

Feather-Prime-Block		
<b>1</b>		<p><b>Featheredge</b> Blow off repair area. Featheredge the surrounding repair area using P180 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 P320 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 VOC compliant surface cleaner.</p>
<p>Visit <a href="http://www.3MCollision.com">www.3MCollision.com</a> for more SOPs and videos</p>		

Product List	
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374</p>	
<p>3M™ Purple Clean Sanding Hookit™ Disc, 6 in., P400 grit, PN 01811</p>	
<p>3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P400, PN 34800</p>	
<p>3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861</p>	
<p>3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P320 grit, PN 01812</p>	
<p>3M™ Accuspray™ Spray Gun Model HG18, PN 16570; 1.8mm Atomizing Head, PN 16611</p>	
<p>3M™ Hookit™ Purple Clean Sanding Roll, 70mm x 12m, P320, PN 30705</p>	
<p>Festool D150 Thin Interface Pad, PN 29939</p>	

Think About Your Health	
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Lexa™ Protective Eyewear, PN 15200</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 [www.3MCollision.com](http://www.3MCollision.com)

For product material safety data sheets see [www.3MCollision.com](http://www.3MCollision.com)

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