

Large Damage Repair		
<b>1</b>		<p><b>Pre-Cleaning</b> Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
<b>2</b>		<p><b>Initial Prep Sand</b> DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.</p>
<b>3</b>		<p><b>Final Metal Prep</b> Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean and Strip disc. Use a 3 in. grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.</p>
<b>4</b>		<p><b>Mix and Apply Filler</b> Mix and apply filler per manufacturer’s recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F.</p>
<b>5</b>		<p><b>Initial Sand Filler</b> Block shape sand filler with grade 80. DA rough featheredge area with grade 80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.</p>
<b>6</b>		<p><b>Final Sand Filler</b> Final block sand filler with grade 150 abrasive. DA fine featheredge sand the repair area with grade 180 abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
<b>7</b>		<p><b>Mix and Apply Glaze</b> Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer’s recommendation or if using the 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.</p>
<b>8</b>		<p><b>Sand Glaze</b> Block sand polyester glaze with grade 180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.</p>
<b>9</b>		<p><b>Final Sand and Inspect</b> Blow off repair area. Featheredge the surrounding area using grade 180 abrasive. Inspect the repair for quality.</p>

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**Product List**

Meguiar’s® Shampoo Plus,  
1 gallon, PN D11101



Meguiar’s® Citrus Power  
Cleaner Plus, 1 gallon,  
PN D10701

3M™ Cubitron™ II Hookit™  
Clean Sanding Abrasive Disc,  
3 in., grade 80+, PN 31361;  
3 in., grade 180+, PN 31364;  
6 in., grade 80+, PN 31371;  
6 in., grade 180+, PN 31374



3M™ Platinum™ Plus Body  
Filler, 1 gallon, PN 01131;  
for DMS, PN 05863



3M™ Platinum™ Select Body  
Filler, 1 gallon, PN 31131;  
for DMS, PN 35863



3M™ Cubitron™ II Roloc™  
Fibre Disc, 3 in., grade 80+,  
PN 33392



3M™ Roloc™+ Holder,  
PN 07500



Scotch-Brite™ Roloc™+  
Clean and Strip XT  
Pro Disc, PN 21552



Scotch-Brite™ Roloc™+  
Clean and Strip XT  
Pro Extra Cut Disc,  
PN 21555



3M™ Platinum™ Plus  
Finishing Glaze, 30 oz.,  
PN 31180; for DMS,  
PN 05862



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



3M™ Cubitron™ II Hookit™  
Clean Sanding Sheet Roll,  
70mm x 12m,  
grade 80+, PN 34442;  
grade 150+, PN 34445;  
grade 180+, PN 34446



**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](http://3MCollision.com)

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

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