

Jeep® Hardtop Texture Repair

1



Clean

Clean the area to be repaired with soap and water, followed by a VOC compliant surface cleaner.

2



Preparation of Substrate

Sand with P180 sandpaper on a DA. Use compressed air to remove dust from the panel and reclean the repair area with a VOC compliant surface cleaner.

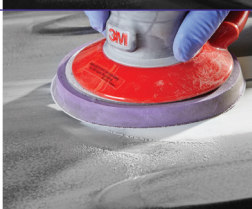
3



Level the Surface

Complete your repair to the Wrangler hard top as necessary. To make an invisible final repair, the surface must be completely flush with the existing texture. To accomplish this, apply glaze over the entire repair area into the factory texture. Allow the glaze to cure.

4



Featheredge Glaze

Using a DA or a hand block, shape sand the glaze with P180 sandpaper. Featheredge the repair area with P320 abrasive disc, ensuring a smooth transition between the repair area and existing texture.

5



Re-clean

Use compressed air to remove dust from the panel and then clean the panel with a VOC compliant surface cleaner and a clean cloth.

6



Apply Coating

Apply textured coating by using the HGP spray gun system. A test panel should be sprayed first to gauge proper air pressure, distance from panel, and gun settings. Suggested settings for the two wet coverage coats are: Fan – 1 turn from closed; Fluid – 2 turns from closed; Pressure – 15–17 psi.

7



Apply Texture

Allow 30 minutes of flash time followed by a final "spatter coat" which will give the proper final appearance. Recommended settings for this coating are: Fan – 1 turn from closed; Fluid – 2-1/2 turns from closed; Pressure – 13–15 psi. Blow air across the panels for 30 minutes and then force cure the coating in the booth at 140°F for 120 minutes, or use an IR lamp to obtain 130°F surface temperature for 30 minutes.

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

Product List

3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377



3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350



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



3M™ Platinum Glaze for DMS, PN 05862



3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180



3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P320 grit, PN 01812



3M™ Scotchgard™ Autobody Coating, PN 7277



3M™ Accuspray™ Spray Gun Kit HGP, PN 16587



3M™ PPS™ Type H/O Pressure Cup, Large, 28 oz. (828mL), PN 16124



3M™ PPS™ Kit Large Size, 200 micron filters, PN 16024

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

