

**E-Coat Panel Prep**

**1**



**Cleaning**

Clean part with soap and water, followed by a VOC compliant surface cleaner.

**2<sub>A</sub>**



**Surface Prep Hand**

Sand edges and other hard to reach areas using P400 flexible abrasive sheet or Scotch-Brite™ hand pad until the surface is matte and all sheen has been removed.

**2<sub>B</sub>**



**Surface Prep Machine**

Sand remaining surfaces using P400 abrasive on a DA sander until the surface is matte and all sheen has been removed. **Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the e-coat surface.**

**3**



**Re-clean**

Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

**4**



**Apply Top Coats**

Seal and paint following paint company recommendations.

Visit [3MCollision.com](http://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™ Flexible Abrasive Hookit™ Sheet, 5.5 in. x 6.8 in., P400, PN 34337



Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine grade, 6 in. x 9 in., PN 64926



3M™ Flexible Abrasive Hookit™ Foam Pad, PN 34349



3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P400 grit, PN 01811



3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P400, PN 34800



3M™ Accuspray™ ONE Spray Gun System with PPS™, PN 16578



**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



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

## 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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