


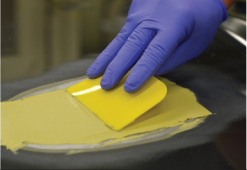
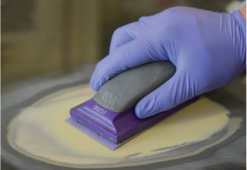


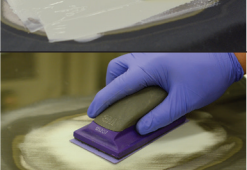



Large Dent Repair		
1		<p>Pre-Cleaning</p> <p>Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p>Initial Prep Sand</p> <p>DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Clean the surface with an approved low VOC surface cleaner.</p>
3		<p>Final Metal Prep</p> <p>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. Clean the surface with an approved low VOC surface cleaner.</p>
4		<p>Mix and Apply Filler</p> <p>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>
5		<p>Initial Sand Filler</p> <p>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. Reapply 3M™ Dry Guide Coat as necessary.</p>
6		<p>Final Sand Filler</p> <p>Final block sand filler with grade 150 abrasive. DA fine featheredge sand the repair area with grade 180 abrasive and clean the surface with an approved low VOC surface cleaner applied to a clean towel. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.</p>
7		<p>Mix and Apply Glaze</p> <p>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>
8		<p>Sand Glaze</p> <p>Block sand polyester glaze with grade 180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Reapply glaze as necessary to fill minor imperfections.</p>
9		<p>Final Sand and Inspect</p> <p>Featheredge the surrounding area using grade 180 abrasive. Inspect the repair for quality.</p>

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Product List
<p>Meguiar’s® Shampoo Plus, 1 gallon, PN D11101</p> 
<p>Meguiar’s® Citrus Power Cleaner Plus, 1 gallon, PN D10701</p> 
<p>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</p> 
<p>3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863</p> 
<p>3M™ Platinum™ Select Body Filler, 1 gallon, PN 31131; for DMS, PN 35863</p> 
<p>3M™ Cubitron™ II Roloc™ Fibre Disc, 3 in., grade 80+, PN 33392</p> 
<p>3M™ Roloc™+ Holder, PN 07500</p> 
<p>Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552</p> 
<p>Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555</p> 
<p>3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180; for DMS, PN 05862</p> 
<p>3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861</p> 
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 80+, PN 34442; grade 150+, PN 34445; grade 180+, PN 34446</p>

Think About Your Health
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p> 
<p>3M™ Half Facepiece Respirator, PN 07182</p> 
<p>3M™ Virtua™ Protective Eyewear, PN 11326</p> 

The Festool mobile dust extractor is not approved for use with aluminum dust. Adapt sander to a non-vacuum airline. PN 29917.

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

For product material safety data sheets see 3MCollision.com

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