Cosmetic Repair (SMC, FRP, Composites)

1. **Clean the Damaged Area**
   Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. **DO NOT** apply any other cleaners throughout the remainder of the repair procedure.

2. **Rough Grind**
   Dish out the repair area with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a lower speed. Finish dishing out the repair area using a P80 abrasive disc on a DA.

3. **Feather-edge**
   Finish the dish-out process using a P180 abrasive disc and feather well into the surrounding area. Blow off the repair area with clean, dry air and a clean cloth.

4. **Adhesion Promoter**
   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.

5. **Apply**
   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 150°F for 15 minutes.

6. **Rough Sand and Shape Filler**
   Rough shape the filler once it has cooled using a DA or a hand block with a P80 abrasive. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7. **Final Sand and Inspect**
   Final DA or block sand the filler with P180 abrasive and feather into the surrounding composite and paint. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Finish sanding with a P220 abrasive sanding well into the surrounding surface. **Note:** Contact your paint manufacturer for final sand preparation.

---

### Product List

- **3M™ Car Wash Soap Concentrate**, 5 gallons, PN 38378
- **3M™ Specialty Adhesive Remover**, 15 oz. aerosol, PN 38987
- **3M™ Cubitron™ II Fibre Roloc Disc, grade 60+**, 3 in. (75mm), PN 33391
- **3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in.**, 180+ grade, PN 31374; 220+ grade, PN 31481
- **3M™ Polyolefin Adhesion Promoter**, PN 05907
- **3M™ Rigid Parts Repair**, 400mL, PN 08275
- **Marson® Yellow Spreaders**, PN 20395
- **3M™ Dry Guide Coat**, PN 05861

---

### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug**, PN P1300
- **3M™ Half Facepiece Respirator**, PN 07182
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket**, PN 11872

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

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at 3MCollision.com

For product material safety data sheets see 3MCollision.com

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use: Many factors beyond 3M’s control and uniquely within user’s knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user’s method of application.

Warranty, Limited Remedy and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M’s option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.