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Applied to Life.™



# Standard Operating Procedures

Heavy Duty Truck Repair  
Europe

3M Automotive Aftermarket Division



# Process for Success

## Standard Operating Procedures

From metal and plastic repair, to sanding, paint finishing and truck clean-up, 3M has the products and repair processes for you. Feel confident your repair is done professionally and efficiently using our **Standard Operating Procedures**. These procedures will help you consistently produce quality, time-proven results for any of your collision repair needs.

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**Aluminium Panel Removal**

**1**



**Clean**

Clean the panel prior to disassembly with soap and water followed by a surface cleaner.

**2**



**Sealer/Coating Removal**

If necessary, use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas.

**3**



**Rivet/Spot Weld Removal — Belt Sander**

Use 80+ grade abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge (e.g. stop grinding when the back of belt is flush with exterior panel). **Note: During application, follow OEM recommended procedures for removal of rivets and/or other fasteners.**

**4**



**Panel Separation**

Separate exterior panel from the host panel. **DO NOT** force separation in areas where the weld isn't completely removed. Go back to Step 3 and finish weld removal before continuing.

**Product List**

3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893



3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573



3M™ Scotch-Brite™ Roloc™ Surface Conditioning Disc, 50mm, PN 07480; PN 07481



3M™ Cubitron™ II Roloc™ Fibre Disc, 80+ grade, 50mm, PN 33380; 75mm, PN 33392



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Cubitron™ II File Belt, 13mm x 457mm, 80+ grade, PN 33446



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503




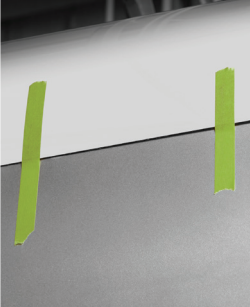
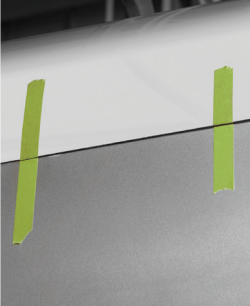

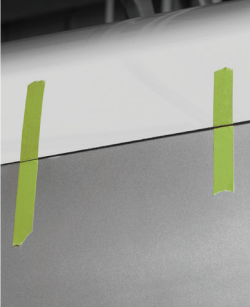
3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Use only tools that have been cleaned properly or are designated for use on aluminium to reduce potential cross contamination. **DO NOT** re-use abrasives that were previously used on steel repairs.

**Aluminium Panel Installation: Adhesive**

<p><b>1</b></p>		<p><b>Clean</b> Wash the truck and repair area prior to disassembly with soap and water followed by a surface cleaner.</p>
<p><b>2</b></p>		<p><b>Dry Fit Panel</b> Dry fit all parts to ensure a good fit before dispensing and applying adhesive. <b>Note: Use 36mm tape for alignment markings to determine proper placement and attachment.</b></p>
<p><b>3</b></p>		<p><b>Remove Panel</b> Cut tape between the two panels and remove panel. Use rubber gloves to prevent contamination.</p>
<p><b>4</b></p>		<p><b>Apply Adhesive</b> Apply adhesive to the sanded replacement panel flange. Use rubber gloves to prevent contamination.</p>
<p><b>5</b></p>		<p><b>Fit Panel</b> Fit panel to the existing truck side panel and slide if necessary to align to 36mm tape. <b>Note: Always slide panel and never pick up panel away from bonding surface.</b> Apply clamps.</p>

**Product List**

3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



Scotch® Premium Automotive Refinish Masking Tape 3030, 36mm width, PN 50980



3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895  
24mm x 50m, PN 07897  
36mm x 50m, PN 07898  
48mm x 50m, PN 07899



3M™ Panel Bonding Adhesive, 200mL, PN 08115



3M™ Impact Resistant Structural Adhesive, 200mL, PN 07333



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100




3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



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Aluminium Dent Repair		
<b>1</b>		<p><b>Pre-Cleaning</b></p> <p>Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Initial Prep Sand</b></p> <p>DA sand the repair area using 80+ grade, removing paint beyond damage by 5–10cm. Clean the surface with an approved surface cleaner.</p>
<b>3</b>		<p><b>Final Metal Prep</b></p> <p>Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N Strip disc. Use a 75mm grinding disc to remove weld nuggets or other surface imperfections. Clean the surface with an approved surface cleaner.</p>
<b>4</b>		<p><b>Mix and Apply Filler</b></p> <p>Mix and apply filler per manufacturer’s recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 23°C.</p>
<b>5</b>		<p><b>Initial Sand Filler</b></p> <p>Sand filler with hand block and 80+ grade abrasive. DA rough featheredge area with 80+ grade abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.</p>
<b>6</b>		<p><b>Final Sand Filler</b></p> <p>Final block sand filler with 150+ grade abrasive. DA fine featheredge sand the repair area with 180+ grade abrasive and clean the surface with an approved surface cleaner applied to a clean towel. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Mix and Apply Glaze</b></p> <p>Mix and apply glaze if required per manufacturer’s recommendation. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 23°C.</p>
<b>8</b>		<p><b>Sand Glaze</b></p> <p>Block sand glaze with 180+ grade abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.</p>
<b>9</b>		<p><b>Final Sand and Inspect</b></p> <p>Featheredge the surrounding area using 180+ grade abrasive. Inspect the repair for quality.</p>

It is recommended to use the Festool mobile dust extractor for aluminium, PN 575106.

Product List
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369</p> 
<p>3M™ DMS Heavy General Purpose Body Filler, PN 51003</p> 
<p>3M™ Cubitron™ II Roloc™ Fibre Disc, 75mm, 80+ grade, PN 33392</p> 
<p>3M™ Roloc™+ Holder, PN 07500</p> 
<p>3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893</p> 
<p>3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809</p> 
<p>3M™ Premium Glaze, 910ml, PN 51212</p> 
<p>3M™ DMS Lightweight Filler PN 51004</p> 
<p>3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator</p> 
<p>3M™ Cubitron™ II Hookit™ Sheet, 80+ grade, PN 51411; 150+ grade, PN 51413; 180+ grade, PN 51414</p> 
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Disc, 150mm, 180+ grade, PN 51422</p> 

Think About Your Health
<p>3M™ Disposable Ear Plugs, PN 1100</p> 
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p> 
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p> 
<p>Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>

**Composite Panel Removal and Installation**

1		<p><b>Clean the Panels</b></p> <p>Clean panels with soap and water followed by a surface cleaner. Thoroughly dry the parts. <b>DO NOT</b> apply any other cleaners throughout the remainder of the removal and installation procedure.</p>
2		<p><b>Panel Removal</b></p> <p>Heat the bond line to 120–150°C and gently pry the panels apart with a rigid putty knife or equivalent. Remove all adhesive from the undamaged part using the same process as below. Let the surface cool.</p>
3		<p><b>Surface Prep</b></p> <p>Sand the surfaces to be bonded using 60+ grade 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a low speed to rough up the area, or 80+ grade abrasive disc on a DA. Blow off the repair area with clean, dry air and a clean cloth. <b>Note: If flame heat was used to help separate panels it's a must that the after burn be removed with a 80+ grade abrasive disc.</b> For metal parts, nothing coarser than 80+ grade is necessary.</p>
4		<p><b>Dry Fit Parts</b></p> <p>Dry fit all parts to ensure a good fit before dispensing and applying adhesive.</p>
5		<p><b>Apply Adhesive</b></p> <p>Follow the Directions for Use to prepare, mix and apply 3M™ Panel Bonding Adhesive. Apply a continuous bead to one part. <b>Note: If you need to adjust the part, slide the part to prevent air pockets in the adhesive bead.</b></p>
6		<p><b>Bond</b></p> <p>Line up the parts. Apply clamps to the bonded panel surface and clamp within the desired area. <b>Note: Apply as many clamps as needed to bring the panels together. Make sure NOT to over clamp, which can result in squeezing the bondline dry of adhesive.</b> Remove any excess adhesive squeeze out.</p>

**Product List**

3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



3M™ Cubitron™ II Roloc™ Fibre Disc, 60+ grade, 75mm, PN 33391



3M™ Pistol Grip Disc Sander, PN 33577



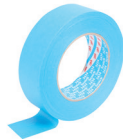
3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369



Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977



3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895  
24mm x 50m, PN 07897  
36mm x 50m, PN 07898  
48mm x 50m, PN 07899



3M™ Flexible Parts Repair Material, 50mL, PN 05901



3M™ Panel Bonding Adhesive, 200mL, PN 08115



3M™ Performance Manual Applicator, 50mL, PN 08190



3M™ Performance Manual Applicator, 200mL, PN 08117



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100




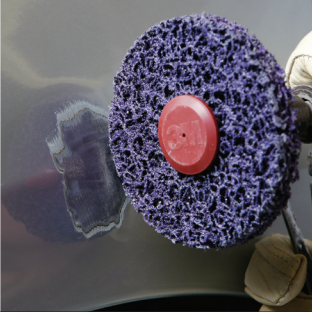
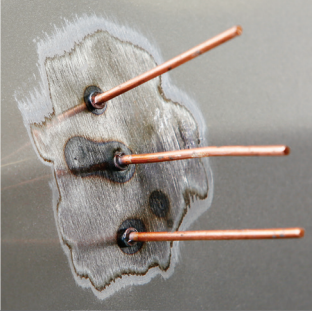


3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF












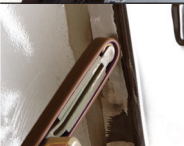
**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Metal Working		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Surface Prep</b> Use a Scotch-Brite™ Clean N Strip disc to remove paint/coating in low points of damage in preparation for dent pulling.</p>
<b>3</b>		<p><b>Dent Pulling</b> Pull low spots of dent using preferred dent pulling method and equipment.</p>
<b>4</b>		<p><b>Final Prep</b> Use a 80+ grade Roloc™ grinding disc to remove weld nuggets from dent pulling operation.</p>
<b>5</b>		<p><b>Clean and Inspect</b> Clean with all purpose cleaner and degreaser. Blow off with clean, dry air. Inspect damage area to determine if additional metal straightening is required.</p>

Product List	
<p>3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893</p>	
<p>3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809</p>	
<p>3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573</p>	
<p>Scotch-Brite™ Roloc™ Surface Conditioning Disc, 50mm, PN 07480; PN 07481</p>	
<p>3M™ Cubitron™ II Roloc™ Fibre Disc, 80+ grade, 75mm, PN 33392</p>	

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<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

**Note:** It will be necessary to apply Cavity Wax Plus to back side of panel at heat effected areas to restore corrosion protection.

Steel Part Replacement		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Panel Cutting</b> Identify OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim repair area using preferred cut-off wheel. Use 36+ grade file belt in hard to reach areas to cut top panel and avoid damage to host panel.</p>
<b>3</b>		<p><b>Sealer/Coating Removal</b> Use Scotch-Brite™ Clean N Strip disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.</p>
<b>4</b>		<p><b>Spot Weld Removal</b> Using 36+ grade or 60+ grade abrasive belt, grind spot weld to remove weld from top panel. Note top panel thickness. <b>Use caution when grinding to only grind top panel and limit cutting into host/interior panel.</b> Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. 80+ grade belt can be used to remove welds from thinner steels.</p>
<b>5</b>		<p><b>Panel Separation</b> Separate exterior panel from the host panel. <b>DO NOT force separation in areas where the weld isn't completely removed; go back to step 4 and finish weld removal before continuing.</b></p>
<b>6<sub>A</sub></b>		<p><b>Surface Preparation</b> Using 80+ grade abrasive belt, remove remaining weld nugget material from host panel.</p>
<b>6<sub>B</sub></b>		<p><b>Surface Preparation</b> Clean and prep remaining mating flanges on host and replacement panel with a coarse Scotch-Brite™ Belt where necessary.</p>
<b>7<sub>A</sub></b>		<p><b>MIG Plug Weld Dressing</b> Use 80+ grade abrasive belt to dress replacement MIG welds. Grind weld. <b>Use caution to avoid damage to adjacent areas.</b></p>
<b>7<sub>B</sub></b>		<p><b>Continuous Weld Dressing</b> Use a 75mm 60+ grade grinding disc to dress continuous MIG welds at sectioning joint. Grind weld. <b>Use caution to limit amount of grinding done to adjacent areas.</b></p>
<b>8</b>		<p><b>Weld Cleaning</b> Use a CRS Scotch-Brite™ Belt to clean weld site in preparation for subsequent operations.</p>

Product List	
<p>3M™ Cubitron™ II Cut-Off Wheel, 75mm x 1mm, PN 33456; 75mm x 1.6mm, PN 33455</p>	
<p>3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893</p>	
<p>3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809</p>	
<p>3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573</p>	
<p>Scotch-Brite™ Roloc™ Surface Conditioning Disc, 50mm, PN 07480; PN 07481</p>	
<p>3M™ Cubitron™ II File Belt, 36+ grade, PN 33443; 60+ grade, PN 33445; 80+ grade, PN 33446</p>	
<p>3M™ Pistol Grip Disc Sander, PN 33577</p>	
<p>3M™ Cubitron™ II Roloc™ Fibre Disc, 60+ grade, 75mm, PN 33391</p>	



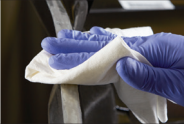




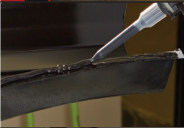




Think About Your Health	
<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

Note: Follow High Strength steel heat control recommendations and techniques when necessary.

Cosmetic Repair (SMC, FRP, Composites)		
<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the repair area with soap and water followed by a surface cleaner making sure to minimise the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. <b>DO NOT</b> apply any other cleaners throughout the remainder of the repair procedure.</p>
<b>2</b>		<p><b>Rough Grind</b></p> <p>Dish out the repair area with a 60+ grade 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a lower speed. Finish dishing out the repair area using a 80+ grade abrasive disc on a DA.</p>
<b>3</b>		<p><b>Feather-edge</b></p> <p>Finish the dish-out process using a 180+ grade abrasive disc and feather well into the surrounding area. Blow off the repair area with clean, dry air and a clean cloth.</p>
<b>4</b>		<p><b>Adhesion Promoter</b></p> <p>SMC and Fiberglass do not require an adhesion promoter. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter, to the repair area. Allow adhesion promoter to dry for 5 minutes before applying the adhesive/filler.</p>
<b>5</b>		<p><b>Apply</b></p> <p>Following product instructions, apply a tight coat of adhesive/filler to the repair area to insure good contact with the composite. Continue to build until the repair area is slightly higher than the surrounding area. For best results heat set at 66°C for 15 minutes.</p>
<b>6</b>		<p><b>Rough Sand and Shape Filler</b></p> <p>Rough shape the filler once it has cooled using a DA or a hand block with an 80+ grade abrasive. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Final Sand and Inspect</b></p> <p>Final DA or block sand the filler with 180+ grade abrasive and feather into the surrounding composite and paint. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Finish sanding with a 220+ grade abrasive sanding well into the surrounding surface. <b>Note: Contact your paint manufacture for final sand preparation.</b></p>

Product List	
3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984	
3M™ Cubitron™ II Roloc™ Fibre Disc, 60+ grade, 75mm, PN 33391	
3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369; 150+ grade, PN 51421; 220+ grade, PN 51423 320+ grade, PN 51426	
3M™ Polyolefin Adhesion Promoter, PN 05917	
3M™ Flexible Plastic Filler 05887	
3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator	

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<b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.	

Weld Bonding (Excluding Door Skin)		
<b>1</b>		<b>Host Panel Preparation</b> Using a 80+ grade abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt to remove all adhesive, corrosion and coatings.
<b>2</b>		<b>Mating Flange Panel Preparation</b> Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.
<b>3</b>		<b>Clean</b> Clean host panel and replacement panel mating flange areas with a surface cleaner.
<b>4</b>		<b>Dry Fit Panel</b> Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
<b>5</b>		<b>Weld-Thru Primer</b> Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.
<b>6</b>		<b>Spot Weld Surface Preparation</b> Identify replacement spot weld sites and remove Ecoat using Scotch-Brite™ belt where spot weld tips will contact host and replacement panel. Remove panel once complete.
<b>7</b>		<b>Pre-Assembly Sound Deadening Replacement</b> If vehicle construction necessitates, apply sound deadening pad or foams at original locations as required.
<b>8</b>		<b>Apply Bonding Adhesive</b> Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange areas.
<b>9</b>		<b>Install Replacement Panel</b> Install replacement panel to host panel. Clamp in place.
<b>10</b>		<b>Spot Weld</b> Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.
<b>11</b>		<b>Adhesive Clean Up</b> Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. <b>Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.</b>
<b>12</b>		<b>Post-Assembly Foam Replacement</b> Apply foams at original locations as required.

**Note:** Follow recommended internal corrosion protection processes prior to vehicle final assembly.

**⚠ WARNING**

Follow OEM and/or welder manufacturers' recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

**Product List**

- 3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573 
- 3M™ Cubitron™ II File Belt, 80+ grade, PN 33446 
- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475 
- 3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893 
- 3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809 
- 3M™ Weld-Thru II Coating, PN 50410 
- 3M™ Sound Deadening Pad, PN 08840 
- 3M™ Flexible Foam, 200mL, PN 08463 
- 3M™ Panel Bonding Adhesive, 200mL, PN 08115 
- 3M™ Flexible Parts Repair Material, 50mL, PN 05901 

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- 3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503 
- 3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF 

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Weld Sealing		
1		<b>Host Panel Preparation</b> Using a 80+ grade abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.
2		<b>Mating Flange Panel Preparation</b> Remove Ecoat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.
3		<b>Clean</b> Clean host panel and replacement panel mating flange areas with a surface cleaner.
4		<b>Straighten Flanges and Dry Fit Part</b> Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
5		<b>Weld-Thru Primer</b> Use Scotch-Brite™ belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.
6		<b>Spot Weld Surface Preparation</b> Identify replacement spot weld sites and remove Ecoat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.
7		<b>Pre-Assembly Sound Deadening Replacement</b> If vehicle construction necessitates, apply sound deadening pad or foams at original locations as required.
8		<b>Apply Seam Sealer</b> Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.
9		<b>Install Replacement Panel</b> Install replacement panel to host panel. Clamp in place.
10		<b>Spot Weld</b> Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.
11		<b>Sealer Clean Up</b> Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. <b>Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.</b>
12		<b>Post-Assembly Foam Replacement</b> Apply foams at original locations as required.

Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.



**WARNING**

Follow OEM and/or welder manufacturers' recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.






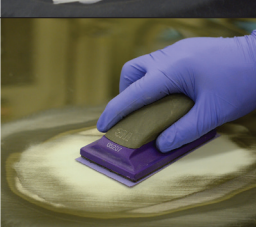

**Product List**

- 3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573 
- 3M™ Cubitron™ II File Belt, 80+ grade, PN 33446 
- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475 
- 3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893 
- 3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809 
- 3M™ Weld-Thru II Coating, PN 50410 
- 3M™ Sound Deadening Pad, PN 08840 
- 3M™ Flexible Foam, 200mL, PN 08463 
- 3M™ Polyurethane Seam Sealer, cartridge, PN 08684; sachet, PN 08782 
- 3M™ Multi-Purpose Seam Sealer, beige, PN 50740 

**Think About Your Health**





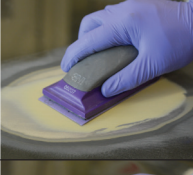




- 3M™ Disposable Ear Plugs, PN 1100 
- 3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503 
- 3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF 

Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Small Damage Repair		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Initial Prep Sand</b> DA sand the repair area using 80+ grade, removing paint beyond damage by 5–10cm. Blow off with clean, dry air and re-clean with surface cleaner.</p>
<b>3</b>		<p><b>Mix and Apply Filler</b> Mix and apply filler per manufacturer's recommendation. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 23°C.</p>
<b>4</b>		<p><b>Sand Filler</b> Using a hand block, shape sand the body filler with 80+ grade abrasive. Apply dry guide coat and finish block sanding with 150+ grade abrasive. DA featheredge the repair area with 180+ grade abrasive disc. Inspect the repair for quality, if glaze is not required, continue to step seven.</p>
<b>5</b>		<p><b>Mix and Apply Glaze</b> Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer's recommendation. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 23°C.</p>
<b>6</b>		<p><b>Sand Glaze</b> Sand glaze with 180+ grade. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Final Sand and Inspect</b> Blow off repair area. Featheredge the surrounding area using 180+ grade abrasive. Inspect the repair for quality.</p>

Product List	
3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369	
3M™ DMS Heavy General Purpose Body Filler, PN 51003	
3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator	
3M™ Premium Glaze, 910ml, PN 51212	
3M™ DMS Lightweight Filler, PN 51004	
3M™ Cubitron™ II Hookit™ Sheet, 80+ grade, PN 51411; 150+ grade, PN 51413; 180+ grade, PN 51414	
3M™ Cubitron™ II Hookit™ Clean Sanding Disc, 150mm, 180+ grade, PN 51422	

Think About Your Health	
3M™ Disposable Ear Plugs, PN 1100	
3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503	
3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

Large Damage Repair		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Initial Prep Sand</b> DA sand the repair area using 80+ grade, removing paint beyond damage by 5–10cm Blow off with clean, dry air and re-clean with surface cleaner.</p>
<b>3</b>		<p><b>Final Metal Prep</b> Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N Strip disc. Use a 75mm grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.</p>
<b>4</b>		<p><b>Mix and Apply Filler</b> Mix and apply filler per manufacturer’s recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 23°C.</p>
<b>5</b>		<p><b>Initial Sand Filler</b> Block sand filler with 80+ grade. DA rough featheredge area with 80+ grade abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.</p>
<b>6</b>		<p><b>Final Sand Filler</b> Final block sand filler with 150+ grade abrasive. DA fine featheredge sand the repair area with 180+ grade abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Mix and Apply Glaze</b> Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer’s recommendation. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 23°C.</p>
<b>8</b>		<p><b>Sand Glaze</b> Block sand glaze with 180+ grade abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.</p>
<b>9</b>		<p><b>Final Sand and Inspect</b> Blow off repair area. Featheredge the surrounding area using 180+ grade abrasive. Inspect the repair for quality.</p>

**Product List**

- 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369 

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- 3M™ DMS Heavy General Purpose Body Filler, PN 51003 

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- 3M™ Cubitron™ II Roloc™ Fibre Disc, 75mm, 80+ grade, PN 33392 

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- 3M™ Roloc™+ Holder, PN 07500 

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- 3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893 

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- 3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809 

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- 3M™ Premium Glaze, 910ml, PN 51212 

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- 3M™ DMS Lightweight Filler, PN 51004 

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- 3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator 

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- 3M™ Cubitron™ II Hookit™ Sheet, 80+ grade, PN 51411; 150+ grade, PN 51413; 180+ grade, PN 51414 

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- 3M™ Cubitron™ II Hookit™ Clean Sanding Disc, 150mm, 180+ grade, PN 51422 

**Think About Your Health**

- 3M™ Disposable Ear Plugs, PN 1100 

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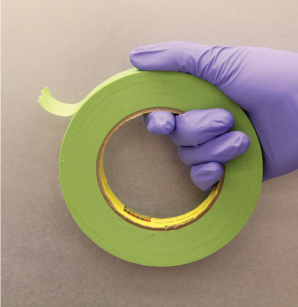



- 3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503 

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- 3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF 

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Seam Sealer Removal**

<p><b>1</b></p>		<p><b>Clean</b> Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<p><b>2</b></p>		<p><b>Protect</b> Protect surrounding areas with masking tape.</p>
<p><b>3</b></p>		<p><b>Method A</b> Use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings where accessible.</p>
<p><b>4</b></p>		<p><b>Method B</b> Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas.</p>
<p><b>5</b></p>		<p><b>Clean</b> Blow off the surface with clean dry air and then use a surface cleaner to remove any remaining residue.</p>

**Product List**

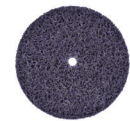
Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977



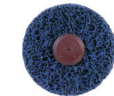
3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895  
24mm x 50m, PN 07897  
36mm x 50m, PN 07898  
48mm x 50m, PN 07899



3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893



3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809



3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Seam Sealer Installation: Over Primer**

**1**



**Surface Prep**

Scuff primer in sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air. **Note: Apply 3M seam sealers only over two-part epoxy or two-part urethane primers.**

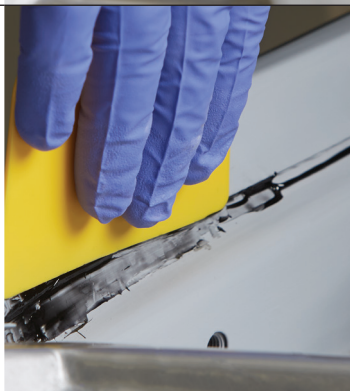
**2**



**Clean**

Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a wax and grease remover. **Note: DO NOT spray or saturate seams with cleaner.**

**3**



**Apply Tight Coat**

Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing and adhesive qualities.

**4**



**Apply Seam Sealer**

Apply seam sealer over the prepared seam. Tool to recreate OEM appearance.

**Product List**

Scotch-Brite™ Hand Pads 7447 PRO, Very Fine grade, 150mm x 229mm, PN 64659



3M™ Polyurethane Seam Sealer, 310mL cartridge, PN 08689; 310mL sachet, PN 08787; 600mL sachet white, PN 08788



3M™ Pneumatic Applicator, 310mL cartridge, PN 08012; 310mL sachet, PN 08006; 600mL sachet, PN 08007



3M™ Multi-Purpose Seam Sealer, beige, PN 50740



3M™ Flexible Plastic Filler, 200mL, PN 05887; Nozzles, PN 08193



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503




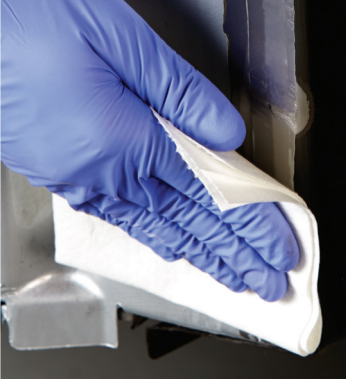
3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Properly dress and finish welded areas prior to applying direct to metal seam sealer.

### Seam Sealer Installation: Direct to Metal

<p><b>1</b></p>		<p><b>Surface Prep</b> Scuff sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air.</p>
<p><b>2</b></p>		<p><b>Clean</b> Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a wax and grease remover. <b>Note: DO NOT spray or saturate seams with cleaner.</b></p>
<p><b>3</b></p>		<p><b>Apply Tight Coat</b> Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing and adhesive qualities.</p>
<p><b>4</b></p>		<p><b>Apply Seam Sealer</b> Apply seam sealer over the prepared seam. Tool to recreate OEM appearance.</p>

### Product List

Scotch-Brite™ Hand Pads 7447 PRO, Very Fine grade, 150mm x 229mm, PN 64659



3M™ Polyurethane Seam Sealer, 310mL cartridge, PN 08689; 310mL sachet, PN 08787; 600mL sachet white, PN 08788



3M™ Pneumatic Applicator, 310mL cartridge, PN 08012; 310mL sachet, PN 08006; 600mL sachet, PN 08007



3M™ Multi-Purpose Seam Sealer, beige, PN 50740



### Think About Your Health

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Corrosion Protection (Cavity Wax Plus)**

1



**Pre-Cleaning**

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



**Shake Aerosol**

Agitate the aerosol can thoroughly — one minute of shaking is required to mix the components prior to use. Attach the desired accessory extension and actuator if needed to access the areas inside the panel enclosure.

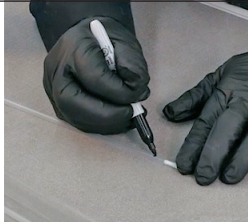
3



**Application with Standard Actuator**

If applying to new panels prior to installation use the standard actuator. Spray up to three (3) coats to ensure full coverage and maximise protection.

4



**Mark Extension Wand**

If using the 360° accessory wand, mark the extension about one inch from the end as a reference to reduce overspray.

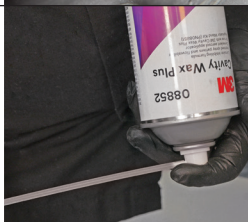
5



**Insert Wand Into Panel Opening**

Insert the wand to the farthest point. Begin spraying as you remove the wand until the reference mark comes into view. Repeat up to three (3) times to ensure complete coverage and maximise corrosion protection.

6



**Clean Accessory Nozzle**

After application, invert the can and clear material from the accessory wand and nozzle by depressing the actuator.

7



**Remove Excess Cavity Wax**

Re-assemble the associated parts and wipe off any excess using a surface cleaner.

**Product List**

3M™ Cavity Wax Plus  
511g, PN 08852



3M™ Cavity Wax Plus  
Applicator Wand Kit,  
PN 08851WK



**Think About Your Health**

3M™ Disposable Ear Plugs,  
PN 1100



3M™ Maintenance Free  
Half Mask Respirator, PNs  
6962/6963 or 7502/7503







3M™ SecureFit™ 200 Series  
Protective Eyewear, clear, PN  
SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Corrosion Protection (Undercoating)**

<p><b>1</b></p>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<p><b>2</b></p>		<p><b>Surface Preparation</b> Use Scotch-Brite™ Clean N Strip disc to remove loose coatings from the repair area. Use CRS Scotch-Brite™ belt in hard to reach areas.</p>
<p><b>3</b></p>		<p><b>Clean and Inspect</b> Blow of area with clean dry compressed air to remove dust and loose surface contaminants. Use a surface cleaner to remove any remaining contaminants. <b>Note: Coatings must be applied over thoroughly cleaned substrates to maximise corrosion protection.</b></p>
<p><b>4</b></p>		<p><b>Coating Application</b> Apply appropriate undercoating following local regulations to the area. For maximum corrosion protection apply four medium coats of undercoating allowing flash time between coats.</p>



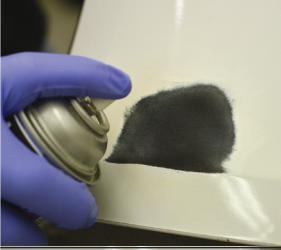
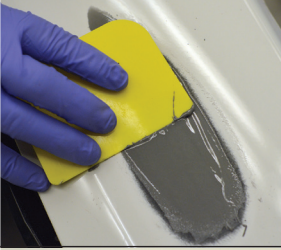


**Product List**

<p>3M™ Scotch-Brite™ Clean and Strip XT Pro, 100mm x 13mm x 6mm, PN 51893</p>	
<p>3M™ Scotch-Brite™ Silicon Carbide Grinding Disc, 100mm x 13mm, PN 05809</p>	
<p>3M™ File Belt Sander, 457mm, PN 33575; 330mm, PN 33573</p>	
<p>Scotch-Brite™ Durable Flex Belt, CRS, PN 64475</p>	
<p>3M™ Body Gard™ Textured Coating, PN 08868, black</p>	

**Think About Your Health**

<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

**Cosmetic Flexible Bumper Repair**  
Scrapes, Gouges and Deformations

<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the repair area with soap and water, followed by a surface cleaner.</p>
<b>2</b>		<p><b>Initial Prep Sand</b></p> <p>“Dish Out” the damaged area using a 80+ grade abrasive disc on a DA sander. Keep the 80+ grade abrasive scratches within the “Dish Out” area. Use a DA sander with 180+ grade abrasive to “feather” the repair area 50–75mm from the “Dish Out” area.</p>
<b>3</b>		<p><b>Apply Adhesion Promoter</b></p> <p>Blow off the repair area with clean, dry air. Apply aerosol adhesion promoter, allowing to dry 5–10 minutes. Always apply adhesion promoter before any filler material.</p>
<b>4</b>		<p><b>Mix and Apply Flexible Filler</b></p> <p>Mix and apply flexible filler with a “tight coat,” followed by additional coats to fill in all low areas. Allow to cure for 15 minutes at 23°C.</p>
<b>5</b>		<p><b>Sand Flexible Filler</b></p> <p>Hand block or DA sand flexible repair material with a 150+ grade disc or sheet, followed by a 180+ grade disc or sheet.</p>
<b>6</b>		<p><b>Final Sand and Inspect</b></p> <p>Finish sand the repair and the surrounding area using a 320+ abrasive disc. Blow off and inspect the repair for quality. Repeat steps 3, 4 and 5 as necessary.</p>

**Product List**

3M™ Cubitron™ II 150mm Abrasive Discs, 80+, PN 51369  
120+, PN 51370  
150+, PN 51421  
180+, PN 51422  
220+, PN 51423  
240+, PN 51424  
320+, PN 51426



3M™ Cubitron™ II Hookit™ Abrasive Sheet, 150+ grade, PN 51388;  
180+ grade, PN 51389



3M™ Polyolefin Adhesion Promoter, PN 05917



3M™ Flexible Plastic Filler, 200mL, PN 05887;  
Nozzles, PN 08193



3M™ Performance Manual Applicator, 200mL, PN 08117



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Note:** We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05917) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05917 may cause a compatibility issue.





Flexible Patch Non-Structural Bumper Repair		
<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the front and back of the repair area with soap and water, followed by a surface cleaner. Be sure to remove any overspray from the back side of the repair area. A Scotch-Brite™ scuffing pad may be used to assist with stubborn overspray.</p>
<b>2</b>		<p><b>Initial Grinding</b></p> <p>Grind the front of the repair using a 75mm 60+ grade disc. Grind at a low speed creating a “Dish Out” area 75mm wide that tapers to the bottom of the damage.</p>
<b>3</b>		<p><b>Initial Prep Sand</b></p> <p>Sand the “Dish Out” area using a 80+ grade abrasive disc on a DA sander, removing any melted plastic. Keep the 80+ grade abrasive scratches within the “Dish Out” area. Using 180+ grade abrasive, feather edge 5–10cm from the “Dish Out” area.</p>
<b>4</b>		<p><b>Apply Reinforcement Patch</b></p> <p>On the back side of the repair area apply the flexible patch adhesion promoter. Firmly apply the flexible reinforcement patch overlapping the damaged area by 36mm on all sides of the repair.</p>
<b>5</b>		<p><b>Mix and Apply Flexible Filler</b></p> <p>Apply 3M™ Polyolefin Adhesion Promoter (PN 05917) to the front side of the repair and allow to dry for 5 minutes. Mix and apply flexible filler with a “tight coat” followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 23°C.</p>
<b>6</b>		<p><b>Sand Flexible Filler</b></p> <p>DA sand the flexible filler material with a 150+ grade abrasive disc. Block sand the repair area with a 180+ grade abrasive sheet.</p>
<b>7</b>		<p><b>Final Sand and Inspect</b></p> <p>Using a DA sander, finish sand the repair and the surrounding area using a P320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 5 and 6 as necessary.</p>

Product List	
<p>3M™ Cubitron™ II 150mm Abrasive Discs, 80+, PN 51369 120+, PN 51370 150+, PN 51421 180+, PN 51422 220+, PN 51423 240+, PN 51424 320+, PN 51426</p>	
<p>3M™ Cubitron™ II Hookit™ Abrasive Sheet, 180+ grade, PN 51389</p>	
<p>3M™ Cubitron™ II Roloc™ Fibre Disc, 50mm, 80+ grade, PN 33380</p>	
<p>3M™ Polyolefin Adhesion Promoter, PN 05917</p>	
<p>3M™ Instant Plastic Repair Patch (with additional adhesion promoter sachets), 102mm x 203mm, PN 05888</p>	
<p>3M™ Automotive Adhesion Promoter Sachets, 2.5mL, PN 06396</p>	
<p>3M™ Flexible Plastic Filler, 200mL, PN 05887; Nozzles, PN 08193</p>	
<p>3M™ Performance Manual Applicator, 200mL, PN 08117</p>	










Think About Your Health	
<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

**Note:** We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05917) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05917 may cause a compatibility issue.

**Two-Sided Bumper Repair**  
Cracks, Holes & Punctures

<b>1</b>		<p><b>Clean the Damaged Area</b></p> <p>Clean the front and back of the repair area with soap and water, followed by a surface cleaner.</p>
<b>2</b>		<p><b>Prepare for Reinforcement Material</b></p> <p>Apply aluminium autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with 80+ grade abrasive disc to sand the repair area where the reinforcement patch will be applied. Apply adhesion promoter, allowing 5 minutes to dry.</p>
<b>3</b>		<p><b>Apply Reinforcement Material</b></p> <p>Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 23°C.</p>
<b>4</b>		<p><b>Tapering the Front Side</b></p> <p>Remove the aluminium tape. Grind the front damage using a 75mm 60+ grade disc or 36+ grade file belt at a low speed to create a gradual "Dish Out" area 75mm wide and deep enough to expose a 5mm wide strip of the back side reinforcement material through the center of the damage.</p>
<b>5</b>		<p><b>Preparing the Repair Area</b></p> <p>Use a DA with 80+ grade abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with 180+ grade around the dished out area where the adhesive will eventually be featheredged.</p>
<b>6</b>		<p><b>Mix and Apply Flexible Filler</b></p> <p>Apply aerosol adhesion promoter and allow to dry for 5 minutes. Mix and apply flexible filler material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 23°C.</p>
<b>7</b>		<p><b>Sand Flexible Filler</b></p> <p>Use a DA to sand the flexible filler material with a 150+ grade abrasive disc, followed by a block with 180+ grade.</p>
<b>8</b>		<p><b>Final Sand and Inspect</b></p> <p>Use a DA sander to finish sand the repair area using P320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.</p>

**Product List**

- 3M™ Polyolefin Adhesion Promoter, PN 05917 
- 3M™ Flexible Parts Repair Material, 50mL cartridge, PN 05901 
- 3M™ Crack Seal Tape, 50mm x 25m, PN 03020 
- 3M™ Pistol Grip Disc Sander, PN 33577 
- 3M™ Cubitron™ II Roloc™ Fibre Disc, 60+ grade, PN 33379 
- 3M™ File Belt Sander, 330mm, PN 33573 
- 3M™ Cubitron™ II File Belt, 10mm x 330mm, 80+ grade, PN 33440 
- 3M™ Flexible Plastic Filler, 200mL, PN 05887; Nozzles, PN 08193 
- 3M™ Performance Manual Applicator, 200mL, PN 08117 
- 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 150mm, 80+ grade, PN 51369; 150+ grade, PN 51421; 220+ grade, PN 51423; 320+ grade, PN 51426 

**Think About Your Health**

- 3M™ Disposable Ear Plugs, PN 1100 
- 3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503 
- 3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF 

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**General Masking**

<p><b>1</b></p>		<p><b>Clean Area</b> Clean the area with water based cleaner. Wipe area with a solvent prep cleaner. Dry the area. The preferable surface temperature for masking is 15–25°C.</p>
<p><b>2</b></p>		<p><b>Critical Edge Masking</b> Mask the areas that require fineline tape first. Mask the rest of the repair and backup the fineline with creped tape. Protect any nearby moldings with trim masking tape.</p>
<p><b>3</b></p>		<p><b>Overspray Protection</b> Ensure that the car is completely dry prior to applying plastic sheeting. Mask entire vehicle with plastic sheeting. Cut out the repair area with a razor blade. Tape the plastic sheeting directly to critical masking edge.</p>
<p><b>4</b></p>		<p><b>Masking Removal</b> After painting, remove the masking tape at a 90-degree angle to the vehicle's surface.</p>

**Product List**

Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977; 36mm width, PN 50980; 48mm width, PN 50981



3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895; 24mm x 50m, PN 07897; 36mm x 50m, PN 07898; 48mm x 50m, PN 07899



3M™ Vinyl Tape 471+, 6.4mm, PN 06405



3M™ Perforated Trim Masking Tape, 5mm, PN 06345; 7mm, PN 06347; 10mm, PN 06349; 15mm, PN 06348



3M™ Clear Masking Film, 5m x 120m roll, PN 07838; 6m x 100m roll, PN 51061



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Mask Openings		
<b>1</b>		<p><b>Clean</b> Clean part with soap and water, followed by a surface cleaner.</p>
<b>2</b>		<p><b>Back Masking</b> Back mask outer edge of opening using wide width tape, ensuring that half of tape width is exposed to the opening.</p>
<b>3</b>		<p><b>Overspray Protection</b> Cover opening with overspray masking film. Pull tight and adhere film to exposed edge of back masking.</p>
<b>4</b>		<p><b>Trim Opening</b> Trim film around inner panel opening.</p>
<b>5</b>		<p><b>Seal Edge</b> Seal edge of masking film using wide width masking tape.</p>

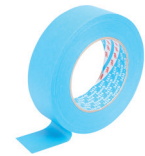
**Note:** All critical edge, jamb masking and general masking should be completed prior to masking openings.

**Product List**

Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977; 36mm width, PN 50980; 48mm width, PN 50981



3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895; 24mm x 50m, PN 07897; 36mm x 50m, PN 07898; 48mm x 50m, PN 07899



3M™ Clear Masking Film, 5m x 120m roll, PN 07838; 6m x 100m roll, PN 51061



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF

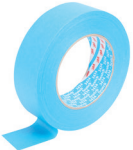


**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

### Primer Masking

1		<p><b>Clean</b> Clean part with soap and water, followed by a surface cleaner.</p>
2		<p><b>Back Masking</b> Back mask primer application area using tape and paper.</p>
3		<p><b>Overspray Protection</b> Apply plastic film to remaining exposed areas, cut out repair area.</p>
4		<p><b>Seal Edge</b> Seal edge of masking film using wide width masking tape.</p>

### Product List







- 3M™ Taped Masking Film, 180cm x 25m, PN 05971  
Applicator M3X, PN M3000K 
- 3M™ Masking Paper (1000), 1218mm, PN 06519 
- Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977; 36mm width, PN 50980; 48mm width, PN 50981 
- 3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895; 24mm x 50m, PN 07897; 36mm x 50m, PN 07898; 48mm x 50m, PN 07899 
- 3M™ Clear Masking Film, 5m x 120m roll, PN 07838; 6m x 100m roll, PN 51061 

### Think About Your Health

- 3M™ Disposable Ear Plugs, PN 1100 
- 3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503 
- 3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF 


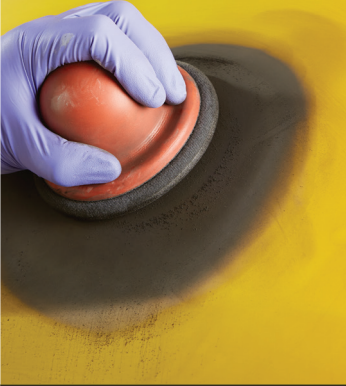
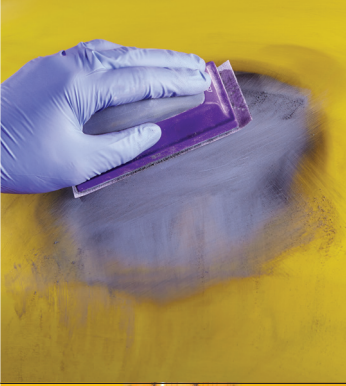

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Prep New Parts	
<b>1</b>	 <p><b>Clean</b> Clean parts to be painted with a wax and grease remover to remove any remaining surface contamination.</p>
<b>2</b>	 <p><b>Scuff</b> Use a P320 abrasive on a DA equipped with a soft interface pad or a red Scotch-Brite™ Hand Pad to sand the part.</p>
<b>3</b>	 <p><b>Clean</b> Blow off the repair area with clean, dry air and a clean cloth. Clean parts to be painted with a wax and grease remover to remove any remaining surface contamination.</p>
<b>4</b>	 <p><b>Apply Top Coats</b> Seal and paint new part following paint company recommendations.</p>

Product List	
<p>3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984</p>	
<p>3M™ Cubitron™ II 150mm Abrasive Discs, 80+, PN 51369 120+, PN 51370 150+, PN 51421 180+, PN 51422 220+, PN 51423 240+, PN 51424 320+, PN 51426</p>	
<p>3M™ Hookit™ E-Coat Disc 150mm, P320, PN 50535</p>	
<p>Festool D150 Thin Interface Pad, PN 202662</p>	
<p>Scotch-Brite™ Cleaning and Finishing Pads, Very Fine grade, pre-cut roll, 115mm x 150mm, PN 07903</p>	
<p>3M™ Accuspray™ Spray Gun HG14, PN 16577</p>	

Think About Your Health	
<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

**Prime Parts (Aluminium, SMC, FRP, Composite)**

<p><b>1</b></p>		<p><b>Assess and Sand</b> Assess damaged area for flatness/straightness. Use 220+ grade abrasive, if necessary, on a DA over the entire repaired area to guarantee the surface is ready to prime. Blow off the repair area with clean, dry air and a clean cloth. Then clean with a wax and grease remover to remove any remaining surface contamination.</p>
<p><b>2</b></p>		<p><b>Apply Primer and Finish Sand</b> Apply primer to repair area following manufacturers recommendations. Apply 3M™ Dry Guide Coat over the entire repaired area. Sand with 220+ grade abrasive to ensure flatness.</p>
<p><b>3</b></p>		<p><b>Block Sand</b> Double check flatness of the repair by block sanding it with 220+ grade abrasive.</p>
<p><b>4</b></p>		<p><b>Paint</b> Paint per manufacturer's recommendation.</p>

**Product List**

3M™ Cubitron™ II Hookit™  
Clean Sanding Abrasive  
Disc, 150mm,  
220+ grade, PN 51423



3M™ General Purpose  
Adhesive Cleaner,  
946mL, PN 08984



3M™ Dry Guide Coat,  
PN 09560, black cartridge;  
PN 09561, applicator



3M™ Cubitron™ II Hookit™  
Abrasive Sheet,  
220+ grade, PN 51390



3M™ Hookit™ Sanding  
Block Dust Free,  
70mm x 127mm,  
PN 05170



3M™ Accuspray™  
Spray Gun HG14,  
PN 16577



**Think About Your Health**

3M™ Disposable Ear Plugs,  
PN 1100



3M™ Maintenance Free  
Half Mask Respirator, PNs  
6962/6963 or 7502/7503







3M™ SecureFit™ 200 Series  
Protective Eyewear, clear, PN  
SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Note:** For aluminium, it is mandatory to use Festool Mobile Dust Extractor CTM 48 E LE EC/B22, PN 575105.

Note: Follow paint company recommended procedures for new raw plastic bumpers.

Refinish Bumper Prep	
<b>1</b>	 <p><b>Cleaning</b> Clean part with soap and water, followed by a surface cleaner.</p>
<b>2</b>	 <p><b>Surface Prep Hand</b> Sand edges and other hard to reach areas using P800–P1000 flexible abrasive sheet until the surface is matte and all sheen has been removed.</p>
<b>3</b>	 <p><b>Re-Clean</b> Clean bumper surface with soap and water, followed by a surface cleaner.</p>
<b>4</b>	 <p><b>Apply Top Coats</b> Seal and paint bumper following paint company recommendations.</p>

**Product List**

3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



3M™ Hookit™ Flexible Abrasive Sheet, 140mm x 171mm, P800, PN 34340; P1000, PN 34341



3M™ Accuspray™ Spray Gun HG14, PN 16577



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503







3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Note: Follow paint company recommended procedures for new raw plastic bumpers.

New Primed Bumper Prep	
<b>1</b>	 <p><b>Cleaning</b> Clean part with soap and water, followed by a surface cleaner.</p>
<b>2</b>	 <p><b>Surface Prep Hand</b> Sand edges and other hard to reach areas using P400 flexible abrasive sheet until the surface is matte and all sheen has been removed.</p>
<b>3</b>	 <p><b>Re-clean</b> Clean bumper surface with soap and water, followed by a surface cleaner.</p>
<b>4</b>	 <p><b>Apply Top Coats</b> Seal and paint bumper following paint company recommendations.</p>

### Product List

3M™ General Purpose Adhesive Cleaner, 946mL, PN 08984



3M™ Hookit™ Flexible Abrasive Sheet, 140mm x 171mm, P400, PN 34337



3M™ Accuspray™ Spray Gun HG14, PN 16577



### Think About Your Health

3M™ Disposable Ear Plugs, PN 1100





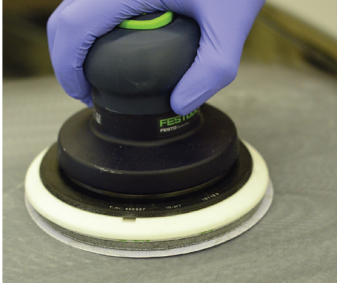
3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

E-Coat Panel Prep		
<b>1</b>		<p><b>Cleaning</b> Clean part with soap and water, followed by a surface cleaner.</p>
<b>2<sub>A</sub></b>		<p><b>Surface Prep Hand</b> Sand edges and other hard to reach areas using P400 flexible abrasive sheet or Scotch-Brite™ hand pad until the surface is matte and all sheen has been removed.</p>
<b>2<sub>B</sub></b>		<p><b>Surface Prep Machine</b> Sand remaining surfaces using P400 abrasive on a DA sander until the surface is matte and all sheen has been removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the e-coat surface.</b></p>
<b>3</b>		<p><b>Re-clean</b> Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a surface cleaner.</p>
<b>4</b>		<p><b>Apply Top Coats</b> Seal and paint following paint company recommendations.</p>

**Product List**

3M™ Hookit™ Flexible Abrasive Sheet, 140mm x 171mm, P400, PN 34337



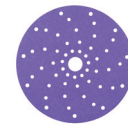
Scotch-Brite™ Cleaning and Finishing Pads, Very Fine grade, pre-cut roll, 115mm x 150mm, PN 07903



Scotch-Brite™ Hand Pads 7447 PRO, Very Fine grade, 150mm x 229mm, PN 64659



3M™ Cubitron™ II Hookit™ Abrasive Disc 737U, 150mm, 400+, PN 51428



3M™ Hookit™ Flexible Abrasive Disc, 17 hole, 150mm, P400, PN 34800



3M™ Accuspray™ Spray Gun HG14, PN 16577



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Feather-Prime-Block		
<b>1</b>		<p><b>Featheredge</b> Blow off repair area. Featheredge the surrounding repair area using 180+ grade abrasive.</p>
<b>2</b>		<p><b>Final Sand and Inspect</b> Final sand surrounding area using P320 abrasive disc on a DA sander. Blow off with clean, dry air. Clean with wax and grease remover. Inspect the repair for quality.</p>
<b>3</b>		<p><b>Mask for Primer</b> Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.</p>
<b>4</b>		<p><b>Apply Primer</b> Apply primer to repair area following manufacturers recommendations. Allow to cure.</p>
<b>5</b>		<p><b>Apply Dry Guide Coat</b> Apply 3M™ Dry Guide Coat over cured primer.</p>
<b>6</b>		<p><b>Hand Block Repair</b> Hand sand or “check block” sand the repair area using a 320+ abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, re-apply dry guide coat and continue block sanding to repair any defects as required.</p>
<b>7</b>		<p><b>Re-Apply Dry Guide Coat</b> Re-apply 3M™ Dry Guide Coat over entire repair area.</p>
<b>8</b>		<p><b>DA Sand Primer</b> DA sand repair area using a P400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.</b></p>
<b>9</b>		<p><b>Clean the Damaged Area</b> Clean the repair area with a surface cleaner.</p>

**Product List**

3M™ Cubitron™ II Hookit™ Clean Sanding Disc, 150mm, 180+ grade, PN 51422



3M™ Cubitron™ II 150mm Abrasive Discs, 320+, PN 51426



3M™ Hookit™ Flexible Abrasive Disc, 17 hole, 150mm, P400, PN 34800



3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator



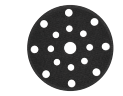
3M™ Accuspray™ Spray Gun HG14, PN 16577



3M™ Cubitron™ II Hookit™ Abrasive Sheet, 320+ grade, PN 30641



Festool D150 Thin Interface Pad, PN 202662



**Think About Your Health**

3M™ Disposable Ear Plugs, PN 1100



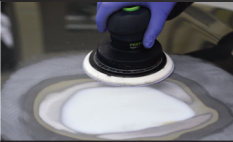
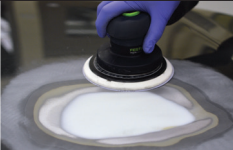
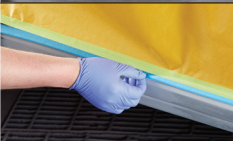


3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Feather-Prime-Block Waterborne		
<b>1</b>		<b>Featheredge</b> Blow off repair area. Featheredge the surrounding repair area using 180+ grade abrasive.
<b>2</b>		<b>Final Sand and Inspect</b> Final sand surrounding area using P320 abrasive disc on a DA sander. Blow off, with clean, dry air. Clean with wax and grease remover. Inspect the repair for quality.
<b>3</b>		<b>Mask for Primer</b> Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.
<b>4</b>		<b>Apply Primer</b> Apply primer to repair area following manufacturers recommendations. Allow to cure.
<b>5</b>		<b>Apply Dry Guide Coat</b> Apply 3M™ Dry Guide Coat over cured primer.
<b>6</b>		<b>Hand Block Repair</b> Hand sand the repair area using a 320+ abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, re-apply dry guide coat and continue block sanding to repair any defects as required.
<b>7</b>		<b>Re-Apply Dry Guide Coat</b> Re-apply 3M™ Dry Guide Coat over entire repair area.
<b>8</b>		<b>DA Sand Primer</b> DA sand repair area using a P400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.</b>
<b>9</b>		<b>Re-Apply Dry Guide Coat</b> Re-apply 3M™ Dry Guide Coat over hand blocked repair area.
<b>10</b>		<b>DA Sand Primer</b> DA Sand repair area using a P600–P800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.</b>
<b>11</b>		<b>Clean the Damaged Area</b> Clean the repair area with a surface cleaner.

Product List	
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Disc, 150mm, 180+ grade, PN 51422 320+ grade, PN51426, 400+ grade, PN51428</p>	
<p>3M™ Dry Guide Coat, PN 09560, black cartridge; PN 09561, applicator</p>	
<p>3M™ Accuspray™ Spray Gun HG14, PN 16577</p>	
<p>3M™ Cubitron™ II Hookit™ Abrasive Sheet, 320+ grade, PN 30641</p>	
<p>Festool D150 Thin Interface Pad, PN 202662</p>	
<p>3M™ Hookit™ Purple Clean Sanding Disc, 150mm, P500, PN 50534; P600, PN 50913</p>	
<p>3M™ Hookit™ Flexible Abrasive Disc, 17 hole, 150mm, P400, PN 34800; P600, PN 34801; P800, PN 34802</p>	

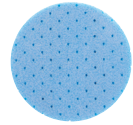
Think About Your Health	
<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	

**Blend Panel Sanding Process**

<p><b>1</b></p>		<p><b>Clean the Repair Area</b> Clean the repair area with soap and water, followed by a surface cleaner.</p>
<p><b>2</b></p>		<p><b>Hand Sand Edges</b> Scuff hard to reach areas and panel edges by hand with P800–P1000 abrasive disc or flexible abrasive sheet.</p>
<p><b>3</b></p>		<p><b>DA Sand Colour Blend Area</b> DA sand the colour blend area using a grade P800 abrasive disc and a soft interface pad. For best results, sand back into primer surfacer. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the top coat surface.</b></p>
<p><b>4</b></p>		<p><b>DA Sand Adjacent Panels</b> DA sand the remainder of the blend panel(s) using a P1000 abrasive disc.</p>
<p><b>5</b></p>		<p><b>Clean and Inspect</b> Clean the repair area with a paint manufacturer recommended surface cleaner. Blow dry the repair area with clean, dry air. Inspect the repair area and re-sand any shiny spots as necessary.</p>

**Product List**

3M™ Hookit™ Flexible Foam Abrasive Disc, P1000  
75mm, PN 33551;  
150mm, PN 33541



3M™ Hookit™ Flexible Abrasive Sheet,  
140mm x 171mm,  
P800, PN 34340



3M™ Hookit™ Flexible Abrasive Disc,  
17 hole, 150mm,  
P800, PN 34802;  
P1000, PN 34803



Festool D150 Thin Interface Pad, PN 202662



**Think About Your Health**

3M™ Disposable Ear Plugs,  
PN 1100



3M™ Maintenance Free Half Mask Respirator, PNs  
6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.



# 3M™ PPS™ Series 2.0 Spray Cup System

Reinvented from top to bottom, it's designed to help make your life easier. To make your painting process cleaner and faster. And to make you a better, more productive painter — more confident in the quality of your work and better able to exceed the expectations of your customers *and* your shop.

## Improved six ways.

- 1 Wide Spout Adapter with Four-Point Connection.** Maximises stability while spraying. Makes cleaning easier.
- 2 Domed Lid with Full-Diameter Filter.** More paint below the filter improves flow and consistency, while reducing spitting from start to finish.
- 3 Quarter-Turn Lid Locking System.** Comes with every lid. Stays cleaner. Locks faster. Fewer parts to keep track of.
- 4 New Cup in Every Lid and Liner Kit.** Start with a clean cup more often, reducing paint build-up. On-cup ratios and fill markings eliminate traditional mixing cups.
- 5 Access Window.** Allows painter to hold the liner for cleaner, easier lid removal when refilling. Also easier to check paint levels.
- 6 Larger Cup Sealing Plug.** Allows painter to seal and protect coatings upside down with greater stability when not in use. Use fewer lids by keeping filters wet.



## Product List

3M™ PPS™ Series 2.0  
Lid and Liner Kit, 200  
micron liner cup system,  
850mL, PN 26024;  
650mL, PN 26112;  
400mL, PN 26112;  
200mL, PN 26114



3M™ PPS™ Series 2.0  
Lid and Liner Kit, 125  
micron liner cup system,  
850mL, PN 26740;  
650mL, PN 26026;  
400mL, PN 26312;  
200mL, PN 26752



3M™ PPS™ Series 2.0  
Hard Cups,  
850mL, PN 26023;  
650mL, PN 26001;  
400mL, PN 26122;  
200mL, PN 26115



3M™ Accuspray™  
Spray Gun HG14,  
PN 16577



3M™ Accuspray™  
Atomizing Heads,  
1.4mm orange, PN 22614;  
1.8mm clear, PN 22618;  
2.0mm red, PN 22620;



## Think About Your Health

3M™ Disposable Ear Plugs,  
PN 1100



3M™ Maintenance Free  
Half Mask Respirator, PNs  
6962/6963 or 7502/7503



3M™ SecureFit™ 200 Series  
Protective Eyewear, clear, PN  
SF201AF



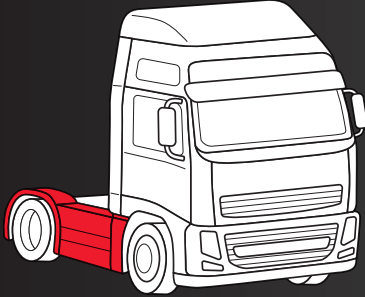
**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Visit [3Mbodyshop.co.uk](http://3Mbodyshop.co.uk) to learn more



## Standard Operating Procedures Paint Shop

### Mini 200mL



Ideal for small areas that require 200mL of material or less.



3M™ PPS™ Series 2.0 Kit Mini Size,  
PN 26114, 200mL, 200 micron filters

3M™ PPS™ Series 2.0 Kit Mini Size,  
PN 26752, 200mL, 125 micron filters

### Midi 400mL



Ideal for areas that require 400mL of material or less.



3M™ PPS™ Series 2.0 Kit Midi Size,  
PN 26112, 400mL, 200 micron filters

3M™ PPS™ Series 2.0 Kit Midi Size,  
PN 26312, 400mL, 125 micron filters

### Standard 650mL



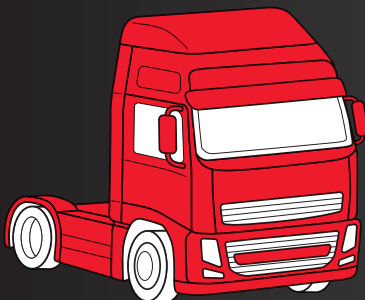
Ideal for large areas that require 650mL of material or less.



3M™ PPS™ Series 2.0 Kit Standard Size,  
PN 26000, 650mL, 200 micron filters

3M™ PPS™ Series 2.0 Kit Standard Size,  
PN 26026, 650mL, 125 micron filters

### Large 850mL



Ideal for large jobs that require 850mL of material or less.



3M™ PPS™ Series 2.0 Kit Large Size,  
PN 26024, 850mL, 200 micron filters

3M™ PPS™ Series 2.0 Kit Large Size,  
PN 26740, 850mL, 125 micron filters




**Paint Finishing: Small Areas**

<b>1</b>		<p><b>Initial Defect Removal</b></p> <p>DA sand the repair area with a 75mm P1500 finishing film disc, removing all paint defects. Wipe panel clean. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc.</p>
<b>2</b>		<p><b>Scratch Refinement P3000</b></p> <p>Refine the P1500 scratches with a DA and a 75mm P3000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. Wipe panel clean.</p>
<b>3</b>		<p><b>Scratch Refinement 6000 (Optional)</b></p> <p>Refine the P3000 scratches with a DA and a 75mm 6000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area five times. The use of P3000 is required prior to 5000 for best results.</p>
<b>4</b>		<p><b>Buff</b></p> <p>Compound the repair area with a 75mm polisher. Use a 75mm foam compound pad and the appropriate rubbing compound. Wipe panel clean.</p>
<b>5</b>		<p><b>Polish</b></p> <p>Polish the repair area with a 75mm polisher. Use a 75mm black foam polishing pad and the appropriate machine polish. Wipe panel clean with a yellow microfibre cloth.</p>
<b>6</b>		<p><b>Swirl Elimination</b></p> <p>Ultrafine polish the repair area with a 75mm polisher. Use a 75mm blue foam polishing pad and ultrafine machine polish. Leave a light film of polish on the surface and wipe the panel clean with a blue microfibre cloth.</p>
<b>7</b>		<p><b>Final Detail</b></p> <p>Clean sling from adjacent panels and door apertures areas. Doing this immediately after the repair will greatly improve the ease of this step.</p>

**Product List**

3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 75mm, P1500, PN 05601	
3M™ Hookit™ Finishing Film Disc, 75mm, P1500, PN 51267	
3M™ Hookit™ Soft Interface Pad, 75mm, PN 05771	
3M™ Pistol Grip Disc Sander, PN 33577	
3M™ Trizact™ Hookit™ Foam Disc, 75mm, 3000, PN 50415; 6000, PN 51131	
3M™ Perfect-It™ III Fast Cut Plus Extreme Compound, 865mL, PN 51815; 432mL, PN 51816	
3M™ Perfect-It™ III Compounding Pad, 75mm, PN 50499	
3M™ Perfect-It™ III Extra Fine Plus Compound, PN 80349	
3M™ Perfect-It™ III Polishing Pad, 75mm, PN 50536	
3M™ Perfect-It™ III Ultrafina SE Polish, PN 50383	
3M™ Perfect-It™ III Polishing Pad, 75mm, PN 50457	

**Think About Your Health**








3M™ Disposable Ear Plugs, PN 1100	
3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503	
3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF	

**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Paint Finishing: Large Areas		
<b>1</b>		<p><b>Initial Defect Removal Texture Match</b></p> <p>DA sand the repair area with a P1500/P2000 3M™ Purple Finishing Film Hookit™ Disc or P1500 3M™ Trizact™ Clearcoat Sanding Disc used damp. Remove all paint defects and match texture to adjacent OEM panels. Wipe panel clean.</p>
<b>2</b>		<p><b>Scratch Refinement 3000</b></p> <p>Refine the P1500/P2000 scratches with a DA and a 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean.</p>
<b>3</b>		<p><b>Scratch Refinement 6000 (Optional)</b></p> <p>To reduce your buffing time refine the 3000 scratches with a DA and a 6000 grit 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean. The use of 3000 is required prior to 6000 for best results.</p>
<b>4</b>		<p><b>Compound</b></p> <p>Compound the repair area with a high speed polisher set between 1200–2000 RPM. For faster results, use a foam compounding pad and the appropriate rubbing compound. To insure all sand scratches have been removed, inspect the surface by spraying with an Inspection Spray and wipe clean with a yellow microfibre cloth.</p>
<b>5</b>		<p><b>Machine Polish</b></p> <p>Polish the repair area with a high speed polisher set between 1200–2000 RPM. Use a black foam polishing pad and the appropriate machine polish. Wipe the panel clean with a yellow microfibre cloth.</p>
<b>6</b>		<p><b>Ultrafine Machine Polish</b></p> <p>Polish the repair area with a high speed polisher with the speed set between 1200–2000 RPM. Use a blue foam polishing pad and the appropriate ultrafine machine polish. Leave a light film of the polish on the panel and wipe clean with a blue microfibre cloth.</p>
<b>7</b>		<p><b>Final Detail</b></p> <p>Remove any masking material from the repair area and clean any residual sling from adjacent panels and door jamb areas. Cleaning the panel immediately after compounding and polishing will greatly improve the ease of cleaning. Inspect the surface using the 3M™ PPS™ Colour Check Light II Kit.</p>

Product List
<p>3M™ Hookit™ Purple Finishing Film Disc 260L+, 150mm, P1500, PN 51154; P2000, PN 51304</p> 
<p>3M™ Trizact™ Hookit™ Clearcoat Sanding Disc, 150mm, P1500, PN 05600</p> 
<p>Festool D150 Thin Interface Pad, PN 202662</p> 
<p>3M™ Trizact™ Hookit™ Foam Disc, 150mm, 3000, PN 50414; 6000, PN 51130</p> 
<p>3M™ Perfect-It™ III Fast Cut Plus Extreme Compound, 865mL, PN 51815; 432mL, PN 51816</p> 
<p>3M™ Perfect-It™ III Double Sided Compounding Pad, 150mm, PN 50878</p> 
<p>3M™ Quick Connect Adaptor, 14mm. Thread, PN 33271</p> 
<p>3M™ Perfect-It™ III Extra Fine Plus Compound, PN 80349</p> 
<p>3M™ Perfect-It™ III Double Sided Polishing Pad, 150mm, PN 50879; 216mm, PN 50875</p> 
<p>3M™ Perfect-It™ III Ultrafina SE Polish, PN 50383</p> 
<p>3M™ Perfect-It™ III Double Sided Polishing Pad, 150mm, PN 50880; 216mm, PN 50708</p> 
<p>3M™ PPS™ Colour Check Light II Kit, PN 16550</p> 

Think About Your Health
<p>3M™ Disposable Ear Plugs, PN 1100</p> 
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p> 
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p> 
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>

Headlight Restoration		
<b>1</b>		<p><b>Clean and Mask</b></p> <p>Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.</p>
<b>2</b>		<p><b>Sand to Remove Yellowing and Defects</b></p> <p>Dry DA sand the damaged headlight lens with a 75mm P600 abrasive disc using a soft interface pad. Completely remove any yellowing and/or surface defects.</p>
<b>3</b>		<p><b>1st Step Scratch Refinement</b></p> <p>Refine the P600 sand scratches by dry DA sanding with a 75mm P800 abrasive disc on a soft interface pad. Wipe the headlight lens clean.</p>
<b>4</b>		<p><b>2nd Step Scratch Refinement</b></p> <p>Refine the P800 sand scratches by DA sanding with a 75mm P1000 foam disc on a soft interface pad. Use water to lubricate the P1000 foam abrasive disc. Spend extra time on this step to ensure removal of all P800 sand scratches. Wipe the headlight lens clean.</p>
<b>5</b>		<p><b>3rd Step Scratch Refinement</b></p> <p>Refine the P1000 sand scratches by DA sanding with a 75mm P3000 foam abrasive disc on a soft interface pad. Use water to lubricate the P3000 foam abrasive disc. Spend extra time on this step to ensure removal of all P1000 sand scratches. Wipe the headlight lens clean.</p>
<b>6</b>		<p><b>Compound Lens</b></p> <p>Completely remove the P3000 sand scratches using a 75mm polishing tool with a foam compounding pad and rubbing compound. Wipe the headlight lens with a clean microfibre cloth.</p>
<b>7</b>		<p><b>Polish Lens</b></p> <p>Polish the headlight lens using a 75mm foam polishing pad and machine polish. Wipe the headlight lens with a clean microfibre cloth. Remove the masking tape and inspect for quality.</p>

Product List	
<p>Scotch® Premium Automotive Refinish Masking Tape 3030, 18mm width, PN 50977; 36mm width, PN 50980; 48mm width, PN 50981</p>	
<p>3M™ Scotch® High Performance Masking Tapes 3434, 18mm x 50m, PN 07895; 24mm x 50m, PN 07897; 36mm x 50m, PN 07898; 48mm x 50m, PN 07899</p>	
<p>3M™ Hookit™ Soft Interface Pad, 75mm, PN 05771</p>	
<p>3M™ Hookit™ Purple Clean Sanding Disc, 75mm, P600, PN 51263; 75mm, P800, PN 51264</p>	
<p>3M™ Trizact™ Hookit™ Blending Disc, 75mm, P1000, PN 50413</p>	
<p>3M™ Trizact™ Hookit™ Foam Disc, 75mm, 3000, PN 50415</p>	
<p>3M™ Perfect-It™ III Fast Cut Plus Extreme Compound, 865mL, PN 51815; 432mL, PN 51816</p>	
<p>3M™ Perfect-It™ III Compounding Pad, 75mm, PN 50499</p>	
<p>3M™ Perfect-It™ III Extra Fine Plus Compound, PN 80349</p>	
<p>3M™ Perfect-It™ III Polishing Pad, 75mm, PN 50536</p>	

Think About Your Health	
<p>3M™ Disposable Ear Plugs, PN 1100</p>	
<p>3M™ Maintenance Free Half Mask Respirator, PNs 6962/6963 or 7502/7503</p>	
<p>3M™ SecureFit™ 200 Series Protective Eyewear, clear, PN SF201AF</p>	
<p><b>Not a complete list.</b> Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	



## Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at [3Mbodyshop.co.uk](https://www.3mbodyshop.co.uk)

For product material safety data sheets see [3Mbodyshop.co.uk](https://www.3mbodyshop.co.uk)

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3M Automotive Aftermarket Division  
3M United Kingdom PLC  
3M Centre, Cain Road  
Bracknell RG12 8HT

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