



**1** Gather your tools.



**2** Study the damage and develop a repair plan.



**3** Rough out the damage and smooth, carefully avoiding as much stretching as possible.



**4** Remove the paint from the repair site and identify the highest spot. This will be the site of your first shrink. After making your first shrink and cooling, the next highest spot will be the site of your next shrink, and so on.



**5** Adjust your torch to a neutral JOF (Just Off Feather) flame. The acetylene regulator should be at 5-7 pounds and oxygen at 12-15 pounds. Use a small tip for more control.

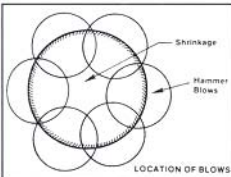
**6** Heat a small dime-to quarter-size spot (smaller is better) on the highest stretched area to a cherry red color, in a tight circular motion. Keep it small. Hold the flat side of the dolly lightly on the backside of the hot spot, while heating.



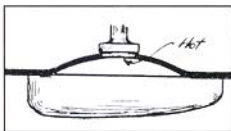
**7** Quickly place the torch in the holder.



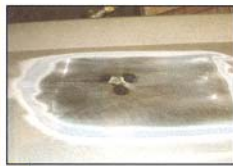
**8** Quickly pick up the hammer, and hammer around the hot spot, in the pattern shown below.



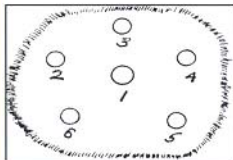
Back up the shrink area using the hammer-off-dolly (flat side) technique, as shown below.



**9** Immediately cool the area with compressed air to control warpage and assist in the shrinking process.



**10** Move to the next highest spot (usually in a circular pattern) and repeat heat, hammer and dolly process with air cooling. Shown below is the sequence of heats in metal shrinking.



**11** Sand the area with an 80-grit disc for finishing.