

Feather-Prime-Block Waterborne		
1		Featheredge Blow off repair area. Featheredge the surrounding repair area using grade 180 abrasive.
2		Final Sand and Inspect Final sand surrounding area using grade 320 abrasive disc on a DA sander. Blow off, with clean, dry air. Clean with wax and grease remover. Inspect the repair for quality.
3		Mask for Primer Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.
4		Apply Primer Apply primer to repair area following manufacturer's recommendations. Allow to cure.
5		Apply Dry Guide Coat Apply 3M™ Dry Guide Coat over cured primer.
6		Hand Block Repair Hand sand or "check block" sand the repair area using a grade 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.
7		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over entire repair area.
8		DA Sand Primer DA sand repair area using a grade 400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed.
9		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over hand blocked repair area.
10		DA Sand Primer DA Sand repair area using a grade 600–800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed.
11		Clean the Damaged Area Clean the repair area with a VOC compliant surface cleaner.

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Product List

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 6 in., grade 180+, PN 31374; 6 in., grade 320+, PN 31483; 6 in., grade 400+, PN 31484



3M™ Accuspray™ ONE Pro Spray Gun Kit for 3M™ PPS™ 2.0, PN 26578



3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861



3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 320+, PN 34449



Festool D150 Thin Interface Pad, PN 30092



3M™ Hookit™ Purple Clean Sanding Disc 334U, 6 in., grade P600, PN 30761; 6 in., grade P800, PN 30760



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



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

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