

Aluminum Repair Procedures

Paint Prep

Feather-Prime-Block

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 standard operating procedures 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.

9



Clean the Damaged Area

Clean the repair area with a recommended 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™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P320 grit, PN 01812



3M™ Accuspray™ Spray Gun Model HG09, PN 16570



3M™ Accuspray™ Atomizing Head, PN 16611



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



3M™ Purple Clean Sanding Hookit™ Disc, 6 in., P400 grit, PN 01811



3M™ Hookit™ Soft Interface Pad, PN 05777



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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