








Headlight Lens Restoration Process		
1		<p>Clean and Mask Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.</p>
2		<p>Sand to Remove Yellowing and Defects Dry DA sand the damaged headlight lens with a 3 in. P500 abrasive disc using a soft interface pad. Completely remove any yellowing and/or surface defects.</p>
3		<p>First Step Scratch Refinement Refine the P500 sand scratches by dry DA sanding with a 3 in. P800 abrasive disc on a soft interface pad. Wipe the headlight lens clean.</p>
4		<p>Second Step Scratch Refinement Refine the P800 sand scratches by DA sanding with a 3 in. 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>
5		<p>Third Step Scratch Refinement Refine the P1000 sand scratches by DA sanding with a 3 in. 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>
6		<p>Compound Lens Completely remove the P3000 sand scratches using a 3 in. polishing tool with a foam compounding pad and rubbing compound. Wipe the headlight lens with a clean microfiber cloth.</p>
7		<p>Polish Lens Polish the headlight lens using a 3 in. foam polishing pad and machine polish. Wipe the headlight lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.</p>

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

Product List	
3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377	
Scotch® Performance Masking Tape 233+, 18mm x 55m, PN 26334	
3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771	
3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P500, PN 30272; 3 in., P800, PN 30260	
3M™ Trizact™ Hookit™ Blending Disc, 3 in., P1000, PN 02091	
3M™ Trizact™ Hookit™ Foam Disc, 3 in., 3000, PN 02087	
3M™ Perfect-It™ Rubbing Compound, 1 qt. (946mL), PN 06085; 16 oz., PN 39060	
3M™ Foam Buffing Pad, 3 in., PN 05759	
3M™ Perfect-It™ Machine Polish, 1 qt. (946mL), PN 06064; 16 oz., PN 39061	
3M™ Foam Polishing Pad, 3 in., PN 05726	
3M™ Perfect-It™ Detail Cloth, PN 06016	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Particulate Respirator N95, PN 07185	
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

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.



**3M Automotive
Aftermarket Division**
3M Center
Building 223-6N-01
St. Paul, MN 55144-1000
U.S.A.
www.3MCollision.com

Please recycle. Printed in U.S.A.
© 3M 2015. All rights reserved.
(Rev 9/2015)

3M, Accuspray, Body Schutz, Cubitron, E-A-R, Hookit, Lexa, Platinum, PPS, Rocker Gard, Roloc, Scotch, Scotchblok, ScotchBlue, Scotch-Brite, Skull Screws and Trizact are trademarks of 3M Company