

# Aluminum Repair Procedures

## Paint Prep

### Feather-Prime-Block Waterborne

1		<b>Featheredge</b> Blow off repair area. Featheredge the surrounding repair area using P180 abrasive.
2		<b>Final Sand and Inspect</b> 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		<b>Mask for Primer</b> Mask repair area as necessary. Refer to primer masking standard operating procedures for 3M specific recommendations.
4		<b>Apply Primer</b> Apply primer to repair area following manufacturers recommendations. Allow to cure.
5		<b>Apply Dry Guide Coat</b> Apply 3M™ Dry Guide Coat over cured primer.
6		<b>Hand Block Repair</b> 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		<b>Re-Apply Dry Guide Coat</b> Re-apply 3M™ Dry Guide Coat over entire repair area.
8		<b>DA Sand Primer</b> DA sand repair area using a P400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed.
9		<b>Re-Apply Dry Guide Coat</b> Re-apply 3M™ Dry Guide Coat over hand blocked repair area.
10		<b>DA Sand Primer</b> DA Sand repair area using a P600–P800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed.
11		<b>Clean the Damaged Area</b> Clean the repair area with a recommended VOC compliant surface cleaner.

Visit [www.3MCollision.com](http://www.3MCollision.com) for more SOPs and videos

### Product List

3M™ Purple Clean Sanding Hookit™ Disc, 6 in., P180 grit, PN 01816; P400 grit, PN 01811



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 334U, 6 in., P600 grit, PN 30761; 6 in., P800 grit, PN 30760



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

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

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