

Feather-Prime-Block Waterborne		
1		Featheredge Blow off repair area. Featheredge the surrounding repair area using P180 abrasive.
2		Final Sand and Inspect 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.
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 manufacturers 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 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.
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 P400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed. Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.
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 P600–P800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed. Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.
11		Clean the Damaged Area Clean the repair area with a VOC compliant surface cleaner.

Visit www.3MCollision.com for more SOPs and videos

Product List

3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374



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



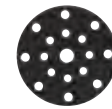
3M™ Accuspray™ Spray Gun Model HG18, PN 16570; 1.8mm Atomizing Head, PN 16611



3M™ Hookit™ Purple Clean Sanding Roll, 70mm x 12m, P320, PN 30705



Festool D150 Thin Interface Pad, PN 29939



3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P320 grit, PN 01812; 6 in., P400 grit, PN 01811; 6 in., P600 grit, PN 30761; 6 in., P800 grit, PN 30760



3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P400, PN 34800; 6 in., P600, PN 34801; 6 in., P800, PN 34802



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Lexa™ Protective Eyewear, PN 15200



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

For product material safety data sheets see www.3MCollision.com

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