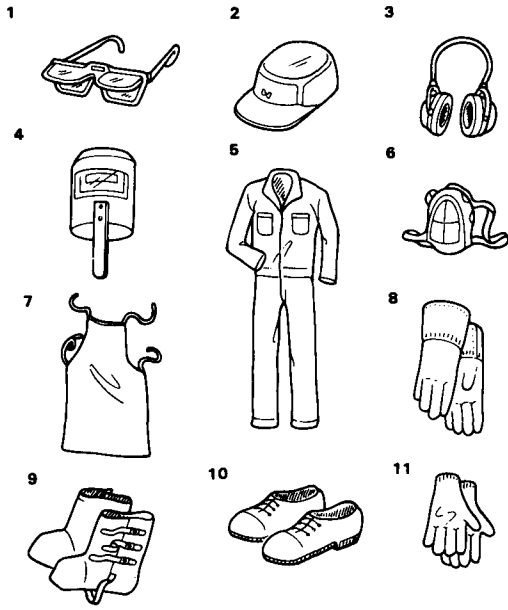
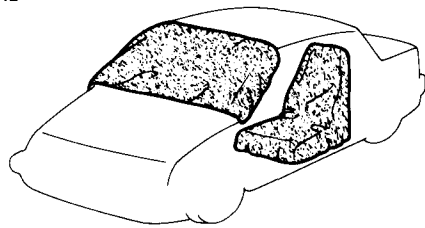
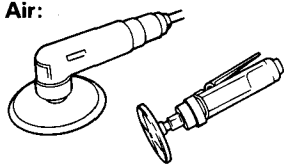
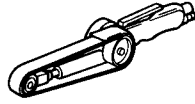
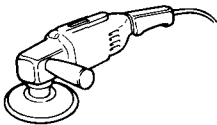
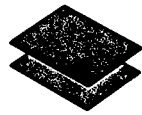



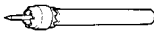



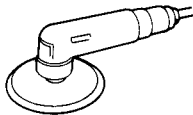
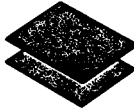
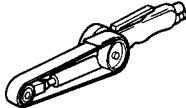
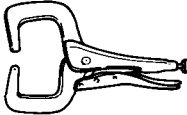

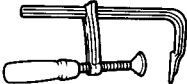
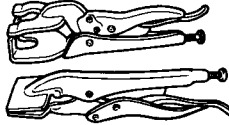



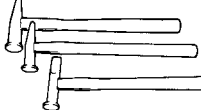
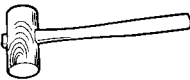






Examples of Repair Tools

Item	Work	Tools, equipment used
Protective equipment	Operator protection	<p> 1. Protective goggles 2. Cap 3. Ear plug 4. Shield for eyes 5. Overalls with long sleeves 6. Dust-proof mask </p> <p> 7. Protective apron 8. Welding gloves 9. Foot protectors 10. Safety shoes 11. Work gloves 12. Spattering guard </p> 
	Vehicle body protection	<p>Heat-resistant protective cover</p> 
Processing tools	Edge preparation	<p>DISC GRINDER, DISC SANDER.</p> <p>Air:</p>  <p>BELT SANDER</p>  <p>Electric:</p>  <p>SANDPAPER, FILES</p> 

(cont'd)

Aluminum Alloy Repair

Examples of Repair Tools (cont'd)

Item	Work	Tools, equipment used	
Processing tools	Plug hole drilling	DRILLING BLADE, DRILL, SPOT CUTTER   ROTARY CUTTER 	PUNCH 
Sanding tools	Cleaning	STAINLESS STEEL WIRE BRUSH  DISC SANDER 	SANDPAPER  BELT SANDER 
	Finishing	Disc grinder, Disc sander, Belt sander, Sandpaper.	
Fixing tools	Base metal fixing	WISE-GRIPS   SCREW CLAMP 	  SQUILL VISES 
Shaping tools	Skin panel shaping	HAMMERS   	DOLLIES/CHISELS      

NOTE: Use a stainless steel wire brush and sanding tools reserved especially for aluminum alloys. Do not use the same tools for steel sheet.

Grain size for sanding/processing tools and jobs performed.

Tool	Disc paper grain size	Job
Disc grinder	A36P (grindstone for grinder)	<ul style="list-style-type: none">• Roughing of weld reinforcement areas.• Roughing of V-shaped edge preparation.
Disc sander	#80~#120 (sanding disc)	<ul style="list-style-type: none">• Roughing of paint film.• Sanding of aluminum alloy surface (oxide film)• Finishing of weld reinforcement areas.• Finishing of V-shaped edge preparation.
Belt sander	#80 or above	<ul style="list-style-type: none">• Sanding of narrow areas.
Stainless steel wire brush		<ul style="list-style-type: none">• Sanding of aluminum alloy surface (oxide film)

NOTE:

- Use a low-speed disc grinder or disc sander.
- If a low-speed air-powered disc grinder is not available, attach an air control valve to reduce grinder speed.
- A double-action sander may also be used.

Cleaning-oxide film removal:

Clean the welding locations thoroughly (both front and back surfaces).

- Use a wax and grease remover to clean off any dirt, oil or grease.
- Use a disc sander and stainless steel wire brush to remove paint and oxide films. Use a #80 sanding disc.

NOTE: Do not allow the sanding disc of the disc sander to become clogged. If the disc sander is pressed excessively hard, it will overheat due to friction and the aluminum alloy will tend to peel off, clogging the disc. The alloy surface will be scraped and scored if a clogged disc is used.