wire brush; don't use an iron wire brush.

### 2. Welding work

- 1) Don't forget to clean and sand the weld zones.
- 2) Do check welding conditions using a test piece prior to welding; don't start welding body areas without preparation.
- 3) Don't use electrode wire other than A5356WY.
- 4) Don't use shielding gas other than 100% argon gas.
- 5) Do keep electrode wire in airtight containers and store in a dry, constant temperature location; don't use wire that has been left around for a long time.
- 6) Don't use acetylene or oxygen gas welding or brazing.

### 3. Sheet metal work

- 1) In structural areas that have been damaged or buckled, do replace any parts with cracks; don't repair cracked parts after frame straightening.
- 2) Do repair buckled areas by heating them in controlled temperature, don't try to extend them when cold.
- 3) Don't clamp anything directly without protection.
- 4) Don't use a serrated face hammer.
- 5) Don't perform soldering (leading) shaping.
- 6) Don't forget to apply an epoxy primer before puttying.

### 4. Assembly work

- 1) Do use only the designated nuts and bolts; don't use any part which has not been coated with [DACRO] or [DACRO + TORQUER] .

### 5. Inspection

- 1) Don't forget to check for cracks after frame straightening and after welding.