Standard Operating Procedures

Heavy Duty Truck Repair

3M Automotive Aftermarket Division
From metal and plastic repair, to sanding, paint finishing and truck clean-up, 3M has the products and repair processes for you. Feel confident your repair is done professionally and efficiently using our Standard Operating Procedures. These procedures will help you consistently produce quality, time-proven results for any of your collision repair needs.

For more Standard Operating Procedures, visit 3MCollision.com.
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**Important Note on VOCs:** Volatile Organic Compound (VOC) regulations may exist that prohibit the use of certain alcohol solutions or solvents. You should check with your state environmental authorities to determine whether use of a solution or solvent is restricted or prohibited in your area.
Standard Operating Procedures

Truck Repair

### Aluminum Panel Removal

1. **Clean**
   - Clean the panel prior to disassembly with soap and water followed by a VOC compliant surface cleaner.

2. **Sealer/Coating Removal**
   - If necessary, use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings from large easy to access areas. For hard-to-reach areas use a CRS grade Scotch-Brite™ Belt.

3. **Rivet/Spot Weld Removal — Belt Grinder**
   - Use grade 80 abrasive belt to remove spot welds or rivet head from top panel. Note top panel thickness. Use belt thickness as a gauge (e.g., stop grinding when the back of belt is flush with exterior panel). **Note:** During application, follow OEM recommended procedures for removal of rivets and/or other fasteners.

4. **Panel Separation**
   - Separate exterior panel from the host panel. **DO NOT** force separation in areas where the weld isn’t completely removed. Go back to Step 3 and finish weld removal before continuing.

### Product List

- **3M™ Car Wash Soap Concentrate,** 5 gallons, PN 38378
- **3M™ Specialty Adhesive Remover,** 15 oz. aerosol, PN 38987
- Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, 4 in. x 1/2 in., Extra Coarse, PN 07470
- Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, 4 in. x 1/2 in., Extra Coarse, PN 07466
- 3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573
- Scotch-Brite™ Durable Flex Belt, 1/2 in. x 18 in., Coarse, PN 64475
- 3M™ Green Corps™ Reinforced Weld Grinding Wheel, PN 01991
- 3M™ Cut-Off Wheel Tool, 3 in., PN 33579
- 3M™ Cubitron™ II File Belt, 1/2 in. x 18 in., grade 80+, PN 33446

### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug,** PN P1300
- **3M™ Half Facepiece Respirator,** PN 07182
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket,** PN 11872

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

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Visit 3MCollision.com for more SOPs and videos

Use only tools that have been cleaned properly or are designated for use on aluminum to reduce potential cross contamination. **DO NOT** re-use abrasives that were previously used on steel repairs.

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For ordering information, contact your 3M Sales Representative
### Aluminum Panel Installation: Adhesive

**1. Clean**
Wash the truck and repair area prior to disassembly with soap and water followed by a VOC compliant surface cleaner.

**2. Dry Fit Panel**
Dry fit all parts to ensure a good fit before dispensing and applying adhesive. **Note:** Use 1-1/2 in. tape for alignment markings to determine proper placement and attachment.

**3. Remove Panel**
Cut tape between the two panels and remove panel. Use rubber gloves to prevent contamination.

**4. Apply Adhesive**
Apply adhesive to the sanded replacement panel flange. Use rubber gloves to prevent contamination.

**5. Fit Panel**
Fit panel to the existing truck side panel and slide if necessary to align to 1-1/2 in. tape. **Note:** Always slide panel and never pick up panel away from bonding surface. Apply clamps.

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### Product List

- **3M™ Car Wash Soap Concentrate**, 5 gallons, PN 38378
- **3M™ Specialty Adhesive Remover**, 15 oz. aerosol, PN 38987
- **Scotch® Performance Green Masking Tape** 233+, 36mm width (1.41 in.), PN 26338
- **3M™ SMC/FRP Repair – 90**, 400mL, PN 08274

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### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug**, PN P1300
- **3M™ Half Facepiece Respirator**, PN 07182
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket**, PN 11872

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Aluminum Dent Repair

1. **Pre-Cleaning**
   Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. **Initial Prep Sand**
   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.

3. **Final Metal Prep**
   Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N 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.

4. **Mix and Apply Filler**
   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.

5. **Initial Sand Filler**

6. **Final Sand Filler**
   Final block sand filler with P150 abrasive. DA fine featheredge sand the repair area with P180 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.

7. **Mix and Apply Glaze**
   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.

8. **Sand Glaze**
   Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Reapply glaze as necessary to fill minor imperfections.

9. **Final Sand and Inspect**
   Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.

Visit 3MCollision.com for more SOPs and videos

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

Product List

- 3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377
- 3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350
- 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+ grade, PN 31361; 6 in., 80+ grade, PN 31371
- 3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863
- 3M™ Cubitron™ II Fibre Roloc™ Disc, 3 in., 80+ grade, PN 33392
- 3M™ Roloc™ Holder, PN 07500
- Scotch-Brite™ Roloc™ Clean N Strip XT Disc, PN 07470
- Scotch-Brite™ Roloc™ Clean N Strip TR Disc, PN 07466
- 3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180
- 3M™ Platinum Glaze for DMS, 05862
- 3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861
- 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 80+ grade, PN 34442; 150+ grade, PN 34445; 180+ grade, PN 34446
- 3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374

Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300
- 3M™ Half Facepiece Respirator, PN 07182
- 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872

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

For ordering information, contact your 3M Sales Representative
## Composite Panel Removal and Installation

### Clean the Panels
Clean panels with soap and water followed by a VOC compliant surface cleaner. Thoroughly dry the parts. **DO NOT** apply any other cleaners throughout the remainder of the removal and installation procedure.

### Panel Removal
Heat the bond line to 250–300°F and gently pry the panels apart with a rigid putty knife or equivalent. Remove all adhesive from the undamaged part using the same process as below. Let the surface cool.

### Surface Prep
Sand the surfaces to be bonded using a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a low speed to rough up the area, or a P80 abrasive disc on a DA. Blow off the repair area with clean, dry air and a clean cloth. **Note:** If flame heat was used to help separate panels it’s a must that the afterburn be removed with a P80 abrasive disc. For metal parts, nothing coarser than P80 is necessary.

### Dry Fit Parts
Dry fit all parts to ensure a good fit before dispensing and applying adhesive.

### Apply Adhesive
Follow the Directions for Use to prepare, mix and apply 3M™ SMC/FRP Repair Adhesive. Apply a continuous bead to one part. **Note:** If you need to adjust the part, slide the part to prevent air pockets in the adhesive bead.

### Bond
Mate the parts. Apply clamps to the bonded panel surface and clamp within the desired area. **Note:** Apply as many clamps as needed to bring the panels together. Make sure **NOT** to over clamp, which can result in squeezing the bondline dry of adhesive. Remove any excess adhesive squeeze out.

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<td><strong>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391</strong></td>
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<td><strong>3M™ Pistol Grip Disc Sander, PN 33577</strong></td>
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<td><strong>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 80+ grade, PN 31371</strong></td>
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<tr>
<td><strong>Scotch® Performance Green Masking Tape 233+, 18mm width (0.71 in.), PN 26334</strong></td>
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<td><strong>3M™ SMC/FRP Repair – 10, 400mL, PN 08272</strong></td>
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<td><strong>3M™ SMC/FRP Repair – 35, 400mL, PN 08273</strong></td>
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<tr>
<td><strong>3M™ SMC/FRP Repair – 90, 400mL, PN 08274</strong></td>
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<tr>
<td><strong>3M™ Performance Pneumatic Applicator for 400mL cartridges, PN 08280</strong></td>
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### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300**
- **3M™ Half Facepiece Respirator, PN 07182**
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872**

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

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

*For ordering information, contact your 3M Sales Representative*
## Metal Working

1. **Pre-Cleaning**
   Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. **Surface Prep**
   Use a Scotch-Brite™ Clean N Strip disc or a Scotch-Brite™ Belt to remove paint/coating in low points of damage in preparation for dent pulling.

3. **Dent Pulling**
   Pull low spots of dent using preferred dent pulling method and equipment.

4. **Final Prep**
   Use a grade 80 Roloc™ grinding disc to remove weld nuggets from dent pulling operation.

5. **Clean and Inspect**
   Clean with all purpose cleaner and degreaser. Blow off with clean, dry air. Inspect damage area to determine if additional metal straightening is required.

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<td>3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573</td>
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<tr>
<td>Scotch-Brite® Durable Flex Belt, CRS, PN 64475</td>
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<tr>
<td>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 80+, 3 in., PN 33392</td>
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### 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

Note: It will be necessary to apply cavity wax to back side of panel at heat effected areas to restore corrosion protection.
Steel Part Replacement

1

**Pre-Cleaning**
Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2

**Panel Cutting**
Identify OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim repair area using preferred cut-off wheel. Use grade 36 file belt in hard-to-reach areas to cut top panel and avoid damage to host panel.

3

**Sealer/Coating Removal**
Use Scotch-Brite™ Clean N Strip disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard-to-reach areas and along pinch weld flanges to expose spot weld locations.

4

**Spot Weld Removal**
Using grade 36 or 60 abrasive belt, grind spot weld to remove weld from top panel. Note top panel thickness. Use caution when grinding to only grind top panel and limit cutting into host/interior panel. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. Grade 80 belt can be used to remove welds from thinner steels.

5

**Panel Separation**
Separate exterior panel from the host panel. DO NOT force separation in areas where the weld isn’t completely removed; go back to step 4 and finish weld removal before continuing.

6A

**Surface Preparation**
Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel.

6B

**Surface Preparation**
Clean and prep remaining mating flanges on host and replacement panel with a coarse Scotch-Brite™ Belt where necessary.

7A

**MIG Plug Weld Dressing**
Use a grade 80 abrasive belt to dress replacement MIG welds. Grind weld. Use caution to avoid damage to adjacent areas.

7B

**Continuous Weld Dressing**
Use a 3 in. grade 60 grinding disc to dress continuous MIG welds at sectioning joint. Grind weld. Use caution to limit amount of grinding done to adjacent areas.

8

**Weld Cleaning**
Use a CRS Scotch-Brite™ Belt to clean weld site in preparation for subsequent operations.

Visit 3MCollision.com for more SOPs and videos

Note: Follow High Strength steel heat control recommendations and techniques when necessary.

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<td>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350</td>
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<td>3M™ Green Corps™ Cut-Off Wheel, 3 in. x 1/32 in., PN 01989; 3 in. x 1/16 in., PN 01990</td>
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<tr>
<td>Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470</td>
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<td>Scotch-Brite™ Durable Flex Belt, CRS, PN 64475</td>
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<tr>
<td>3M™ Cubitron™ II File Belt, grade 36+, PN 33443; grade 60+, PN 33445; grade 80+, PN 33446</td>
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<tr>
<td>3M™ Pistol Grip Disc Sander, PN 33577</td>
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# Back Side Reinforcement (SMC, FRP, Composites)

## Clean the Damaged Area
Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. Do not apply any other cleaners throughout the remainder of the repair procedure.

## Surface Preparation
Grind the backside of the repair with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip grinder set at a low speed. When finished the sanded area should be at least 2 in. larger than the repair area. Remove sanding debris from the surface using clean compressed air and a clean, dry rag.

## Adhesion Promoter
No adhesion promoter is needed for SMC or FRP repairs. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter to the repair area. Allow to dry for at least 5 minutes.

## Alignment
Align the front side of the repair and cover the damaged area with Scotch® Auto Body Repair Tape to keep the adhesive from the back side from flowing through to the front side.

## Prepare and Apply Reinforcement Material
Cut a piece of fiberglass matting 1-1/2 in. larger than the damaged area. Following product instructions, apply a “tight coat” of matting adhesive to the repair area to ensure good contact with the composite. Place the fiberglass mat on a clean, dry work surface. Saturate the entire section of mat with matting adhesive on both sides and apply it over the “tight coat” on the repair. Apply more 3M™ Fiberglass Mat Adhesive if necessary.

## Dry
Allow the matting adhesive to cure for 45 minutes at 75°F.

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### Product List

- **3M™ Car Wash Soap Concentrate**, 5 gallons, PN 38379
- **3M™ Specialty Adhesive Remover**, 15 oz. aerosol, PN 38957
- **3M™ Cubitron™ II Fibre Roloc™ Disc**, grade 60+, 3 in. (75mm), PN 33391
- **3M™ Pistol Grip Disc Sander**, PN 33577
- **3M™ Polyolefin Adhesion Promoter**, PN 05907
- **Scotch® Auto Body Repair Tape**, 2 in. x 125 in., PN 95331
- **3M™ Aluminum Foil Tape 425**, Silver, 2 in. x 60 yd., 4.6 mil, PN 95072
- **Scotch® Performance Green Masking Tape 233+**, 48mm width (1.9 in.), PN 26340
- **Dynatron™ Fiberglass Mat**, 8 sq. ft., PN 00688
- **3M™ Fiberglass Mat Adhesive**, 400mL, PN 08277
- **3M™ Performance Pneumatic Applicator for 400mL cartridges**, PN 08280
- **Marson® Yellow Spreaders**, PN 20395

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### Think About Your Health

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- **3M™ Half Facepiece Respirator**, PN 07182
- **3M™ Virtua™ CCS Protective Eyewear with Foam Gasket**, PN 11872

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Cosmetic Repair (SMC, FRP, Composites)

1. Clean the Damaged Area
   - Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. DO NOT apply any other cleaners throughout the remainder of the repair procedure.

2. Rough Grind
   - Dish out the repair area with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a lower speed. Finish dishing out the repair area using a P80 abrasive disc on a DA.

3. Feather-edge
   - Finish the dish-out process using a P180 abrasive disc and feather well into the surrounding area. Blow off the repair area with clean, dry air and a clean cloth.

4. Adhesion Promoter
   - SMC and fiberglass do not require an adhesion promoter. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter, to the repair area. Allow adhesion promoter to dry for 5 minutes before applying the adhesive/filler.

5. Apply
   - Following product instructions, apply a tight coat of adhesive/filler to the repair area to insure good contact with the composite. Continue to build until the repair area is slightly higher than the surrounding area. For best results heat set at 150°F for 15 minutes.

6. Rough Sand and Shape Filler
   - Rough shape the filler once it has cooled using a DA or a hand block with a P80 abrasive. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7. Final Sand and Inspect
   - Final DA or block sand the filler with P180 abrasive and feather into the surrounding composite and paint. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Finish sanding with a P220 abrasive sanding well into the surrounding surface. Note: Contact your paint manufacture for final sand preparation.

Visit 3MCollision.com for more SOPs and videos

Product List

- 3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378
- 3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987
- 3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391
- 3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374; 220+ grade, PN 31481
- 3M™ Polyolefin Adhesion Promoter, PN 05907
- 3M™ Rigid Parts Repair, 400mL, PN 08275
- Marson® Yellow Spreaders, PN 20395
- 3M™ Dry Guide Coat, PN 05861

Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300
- 3M™ Half Facepiece Respirator, PN 07182
- 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872

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Weld Bonding (Excluding Door Skin)

1. **Host Panel Preparation**
   Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt to remove all adhesive, corrosion and coatings.

2. **Mating Flange Panel Preparation**
   Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.

3. **Clean**
   Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.

4. **Dry Fit Panel**
   Dry fit replacement panel and complete any necessary metal straightening at flanges areas.

5. **Weld-Thru Primer**
   Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.

6. **Spot Weld Surface Preparation**
   Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.

7. **Pre-Assembly NVH Replacement**
   If vehicle construction necessitates, apply NVH material or foams at original locations as required.

8. **Apply Bonding Adhesive**
   Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange areas.

9. **Install Replacement Panel**
   Install replacement panel to host panel. Clamp in place.

10. **Spot Weld**
    Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.

11. **Adhesive Clean Up**
    Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.

12. **Post-Assembly Foam Replacement**
    Apply foams at original locations as required.

Visit 3MCollision.com for more SOPs and videos

Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.

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**WARNING**
Follow OEM and/or welder manufacturers’ recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

**Product List**
- 3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573
- 3M™ Cubitron™ II File Belt, grade 80+, PN 33446
- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
- Scotch-Brite™ Roloc™ Clean N Strip TR Disc, PN 07466
- Scotch-Brite™ Roloc™ Clean N Strip XT Disc, PN 07470
- 3M™ Weld-Thru Coating II, PN 05917
- 3M™ NVH Dampening Material, PN 04274
- 3M™ Flexible Foam, 200mL, PN 08463
- 3M™ Panel Bonding Adhesive, 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115; 50mL, PN 38315
- 3M™ SMC/FRP Panel Adhesive, 200mL, PN 08219
- 3M™ Rigid Pillar Foam, 200mL, PN 08458

**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.
### Weld Sealing

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1</strong></td>
<td><strong>Host Panel Preparation</strong>&lt;br&gt;Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.</td>
</tr>
<tr>
<td><strong>2</strong></td>
<td><strong>Mating Flange Panel Preparation</strong>&lt;br&gt;Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean N Strip disc.</td>
</tr>
<tr>
<td><strong>3</strong></td>
<td><strong>Clean</strong>&lt;br&gt;Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.</td>
</tr>
<tr>
<td><strong>4</strong></td>
<td><strong>Dry Fit Panel</strong>&lt;br&gt;Dry fit replacement panel and complete any necessary metal straightening at flanges areas.</td>
</tr>
<tr>
<td><strong>5</strong></td>
<td><strong>Weld-Thru Primer</strong>&lt;br&gt;Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding.</td>
</tr>
<tr>
<td><strong>6</strong></td>
<td><strong>Spot Weld Surface Preparation</strong>&lt;br&gt;Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.</td>
</tr>
<tr>
<td><strong>7</strong></td>
<td><strong>Pre-Assembly NVH Replacement</strong>&lt;br&gt;If vehicle construction necessitates, apply NVH material or foams at original locations as required.</td>
</tr>
<tr>
<td><strong>8</strong></td>
<td><strong>Apply Seam Sealer</strong>&lt;br&gt;Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.</td>
</tr>
<tr>
<td><strong>9</strong></td>
<td><strong>Install Replacement Panel</strong>&lt;br&gt;Install replacement panel to host panel. Clamp in place.</td>
</tr>
<tr>
<td><strong>10</strong></td>
<td><strong>Spot Weld</strong>&lt;br&gt;Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.</td>
</tr>
<tr>
<td><strong>11</strong></td>
<td><strong>Sealer Clean Up</strong>&lt;br&gt;Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair.&lt;br&gt;Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.</td>
</tr>
<tr>
<td><strong>12</strong></td>
<td><strong>Post-Assembly Foam Replacement</strong>&lt;br&gt;Apply foams at original locations as required.</td>
</tr>
</tbody>
</table>

**Product List**

- **3M™ File Belt Sander**, 18 in., PN 33575; 13 in., PN 33573
- **3M™ Cubitron™ II File Belt**, grade 80+, PN 33446
- Scotch-Brite™ Durable Flex Belt, CRS, PN 64475
- Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, PN 07470
- Scotch-Brite™ Roloc™+ Clean N Strip TR Disc, PN 07466
- **3M™ Weld-Thru Coating II**, PN 05917
- **3M™ NVH Dampening Material**, PN 04274
- **3M™ Flexible Foam**, 200mL, PN 08463
- **3M™ Urethane Seam Sealer**, PN 08361; PN 08362
- **3M™ MSP Seam Sealer**, PN 08370
- **3M™ Rigid Pillar Foam**, 200mL, PN 08458

**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

**WARNING**

Follow OEM and/or welder manufacturers’ recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

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**Note:** Follow recommended internal corrosion protection processes prior to vehicle final assembly.
Small Damage Repair

1. **Pre-Cleaning**
   Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. **Initial Prep Sand**
   DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.

3. **Mix and Apply Filler**
   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.

4. **Sand Filler**
   Using a hand block, shape sand the body filler with P80 abrasive. Apply dry guide coat and finish block sanding with P150 abrasive. DA featheredge the repair area with P180 abrasive disc. Inspect the repair for quality; if glaze is not required, continue to step seven.

5. **Mix and Apply Glaze**
   Blow off the repair area, completely removing sanding dust from the surface. 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.

6. **Sand Glaze**
   Sand polyester glaze with P180. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7. **Final Sand and Inspect**
   Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.

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Product List

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Specification</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Car Wash Soap Concentrate</td>
<td>1 gallon</td>
<td>PN 38377</td>
</tr>
<tr>
<td>3M™ All Purpose Cleaner and Degreaser Concentrate</td>
<td>1 gallon</td>
<td>PN 38350</td>
</tr>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc</td>
<td>3 in., 80+ grade</td>
<td>PN 31361</td>
</tr>
<tr>
<td></td>
<td>6 in., 80+ grade</td>
<td>PN 31371</td>
</tr>
<tr>
<td>3M™ Platinum™ Plus Body Filler</td>
<td>1 gallon</td>
<td>PN 01131; for DMS, PN 05863</td>
</tr>
<tr>
<td>3M™ Dry Guide Coat</td>
<td>50 gram applicator kit</td>
<td>PN 05861</td>
</tr>
<tr>
<td>3M™ Platinum™ Plus Finishing Glaze</td>
<td>30 oz.</td>
<td>PN 31180</td>
</tr>
<tr>
<td>3M™ Platinum™ Glaze</td>
<td>for DMS</td>
<td>PN 05862</td>
</tr>
<tr>
<td>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll</td>
<td>70mm x 12m, 80+ grade</td>
<td>PN 34442; 150+ grade, PN 34445; 180+ grade, PN 34446</td>
</tr>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Disc</td>
<td>6 in., 180+ grade</td>
<td>PN 31374</td>
</tr>
</tbody>
</table>

Think About Your Health

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Specification</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ E-A-R™ Skull Screws® Ear Plug</td>
<td>P1300</td>
<td></td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator</td>
<td>07182</td>
<td></td>
</tr>
<tr>
<td>3M™ Lexa™ Protective Eyewear</td>
<td>15200</td>
<td></td>
</tr>
</tbody>
</table>

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

1. Pre-Cleaning
   Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. Initial Prep Sand
   DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.

3. Final Metal Prep
   Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean N Strip disc. Use a 3 in. grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.

4. Mix and Apply Filler
   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.

5. Initial Sand Filler

6. Final Sand Filler
   Final block sand filler with P150 abrasive. DA fine featheredge sand the repair area with P180 abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7. Mix and Apply Glaze
   Blow off the repair area, completely removing sanding dust from the surface. 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.

8. Sand Glaze
   Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Reapply glaze as necessary to fill minor imperfections.

9. Final Sand and Inspect
   Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.

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Product List

- 3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377
- 3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350
- 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+ grade, PN 31361; 6 in., 80+ grade, PN 31371
- 3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863
- 3M™ Cubitron™ II Fibre Roloc™ Disc, 3 in., 80+ grade, PN 33392
- 3M™ Roloc™+ Holder, PN 07500
- Scotch-Brite™ Roloc™ Clean N Strip XT Disc, PN 07470
- Scotch-Brite™ Roloc™ Clean N Strip TR Disc, PN 07466
- 3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180
- 3M™ Platinum™ Glaze for DMS, PN 05862
- 3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861
- 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 80+ grade, PN 34442; 150+ grade, PN 34445; 180+ grade, PN 34446
- 3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374

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.
# Standard Operating Procedures

## Truck Repair

### Seam Sealer Removal

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Clean</td>
<td>Prewash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</td>
</tr>
<tr>
<td>2</td>
<td>Protect</td>
<td>Protect surrounding areas with masking tape.</td>
</tr>
<tr>
<td>3</td>
<td>Method A</td>
<td>Use a Scotch-Brite™ Clean N Strip Disc to remove seam sealer and coatings where accessible.</td>
</tr>
<tr>
<td>4</td>
<td>Method B</td>
<td>Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas.</td>
</tr>
<tr>
<td>5</td>
<td>Clean</td>
<td>Blow off the surface with clean dry air and then use a VOC compliant surface cleaner to remove any remaining residue.</td>
</tr>
</tbody>
</table>

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### Product List

<table>
<thead>
<tr>
<th>Product</th>
<th>Image</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377</td>
<td><img src="image1.jpg" alt="Image" /></td>
</tr>
<tr>
<td>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350</td>
<td><img src="image2.jpg" alt="Image" /></td>
</tr>
<tr>
<td>Scotch® Performance Green Masking Tape 233+, 18mm width (.71 in.), PN 26334</td>
<td><img src="image3.jpg" alt="Image" /></td>
</tr>
<tr>
<td>Scotch-Brite™ Roloc™+ Clean N Strip XT Disc, 4 in. x 1/2 in., Extra Coarse, PN 07470</td>
<td><img src="image4.jpg" alt="Image" /></td>
</tr>
<tr>
<td>Scotch-Brite™ Roloc™+ Clean N Strip Disc, 4 in. x 1/2 in., Extra Coarse, PN 07466</td>
<td><img src="image5.jpg" alt="Image" /></td>
</tr>
<tr>
<td>3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573</td>
<td><img src="image6.jpg" alt="Image" /></td>
</tr>
<tr>
<td>Scotch-Brite™ Durable Flex Belt, 1/2 in. x 18 in., Coarse, PN 64475</td>
<td><img src="image7.jpg" alt="Image" /></td>
</tr>
<tr>
<td>3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987</td>
<td><img src="image8.jpg" alt="Image" /></td>
</tr>
</tbody>
</table>

### Think About Your Health

<table>
<thead>
<tr>
<th>Product</th>
<th>Image</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</td>
<td><img src="image9.jpg" alt="Image" /></td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator, PN 07182</td>
<td><img src="image10.jpg" alt="Image" /></td>
</tr>
<tr>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872</td>
<td><img src="image11.jpg" alt="Image" /></td>
</tr>
</tbody>
</table>

Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.
## Seam Sealer Installation: Over Primer

### 1. Surface Prep
Scuff primer in sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air. **Note:** Apply 3M seam sealers only over two-part epoxy or two-part urethane primers.

### 2. Clean
Use a clean cloth or paper towel to clean repair area with 3M™ All Purpose Cleaner and Degreaser followed by a VOC compliant wax and grease remover. **Note:** DO NOT spray or saturate seams with cleaner.

### 3. Apply Tight Coat
Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing and adhesive qualities.

### 4. Apply Seam Sealer
Apply seam sealer over the prepared seam. Tool to recreate OEM appearance.

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## Product List

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

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

### Marson® Yellow Spreaders, PN 20395

### 3M™ Urethane Seam Sealer, PN 08361

### 3M™ MSP Seam Sealer, PN 08370

### 3M™ MSP Sprayable Seam Sealer, PN 08374

### 3M™ Heavy-Bodied Seam Sealer, 200mL, PN 08308; 600mL DMS, PN 58308

### 3M™ EZ Sand Multi Purpose Repair Material, 200mL, PN 05887; 600mL DMS, PN 55887

## Think About Your Health

### 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

### 3M™ Half Facepiece Respirator, PN 07182

### 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872

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For ordering information, contact your 3M Sales Representative
# Standard Operating Procedures

## Truck Repair

**Seam Sealer Installation: Direct to Metal**

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td><strong>Surface Prep</strong>&lt;br&gt;Scuff sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air.</td>
</tr>
<tr>
<td>2</td>
<td><strong>Clean</strong>&lt;br&gt;Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a VOC compliant wax and grease remover. <strong>Note: DO NOT</strong> spray or saturate seams with cleaner.</td>
</tr>
<tr>
<td>3</td>
<td><strong>Apply Tight Coat</strong>&lt;br&gt;Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing and adhesive qualities.</td>
</tr>
<tr>
<td>4</td>
<td><strong>Apply Seam Sealer</strong>&lt;br&gt;Apply seam sealer over the prepared seam. Tool to recreate OEM appearance.</td>
</tr>
</tbody>
</table>

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## Product List

- Scotch-Brite™ Hand Pads 7447 PRO, Very Fine grade, 6 in. x 9 in., PN 64926
- 3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350
- Marson® Yellow Spreaders, PN 20395
- 3M™ Urethane Seam Sealer, PN 08361; PN 08362
- 3M™ MSP Seam Sealer, PN 08370
- 3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310

## Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300
- 3M™ Half Facepiece Respirator, PN 07182
- 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872

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# Standard Operating Procedures

## Truck Repair

### Corrosion Protection (Cavity Wax)

1. **Pre-Cleaning**
   - Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2. **Shake Aerosol**
   - Agitate the aerosol can thoroughly — one minute of shaking is required to mix the components prior to use. Attach the desired accessory extension and actuator if needed to access the areas inside the panel enclosure.

3. **Application with Standard Actuator**
   - If applying to new panels prior to installation use the standard actuator. Spray up to three (3) coats to ensure full coverage and maximize protection.

4. **Mark Extension Wand**
   - If using the 360° accessory wand, mark the extension about one inch from the end as a reference to reduce overspray.

5. **Insert Wand Into Panel Opening**
   - Insert the wand to the farthest point. Begin spraying as you remove the wand until the reference mark comes into view. Repeat up to three (3) times to ensure complete coverage and maximize corrosion protection.

6. **Clean Accessory Nozzle**
   - After application, invert the can and clear material from the accessory wand and nozzle by depressing the actuator.

7. **Remove Excess Cavity Wax**
   - Re-assemble the associated parts and wipe off any excess using a VOC compliant surface cleaner.

---

### Product List

- **3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377**
- **3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350**
- **3M™ Cavity Wax Plus 18 oz. aerosol, PN 08852**
- **3M™ Cavity Wax Plus Applicator Wand Kit, PN 08851**

### 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**

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### Standard Operating Procedures

#### Truck Repair

## Corrosion Protection (Undercoating)

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1</strong></td>
<td><strong>Pre-Cleaning</strong>&lt;br&gt;Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</td>
</tr>
<tr>
<td><strong>2</strong></td>
<td><strong>Surface Preparation</strong>&lt;br&gt;Use Scotch-Brite™ Clean N Strip disc to remove loose coatings from the repair area. Use CRS Scotch-Brite™ belt in hard-to-reach areas.</td>
</tr>
<tr>
<td><strong>3</strong></td>
<td><strong>Clean and Inspect</strong>&lt;br&gt;Blow off area with clean dry compressed air to remove dust and loose surface contaminants. Use a VOC compliant surface cleaner to remove any remaining contaminants. <strong>Note:</strong> Coatings must be applied over thoroughly cleaned substrates to maximize corrosion protection.</td>
</tr>
<tr>
<td><strong>4</strong></td>
<td><strong>Coating Application</strong>&lt;br&gt;Apply appropriate undercoating following local VOC regulations to the area. For maximum corrosion protection apply four medium coats of undercoating allowing flash time between coats.</td>
</tr>
</tbody>
</table>

### Product List

| 3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377 |
| 3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350 |
| Scotch-Brite™ Roloc™ Clean N Strip XT Disc, PN 07470 |
| Scotch-Brite™ Roloc™ Clean N Strip TR Disc, PN 07466 |
| 3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573 |
| Scotch-Brite™ Durable Flex Belt, CRS, PN 64475 |
| 3M™ Waterbased Paintable Undercoating Pouch, 5.5 fl. oz. (US), PN 08744 |
| 3M™ Paintable Undercoating Pouch, 5.5 fl. oz., PN 08747 |

### Think About Your Health

| 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300 |
| 3M™ Respirator Assembly/ Organic Vapor N95 Dual Cartridge, PN 07192 |
| 3M™ Lexa™ Protective Eyewear, PN 15200 |

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### LASD Replacement (On Body)

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
</table>
| 1    | **Pre-Cleaning**  
Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair). |
| 2    | **LASD Removal**  
Remove sound deadening material from affected repair area using a scraper or chisel. |
| 3    | **Surface Prep**  
Scuff surface with a maroon Scotch-Brite™ Hand Pad. Blow off area with compressed air and clean with APCD. |
| 4    | **Application**  
Mask area and apply seam sealer. Re-create desired appearance and texture of NVH material using tools of the trade (e.g., notched spreaders, brushes, scuff pads, compressed air, etc.). Remove perimeter masking following the tooling process and prior to final cure. |

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### Product List

**Las Vegas Truck Repair**

- **3M™ Car Wash**  
  Soap Concentrate, 1 gallon, PN 38377
- **3M™ All Purpose Cleaner and Degreaser Concentrate**, 1 gallon, PN 38350
- **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™ Heavy-Bodied Seam Sealer**, 200mL, PN 08308; 600mL DMS, PN 58308
- **3M™ Urethane Seam Sealer**, PN 08361
- **3M™ MSP Seam Sealer**, PN 08370
- **3M™ NVH Dampening Material**, PN D4274

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### Think About Your Health

- **3M™ E-A-R™ Skull Screws™ Ear Plug**, PN P1300
- **3M™ Respirator Assembly/ Organic Vapor N95 Dual Cartridge**, PN 07192
- **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.*

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### Cosmetic Flexible Bumper Repair
Scrapes, Gouges and Deformations

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Clean the Damaged Area</td>
<td>Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.</td>
</tr>
<tr>
<td>2</td>
<td>Initial Prep Sand</td>
<td>“Dish Out” the damaged area using a P80 abrasive disc on a DA sander. Keep the P80 abrasive scratches within the “Dish Out” area. Use a DA sander with P180 abrasive to “feather” the repair area 2–3 in. from the “Dish Out” area.</td>
</tr>
<tr>
<td>3</td>
<td>Apply Adhesion Promoter</td>
<td>Blow off the repair area with clean, dry air. Apply aerosol adhesion promoter, allowing to dry 5–10 minutes. Always apply adhesion promoter before any filler material.</td>
</tr>
<tr>
<td>4</td>
<td>Mix and Apply Flexible Filler</td>
<td>Mix and apply flexible filler with a “tight coat,” followed by additional coats to fill in all low areas. Allow to cure for 15 minutes at 75°F.</td>
</tr>
<tr>
<td>5</td>
<td>Sand Flexible Filler</td>
<td>Hand block or DA sand flexible repair material with a P150 disc or sheet, followed by a P180 disc or sheet.</td>
</tr>
<tr>
<td>6</td>
<td>Final Sand and Inspect</td>
<td>Finish sand the repair and the surrounding area using a P320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 3, 4 and 5 as necessary.</td>
</tr>
</tbody>
</table>

Visit 3MCollision.com for more SOPs and videos

---

### Product List

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc</td>
<td>3 in., 320+, PN 31463 6 in., 320+, PN 31483</td>
</tr>
<tr>
<td>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet</td>
<td>Roll, 70mm x 12m, 150+ grade, PN 34445; 180+ grade, PN 34446</td>
</tr>
<tr>
<td>3M Polyolefin Adhesion Promoter</td>
<td>12 oz. aerosol, PN 05907</td>
</tr>
<tr>
<td>3M™ EZ Sand Multi Purpose Flexible Adhesive</td>
<td>200mL, PN 05887; 600mL DMS, PN 55887</td>
</tr>
<tr>
<td>3M™ Performance Manual Applicator</td>
<td>200mL, PN 08117</td>
</tr>
</tbody>
</table>

### Think About Your Health

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ E-A-R™ Skull Screws™ Ear Plug</td>
<td>PN P1300</td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator</td>
<td>PN 07192</td>
</tr>
<tr>
<td>3M™ Lexa™ Protective Eyewear</td>
<td>PN 15200</td>
</tr>
</tbody>
</table>

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

---

**Note:** We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.
### Flexible Patch Non-Structural Bumper Repair

<table>
<thead>
<tr>
<th>Step</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td><strong>Clean the Damaged Area</strong>&lt;br&gt;Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner. Be sure to remove any overspray from the back side of the repair area. A Scotch-Brite™ Scuffing Pad may be used to assist with stubborn overspray.</td>
</tr>
<tr>
<td>2</td>
<td><strong>Initial Grinding</strong>&lt;br&gt;Grind the front of the repair using a 3 in. grade 60 disc. Grind at a low speed creating a “Dish Out” area 3 in. wide that tapers to the bottom of the damage.</td>
</tr>
<tr>
<td>3</td>
<td><strong>Initial Prep Sand</strong>&lt;br&gt;Sand the “Dish Out” area using a P80 abrasive disc on a DA sander, removing any melted plastic. Keep the P80 abrasive scratches within the “Dish Out” area. Using P180 abrasive, feather edge 2–4 in. from the “Dish Out” area.</td>
</tr>
<tr>
<td>4</td>
<td><strong>Apply Reinforcement Patch</strong>&lt;br&gt;On the back side of the repair area apply the flexible patch adhesion promoter. Firmly apply the flexible reinforcement patch overlapping the damaged area by 1-1/2 in. on all sides of the repair.</td>
</tr>
<tr>
<td>5</td>
<td><strong>Mix and Apply Flexible Filler</strong>&lt;br&gt;Apply 3M™ Polyolefin Adhesion Promoter (PN 05907) to the front side of the repair and allow to dry for 5 minutes. Mix and apply flexible filler with a “tight coat” followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.</td>
</tr>
<tr>
<td>6</td>
<td><strong>Sand Flexible Filler</strong>&lt;br&gt;DA sand the flexible filler material with a P150 abrasive disc. Block sand the repair area with a P180 abrasive sheet.</td>
</tr>
<tr>
<td>7</td>
<td><strong>Final Sand and Inspect</strong>&lt;br&gt;Using a DA sander, finish sand the repair and the surrounding area using a P320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 5 and 6 as necessary.</td>
</tr>
</tbody>
</table>

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

### Product List

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<tbody>
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<td>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 320+, PN 31463 6 in., 320+, PN 31483</td>
<td></td>
</tr>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+, PN 31361 3 in., 150+, PN 31363 3 in., 180+, PN 31364 6 in., 80+, PN 31371 6 in., 150+, PN 31373 6 in., 180+, PN 31374</td>
<td></td>
</tr>
<tr>
<td>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 180+ grade, PN 34446</td>
<td></td>
</tr>
<tr>
<td>3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, PN 33391</td>
<td></td>
</tr>
<tr>
<td>3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907</td>
<td></td>
</tr>
<tr>
<td>3M™ EZ Fix Flexible Patch Kit (with adhesion promoter wipes), 4 in. x 8 in., PN 05888</td>
<td></td>
</tr>
<tr>
<td>3M™ Automotive Adhesion Promoter, Sponge Applicator Packets, 2.5mL per packet, PN 06396</td>
<td></td>
</tr>
<tr>
<td>3M™ EZ Sand Multi Purpose Flexible Adhesive, 200mL, PN 05887; 600mL DMS, PN 55887</td>
<td></td>
</tr>
<tr>
<td>3M™ Performance Manual Applicator, 200mL, PN 08117</td>
<td></td>
</tr>
</tbody>
</table>

### Think About Your Health

<table>
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<tr>
<th>Item</th>
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</tr>
</thead>
<tbody>
<tr>
<td>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</td>
<td></td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator, PN 07182</td>
<td></td>
</tr>
<tr>
<td>3M™ Lexa™ Protective Eyewear, PN 15200</td>
<td></td>
</tr>
</tbody>
</table>

**Note:** We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

---

For ordering information, contact your 3M Sales Representative
Two-Sided Bumper Repair
Cracks, Holes & Punctures

1. Clean the Damaged Area
   - Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner.

2. Prepare for Reinforcement Material
   - Apply aluminum autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with grade 80 abrasive disc to sand the repair area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing 5 minutes to dry.

3. Apply Reinforcement Material
   - Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 75°F.

4. Tapering the Front Side
   - Remove the aluminum tape. Grind the front damage using a 3 in. grade 60 disc or grade 36 file belt at a low speed to create a gradual “Dish Out” area 3 in. wide and deep enough to expose a 1/4-inch wide strip of the back side reinforcement material through the center of the damage.

5. Preparing the Repair Area
   - Use a DA with grade 80 abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with grade 180 around the dished out area where the adhesive will eventually be featheredged.

6. Mix and Apply Flexible Filler
   - Blow off the front side repair area with clean dry air, apply aerosol adhesion promoter and allow to dry for 5 minutes. Mix and apply flexible filler material with an initial “tight coat” immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.

7. Sand Flexible Filler
   - Use a DA to sand the flexible filler material with a grade 150 abrasive disc, followed by a block with grade 180.

8. Final Sand and Inspect
   - Use a DA sander to finish sand the repair area using P320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.

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Product List
- 3M™ Polyolefin Adhesion Promoter, 12 oz. aerosol, PN 05907
- 3M™ Plastic Repair Material Semi-Rigid, 200mL cartridge, PN 04240
- 3M™ Reinforcement Patch, 5 in. x 12 ft., roll, PN 04904
- 3M™ File Belt Sander, 18 in., PN 33575; 13 in., PN 33573
- 3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, PN 33391
- 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 320+, PN 31463
- 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 3 in., 80+, PN 31361
- 3M™ Lexa™ Protective Eyewear, PN 15200

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

Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.
General Masking

1. **Clean Area**
   Clean the area with water based cleaner. Wipe area with a VOC compliant solvent prep cleaner. Dry the area. The preferable surface temperature for masking is 60–80°F.

2. **Critical Edge Masking**
   Mask the areas that require fineline tape first. Mask the rest of the repair and back up the fineline with creped tape. Protect any nearby moldings with trim masking tape.

3. **Overspray Protection**
   Ensure that the car is completely dry prior to applying plastic sheeting. Mask entire vehicle with plastic sheeting. Cut out the repair area with a razor blade. Tape the plastic sheeting directly to critical masking edge.

4. **Masking Removal**
   After painting, remove the masking tape at a 90-degree angle to the vehicle’s surface.

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Product List

- **Scotch® Performance Green Masking Tape**
  - 233+, 18mm x 55m (3/4 in. applications), PN 26334;
  - 36mm x 55m (1-1/2 in. applications), PN 26338;
  - 48mm x 55m (2 in. applications), PN 26340

- **3M™ Vinyl Tape 471+**, 1/4 in. width (6.4mm), PN 06405

- **3M™ Perforated Trim Masking Tape**
  - 5mm, PN 06345;
  - 7mm, PN 06347;
  - 10mm, PN 06349;
  - 15mm, PN 06348

- **3M™ Overspray Protective Sheeting**
  - 12 ft. x 400 ft. roll, PN 06727;
  - 16 ft. x 400 ft. roll, PN 06728;
  - 20 ft. x 250 ft. roll, PN 06742

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.
### Mask Openings

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

#### Back Masking
Back mask outer edge of opening using wide width tape, ensuring that half of tape width is exposed to the opening.

#### Overspray Protection
Cover opening with overspray masking film. Pull tight and adhere film to exposed edge of back masking.

#### Trim Opening
Trim film around inner panel opening.

#### Seal Edge
Seal edge of masking film using wide width masking tape.

### Product List

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

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

**Scotch® Performance Green Masking Tape 233+, 36mm width (1.41 in.), PN 26338; 48mm width (1.9 in.), PN 26340**

**3M™ Overspray Protective Sheeting**, 12 ft. x 400 ft. roll, PN 06727; 16 ft. x 400 ft. roll, PN 06728; 20 ft. x 250 ft. roll, PN 06742

### 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.*

### Note
All critical edge, jamb masking and general masking should be completed prior to masking openings.
**Primer Masking**

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

2. **Back Masking**
   Back mask primer application area using tape and paper.

3. **Overspray Protection**
   Apply plastic film to remaining exposed areas, cut out repair area.

4. **Seal Edge**
   Seal edge of masking film using wide width masking tape.

**Product List**

- **3M™ Car Wash Soap Concentrate**, 1 gallon, PN 38377
- **3M™ All Purpose Cleaner and Degreaser Concentrate**, 1 gallon, PN 38350
- **3M™ Scotchblok™ Masking Paper**, 18 in. x 750 ft., PN 06718
- **3M™ Overspray Protective Sheeting**, 12 ft. x 400 ft. roll, PN 06727; 16 ft. x 400 ft. roll, PN 06728; 20 ft. x 250 ft. roll, PN 06742
- **Scotch® Performance Green Masking Tape 233+**, 18mm width (.71 in.), PN 26334; 36mm width (1.41 in.), PN 26338; 48mm width (1.9 in.), PN 26340
- **3M™ E-A-R™ Skull Screws™ Ear Plug**, PN P1300
- **3M™ Lexa™ Protective Eyewear**, PN 15200
- **3M™ Half Facepiece Respirator**, PN 07182

**Think About Your Health**

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

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### Prep New Parts

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Instructions</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Clean</td>
<td>Clean parts to be painted with a VOC compliant wax and grease remover to remove any remaining surface contamination.</td>
</tr>
<tr>
<td>2</td>
<td>Scuff</td>
<td>Use a P320 abrasive on a DA equipped with a soft interface pad or a red Scotch-Brite™ Hand Pad to sand the part.</td>
</tr>
<tr>
<td>3</td>
<td>Clean</td>
<td>Blow off the repair area with clean, dry air and a clean cloth. Clean parts to be painted with a VOC compliant wax and grease remover to remove any remaining surface contamination.</td>
</tr>
<tr>
<td>4</td>
<td>Apply Top Coats</td>
<td>Seal and paint bumper following paint company recommendations.</td>
</tr>
</tbody>
</table>

### Product List

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
<th>PN</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Specialty Adhesive Remover, 15 oz. aerosol</td>
<td></td>
<td>38987</td>
</tr>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 320+,</td>
<td></td>
<td>31483</td>
</tr>
<tr>
<td>Festool D150 Thin Interface Pad</td>
<td></td>
<td>29939</td>
</tr>
<tr>
<td>Scotch-Brite™ General Purpose Hand Pad</td>
<td></td>
<td>07447</td>
</tr>
<tr>
<td>3M™ Accuspray™ ONE Spray Gun</td>
<td></td>
<td>16579</td>
</tr>
</tbody>
</table>

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<td></td>
<td>P1300</td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator</td>
<td></td>
<td>07182</td>
</tr>
<tr>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket</td>
<td></td>
<td>11872</td>
</tr>
</tbody>
</table>

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

Visit 3MCollision.com for more SOPs and videos.
### Prime Parts (Aluminum, SMC, FRP, Composite)

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Instructions</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Assess and Sand</td>
<td>Assess damaged area for flatness/straightness. Use P220 abrasive, if necessary, on a DA over the entire repaired area to guarantee the surface is ready to prime. Blow off the repair area with clean, dry air and a clean cloth. Then clean with a VOC compliant wax and grease remover to remove any remaining surface contamination.</td>
</tr>
<tr>
<td>2</td>
<td>Apply Primer and Finish Sand</td>
<td>Apply primer to repair area following manufacturer’s recommendations. Apply 3M™ Dry Guide Coat over the entire repaired area. Sand with P220 abrasive to ensure flatness.</td>
</tr>
<tr>
<td>3</td>
<td>Block Sand</td>
<td>Double check flatness of the repair by block sanding it with P220 abrasive.</td>
</tr>
<tr>
<td>4</td>
<td>Paint</td>
<td>Paint per manufacturer’s recommendation.</td>
</tr>
</tbody>
</table>

Visit 3MCollision.com for more SOPs and videos

### Product List

<table>
<thead>
<tr>
<th>Product</th>
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</tr>
</thead>
<tbody>
<tr>
<td>3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 220+ grade, PN 31481</td>
<td></td>
</tr>
<tr>
<td>3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987</td>
<td></td>
</tr>
<tr>
<td>3M™ Dry Guide Coat, PN 05861</td>
<td></td>
</tr>
<tr>
<td>3M™ Hookit™ Purple Clean Sanding Sheet Roll, 220 grade, 70mm x 12m, PN 30708</td>
<td></td>
</tr>
<tr>
<td>3M™ Hookit™ Sanding Block Dust Free, 70mm x 127mm, PN 05207</td>
<td></td>
</tr>
<tr>
<td>3M™ Accuspray™ ONE Spray Gun, PN 16579</td>
<td></td>
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<tr>
<td>3M™ Half Facepiece Respirator, PN 07182</td>
<td></td>
</tr>
<tr>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872</td>
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Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

For ordering information, contact your 3M Sales Representative
### Refinish Bumper Prep

**1**  
**Cleaning**  
Clean part with soap and water, followed by a VOC compliant surface cleaner.

**2**

- **2A**  
  **Surface Prep Hand**  
  Sand edges and other hard-to-reach areas using P800–P1000 flexible abrasive sheet until the surface is matte and all sheen has been removed.

- **2B**  
  **Surface Prep Machine**  
  Sand remaining surfaces using P800–P1000 flexible abrasives on an orbital sander until the surface is matte and all sheen has been removed.

**3**  
**Re-Clean**  
Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

**4**  
**Apply Top Coats**  
Seal and paint bumper following paint company recommendations.

---

### Product List

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Quantity</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38360</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3M™ Flexible Abrasive Hookit™ Sheet, P800, PN 34340; P1000, PN 34341</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3M™ Flexible Abrasive Hookit™ Foam Pad, PN 34349</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3M™ Orbital Sander, 3 in. x 4 in. Non-Vacuum, 10,000 RPM, PN 20331</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3M™ Accuspray™ ONE Spray Gun, PN 16579</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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### 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.*
### New Primed Bumper Prep

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

2. **Surface Prep Hand**
   Sand edges and other hard-to-reach areas using P400 flexible abrasive sheet until the surface is matte and all sheen has been removed.

2A. **Surface Prep Machine**
   Sand remaining surfaces using P400 flexible abrasives on an orbital sander until the surface is matte and all sheen has been removed.

3. **Re-clean**
   Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

4. **Apply Top Coats**
   Seal and paint bumper following paint company recommendations.

---

### 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

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

- **3M™ Orbital Sander,**
  3 in. x 4 in. Non-Vacuum, 10,000 RPM, PN 20331

- **3M™ Accuspray™ ONE Spray Gun,**
  PN 16579

### 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.

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For ordering information, contact your 3M Sales Representative
## E-Coat Panel Prep

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Cleaning</td>
<td>Clean part with soap and water, followed by a VOC compliant surface cleaner.</td>
</tr>
<tr>
<td>2A</td>
<td>Surface Prep Hand</td>
<td>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.</td>
</tr>
<tr>
<td>2B</td>
<td>Surface Prep Machine</td>
<td>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.</td>
</tr>
<tr>
<td>3</td>
<td>Re-clean</td>
<td>Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.</td>
</tr>
<tr>
<td>4</td>
<td>Apply Top Coats</td>
<td>Seal and paint following paint company recommendations.</td>
</tr>
</tbody>
</table>

### 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**, PN 16579

### 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.*

Visit 3MCollision.com for more SOPs and videos.
# Standard Operating Procedures
## Paint Repair

### Feather-Prime-Block

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
</tr>
</thead>
</table>
| **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 SOP for 3M specific recommendations. |
| **4** | Apply Primer  
Apply primer to repair area following manufacturer’s 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 P920 abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, reapply dry guide coat and continue block sanding to repair any defects as required. |
| **7** | Reapply Dry Guide Coat  
Reapply 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. **Note:** Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface. |
| **9** | Clean the Damaged Area  
Clean the repair area with a VOC compliant surface cleaner. |

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### Product List

- 3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374
- 3M™ Purple Clean Sanding Hookit™ Disc, 6 in., P400 grit, PN 01811
- 3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P400, PN 34800
- 3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861
- 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 6 in., 320+, PN 31483
- 3M™ Accuspray™ ONE Spray Gun, PN 16579
- 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, 320+, PN 34449
- Festool D150 Thin Interface Pad, PN 29939

### 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

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<th>Task</th>
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<tr>
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<td><strong>Featheredge</strong>&lt;br&gt;Blow off repair area. Featheredge the surrounding repair area using P180 abrasive.</td>
</tr>
<tr>
<td>2</td>
<td><strong>Final Sand and Inspect</strong>&lt;br&gt;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.</td>
</tr>
<tr>
<td>3</td>
<td><strong>Mask for Primer</strong>&lt;br&gt;Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.</td>
</tr>
<tr>
<td>4</td>
<td><strong>Apply Primer</strong>&lt;br&gt;Apply primer to repair area following manufacturer’s recommendations. Allow to cure.</td>
</tr>
<tr>
<td>5</td>
<td><strong>Apply Dry Guide Coat</strong>&lt;br&gt;Apply 3M™ Dry Guide Coat over cured primer.</td>
</tr>
<tr>
<td>6</td>
<td><strong>Hand Block Repair</strong>&lt;br&gt;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, reapply dry guide coat and continue block sanding to repair any defects as required.</td>
</tr>
<tr>
<td>8</td>
<td><strong>DA Sand Primer</strong>&lt;br&gt;DA sand repair area using a P400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed. <strong>Note:</strong> Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.</td>
</tr>
<tr>
<td>10</td>
<td><strong>DA Sand Primer</strong>&lt;br&gt;DA Sand repair area using a P600–P800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed. <strong>Note:</strong> Use 3M™ Flexible Abrasive Disc to reduce burning through the primer surface.</td>
</tr>
<tr>
<td>11</td>
<td><strong>Clean the Damaged Area</strong>&lt;br&gt;Clean the repair area with a VOC compliant surface cleaner.</td>
</tr>
</tbody>
</table>

Visit 3MCollision.com for more SOPs and videos

---

**Product List**

- **3M™ Cubitron™ II Clean Sanding Hookit™ Disc**<br>6 in., 180+ grade, PN 31374
- **3M™ Accuspray™ ONE Spray Gun**, PN 16579
- **3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll**, 70mm x 12m, 320+, PN 34449
- **Festool D150 Thin Interface Pad**, PN 29939
- **3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc**, 6 in., 320+, PN 31483
- **3M™ Purple Clean Sanding Hookit™ Disc**<br>334U, 6 in., P400 grit, PN 01811; 6 in., P600 grit, PN 30761; 6 in., P800 grit, PN 30760
- **3M™ Flexible Abrasive Hookit™ Disc**, 17 hole, 6 in., P400, PN 34800; 6 in., P600, PN 34801; 6 in., P800, PN 34802

**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.*
**Blend Panel Sanding Process**

1. **Clean the Repair Area**
   - Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.

2. **Hand Sand Edges**
   - Scuff hard-to-reach areas and panel edges by hand with P800–P1000 abrasive disc or flexible abrasive sheet.

3. **DA Sand Color Blend Area**
   - DA sand the color blend area using a grade P800 abrasive disc and a soft interface pad. For best results, sand back into primer surfacer. **Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the top coat surface.**

4. **DA Sand Adjacent Panels**
   - DA sand the remainder of the blend panel(s) using a P1000 abrasive disc.

5. **Clean and Inspect**
   - Clean the repair area with a VOC compliant or paint manufacturer recommended surface cleaner. Blow dry the repair area with clean, dry air. Inspect the repair area and re-sand any shiny spots as necessary.

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**Product List**

- 3M™ Trizact™ Hookit™ Blending Disc, 6 in., P1000, PN 02090
- 3M™ Flexible Abrasive Hookit™ Sheet, 5.5 in. x 6.8 in., P800, PN 34340
- 3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P800 grit, PN 30760
- 3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P800, PN 34802; 6 in., P1000, PN 34803
- Festool D150 Thin Interface Pad, PN 29939

**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

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3M™ PPS™ Series 2.0 Spray Cup System

An innovative, all-in-one disposable system that enables painters to eliminate expensive liquid coating waste left on mixing cups and filters by mixing directly in the PPS cup. Mix, measure, filter and spray your coating materials.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Accuspray™ Spray Gun Kits</td>
<td></td>
</tr>
<tr>
<td>16579</td>
<td>3M™ Accuspray™ ONE Spray Gun</td>
</tr>
<tr>
<td>16587</td>
<td>3M™ Accuspray™ HGP Spray Gun Kit</td>
</tr>
<tr>
<td>3M™ Accuspray™ Atomizing Heads for 3M™ PPS™ Series 2.0</td>
<td></td>
</tr>
<tr>
<td>22612</td>
<td>1.2mm, blue</td>
</tr>
<tr>
<td>22613</td>
<td>1.3mm, green</td>
</tr>
<tr>
<td>22614</td>
<td>1.4mm, orange</td>
</tr>
<tr>
<td>22618</td>
<td>1.8mm, clear</td>
</tr>
<tr>
<td>22620</td>
<td>2.0mm, red</td>
</tr>
</tbody>
</table>

3 fluid ounces

Ideal for spot repairs that require 3 fluid ounces of material or less.

- 3M™ PPS™ Series 2.0 Micro Cup System Kit, PN 26028, 3 fl. oz. (90mL) full diameter 200 micron filters
- 3M™ PPS™ Series 2.0 Micro Cup System Kit, PN 26328, 3 fl. oz. (90mL) full diameter 125 micron filters

6.8 fluid ounces

Ideal for small areas that require 6.8 fluid ounces of material or less.

- 3M™ PPS™ Series 2.0 Mini Cup System Kit, PN 26114 6.8 fl. oz. (200mL) full diameter 200 micron filters
- 3M™ PPS™ Series 2.0 Mini Cup System Kit, PN 26314 6.8 fl. oz. (200mL) full diameter 125 micron filters
### 13.5 fluid ounces

Ideal for areas that require 13.5 fluid ounces of material or less.

- **3M™ PPS™ Series 2.0 Midi Cup System Kit**, PN 26112, 13.5 fl. oz. (400mL) full diameter 200 micron filters
- **3M™ PPS™ Series 2.0 Midi Cup System Kit**, PN 26312, 13.5 fl. oz. (400mL) full diameter 125 micron filters

### 22 fluid ounces

Ideal for large areas that require 22 fluid ounces of material or less.

- **3M™ PPS™ Series 2.0 Standard Cup System Kit**, PN 26000, 22 fl. oz. (650mL) full diameter 200 micron filters
- **3M™ PPS™ Series 2.0 Standard Cup System Kit**, PN 26301, 22 fl. oz. (650mL) full diameter 125 micron filters

### 28 fluid ounces

Ideal for large jobs that require 28 fluid ounces of material or less.

- **3M™ PPS™ Series 2.0 Large Cup System Kit**, PN 26024, 28 fl. oz. (850mL) full diameter 200 micron filters
- **3M™ PPS™ Series 2.0 Large Cup System Kit**, PN 26325, 28 fl. oz. (850mL) full diameter 125 micron filters

For ordering information, contact your 3M Sales Representative
# Paint Finishing: Small Areas

<table>
<thead>
<tr>
<th>Step</th>
<th>Task</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1</strong></td>
<td>Initial Defect Removal</td>
<td>DA sand the repair area with a 4 in. P1500 finishing film disc, removing all paint defects. Wipe panel clean. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc.</td>
</tr>
<tr>
<td><strong>2</strong></td>
<td>Scratch Refinement P3000</td>
<td>Refine the P1500 scratches with a DA and a 4 in. P3000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. Wipe panel clean.</td>
</tr>
<tr>
<td><strong>3</strong></td>
<td>Scratch Refinement 5000 (Optional)</td>
<td>Refine the P3000 scratches with a DA and a 4 in. 5000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area five times. The use of P3000 is required prior to 5000 for best results.</td>
</tr>
<tr>
<td><strong>4</strong></td>
<td>Buff</td>
<td>Compound the repair area with a 4 in. polisher. Use a 4 in. foam compound pad and the appropriate rubbing compound. Wipe panel clean.</td>
</tr>
<tr>
<td><strong>5</strong></td>
<td>Polish</td>
<td>Polish the repair area with a 4 in. polisher. Use a 4 in. black foam polishing pad and the appropriate machine polish. Wipe panel clean with a yellow microfiber cloth.</td>
</tr>
<tr>
<td><strong>6</strong></td>
<td>Swirl Elimination</td>
<td>Ultrafine polish the repair area with a 4 in. polisher. Use a 4 in. blue foam polishing pad and ultrafine machine polish. Leave a light film of polish on the surface and wipe the panel clean with a blue microfiber cloth.</td>
</tr>
<tr>
<td><strong>7</strong></td>
<td>Final Detail</td>
<td>Clean sling from adjacent panels and door jamb areas. Doing this immediately after the repair will greatly improve the ease of this step.</td>
</tr>
</tbody>
</table>

Visit 3MCollision.com for more SOPs and videos

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# Product List

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 3 in., P1500 grit, PN 02094</td>
<td></td>
</tr>
<tr>
<td>3M™ Purple Finishing Film Hookit™ Disc, 3 in., P1500 grit, PN 30367</td>
<td></td>
</tr>
<tr>
<td>3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771</td>
<td></td>
</tr>
<tr>
<td>3M™ Pistol Grip Disc Sander, PN 33577</td>
<td></td>
</tr>
<tr>
<td>3M™ Trizact™ Hookit™ Foam Disc, 3 in., 3000 grit, PN 02087; 5000 grit, PN 30362</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ EX AC Rubbing Compound, 1 qt., PN 36060</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Foam Compounding Pad, Single Sided with Inset, Hookit™ Attachment, 4 in., PN 30041</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ EX Machine Polish, 1 qt., PN 06094</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Foam Polishing Pad, Single Sided with Inset, Hookit™ Attachment, 4 in., PN 30042</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Jumbo Detailing Cloth, PN 06018</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ EX Ultrafine Machine Polish, 1 qt., PN 06068</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Ultrafine Foam Polishing Pad, Single Sided with Inset, Hookit™ Attachment, 4 in., PN 30043</td>
<td></td>
</tr>
</tbody>
</table>

# Think About Your Health

<table>
<thead>
<tr>
<th>Product</th>
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</tr>
</thead>
<tbody>
<tr>
<td>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</td>
<td></td>
</tr>
<tr>
<td>3M™ Half Facepiece Respirator, PN 07182</td>
<td></td>
</tr>
<tr>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872</td>
<td></td>
</tr>
</tbody>
</table>

Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.
### Paint Finishing: Large Areas

#### Initial Defect Removal Texture Match
DA sand the repair area with a P1500/P2000 3M™ Purple Finishing Film Hookit™ Disc or P1500 3M™ Trizact™ Clearcoat Sanding Disc used damp. Remove all paint defects and match texture to adjacent OEM panels. Wipe panel clean.

#### Scratch Refinement 3000
Refine the P1500/P2000 scratches with a DA and a 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean.

#### Scratch Refinement 5000 (Optional)
To reduce your buffing time refine the 3000 scratches with a DA and a 5000 grit 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean. The use of 3000 is required prior to 5000 for best results.

#### Compound
Compound the repair area with a high speed polisher set between 1200–2000 RPM. For faster results, use a foam compounding pad and the appropriate rubbing compound. To insure all sand scratches have been removed, inspect the surface by spraying with an Inspection Spray and wipe clean with a yellow microfiber cloth.

#### Machine Polish
Polish the repair area with a high speed polisher set between 1200–2000 RPM. Use a black foam polishing pad and the appropriate machine polish. Wipe the panel clean with a yellow microfiber cloth.

#### Ultrafine Machine Polish
Polish the repair area with a high speed polisher with the speed set between 1200–2000 RPM. Use a blue foam polishing pad and the appropriate ultrafine machine polish. Leave a light film of the polish on the panel and wipe clean with a blue microfiber cloth.

#### Final Detail
Remove any masking material from the repair area and clean any residual sling from adjacent panels and door jamb areas. Cleaning the panel immediately after compounding and polishing will greatly improve the ease of cleaning. Inspect the surface using the 3M™ PPS™ SUN GUN™ II Light Kit.

---

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<thead>
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<tbody>
<tr>
<td>3M™ Purple Finishing Film Hookit™ Disc</td>
<td>6 in., P1500, PN 30667; P2000, PN 30666</td>
<td></td>
</tr>
<tr>
<td>3M™ Trizact™ Clearcoat Sanding Disc</td>
<td>6 in., P1500, PN 02088</td>
<td></td>
</tr>
<tr>
<td>Festool D150 Thin Interface Pad</td>
<td>PN 29939</td>
<td></td>
</tr>
<tr>
<td>3M™ Purple Finishing Film Hookit™ Disc</td>
<td>6 in., 3000, PN 30666; 6 in., 5000 grit, PN 30662</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ EX AC Rubbing Compound</td>
<td>1 qt., PN 36060</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Foam Compounding Pad</td>
<td>Double Sided, Quick Connect, 9 in., PN 05706</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Low Linting 100% Wool Compound Pad</td>
<td>Double Sided, Quick Connect, PN 33279</td>
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</tr>
<tr>
<td>3M™ Quick Connect Adaptor</td>
<td>14mm. Thread, PN 33271</td>
<td></td>
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<tr>
<td>3M™ Perfect-It™ EX Machine Polish</td>
<td>1 qt., PN 06084</td>
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<tr>
<td>3M™ Perfect-It™ Foam Polishing Pad</td>
<td>Double Sided, Quick Connect, 9 in., PN 05707</td>
<td></td>
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<tr>
<td>3M™ Inspection Spray</td>
<td>1 gallon, PN 06082</td>
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</tr>
<tr>
<td>3M™ Perfect-It™ EX Ultrafine Machine Polish</td>
<td>1 qt., PN 06088</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Ultrafine Foam Polishing Pad</td>
<td>Double Sided, Quick Connect, 9 in., PN 05708</td>
<td></td>
</tr>
<tr>
<td>3M™ Perfect-It™ Detail Cloth</td>
<td>PN 06016; PN 06020</td>
<td></td>
</tr>
<tr>
<td>3M™ PPS™ SUN GUN™ II Light Kit</td>
<td>PN 16550; 16 fl. oz. bottle, PN 06084</td>
<td></td>
</tr>
</tbody>
</table>

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### Think About Your Health

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<td>3M™ Half Facepiece Respirator</td>
<td>PN 07182</td>
<td></td>
</tr>
<tr>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket</td>
<td>PN 11872</td>
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Headlight Restoration

1. **Clean and Mask**
   Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.

2. **Sand to Remove Yellowing and Defects**
   Dry DA sand the damaged headlight lens with a 4 in. P500 abrasive disc using a soft interface pad. Completely remove any yellowing and/or surface defects.

3. **1st Step Scratch Refinement**
   Refine the P500 sand scratches by dry DA sanding with a 4 in. P800 abrasive disc on a soft interface pad. Wipe the headlight lens clean.

4. **2nd Step Scratch Refinement**
   Refine the P800 sand scratches by DA sanding with a 4 in. P1000 foam disc on a soft interface pad. Use water to lubricate the P1000 foam abrasive disc. Spend extra time on this step to ensure removal of all P800 sand scratches. Wipe the headlight lens clean.

5. **3rd Step Scratch Refinement**
   Refine the P1000 sand scratches by DA sanding with a 4 in. P3000 foam abrasive disc on a soft interface pad. Use water to lubricate the P3000 foam abrasive disc. Spend extra time on this step to ensure removal of all P1000 sand scratches. Wipe the headlight lens clean.

6. **Compound Lens**
   Completely remove the P3000 sand scratches using a 4 in. polishing tool with a foam compounding pad and rubbing compound. Wipe the headlight lens with a clean microfiber cloth.

7. **Polish Lens**
   Polish the headlight lens using a 4 in. foam polishing pad and machine polish. Wipe the headlight lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.

Product List

- 3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377
- Scotch® Performance Masking Tape 233+, 18mm x 55m, PN 26334
- 3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771
- 3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P500, PN 30272; 3 in., P800, PN 30260
- 3M™ Trizact™ Hookit™ Blending Disc, 3 in., P1000, PN 02091
- 3M™ Trizact™ Hookit™ Foam Disc, 3 in., 3000, PN 02087
- 3M™ Perfect-It™ EX AC Rubbing Compound, 8 oz., PN 36058
- 3M™ Perfect-It™ Foam Buffing Pad, 4 in., PN 30041
- 3M™ Perfect-It™ EX Machine Polish, 8 oz., PN 06093
- 3M™ Perfect-It™ Foam Polishing Pad, 4 in., PN 30042
- 3M™ Perfect-It™ Detail Cloth, PN 06016

Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300
- 3M™ Half Facepiece Respirator, PN 07182
- 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872

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<thead>
<tr>
<th>Clean-Up Process</th>
<th>Product List</th>
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<tbody>
<tr>
<td><strong>1</strong> Inspect</td>
<td>3M™ Detailing Diluter, PN 37721</td>
</tr>
<tr>
<td>Remove any trash and blow out the air vents. Vacuum the interior of the truck. Inspect the carpet and upholstery for any heavily soiled stains that may require a pre-spot treatment.</td>
<td>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350</td>
</tr>
<tr>
<td><strong>2</strong> Clean Interior and Glass</td>
<td>3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377</td>
</tr>
<tr>
<td>Clean interior vinyl and leather using 3M™ All Purpose Cleaner and Degreaser at a 1:30 dilution ratio. Clean the interior and the exterior of the windows with glass cleaner. Use an extractor on carpet or fabric as needed.</td>
<td>3M™ Glass Cleaner Concentrate, 1 gallon, PN 38399</td>
</tr>
<tr>
<td><strong>3</strong> Rinse Truck Exterior</td>
<td>3M™ Detailing Spray Bottle, PN 37716</td>
</tr>
<tr>
<td>Scrub, pressure wash, and rinse any areas where pre-cleaner was applied. Rinse the entire vehicle to remove loose dirt and debris.</td>
<td>3M™ Spray Trigger Nozzle Head, PN 37717 or PN 37718</td>
</tr>
<tr>
<td><strong>4</strong> Wash Truck Exterior</td>
<td>3M™ Silicone Free Tire Dressing, 1 gallon, PN 38327</td>
</tr>
<tr>
<td>Pre-soak any remaining bugs, soiled areas or compound residue using 3M™ All Purpose Cleaner and Degreaser at a 1:15 ratio. Wash the entire vehicle, then rinse. Dry, using a water blade or chamois as needed.</td>
<td>3M™ Perfect-It™ III Truck Detailing Cloth, PN 06020</td>
</tr>
<tr>
<td><strong>5</strong> Apply Tire Dressing</td>
<td>3M™ Perfect-It™ Clean and Shine, 16 oz., PN 06084</td>
</tr>
<tr>
<td>Dress the tires with a silicone-free tire dressing, being sure to remove the excess with an absorbent cloth.</td>
<td></td>
</tr>
<tr>
<td><strong>6</strong> Final Detail</td>
<td>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</td>
</tr>
<tr>
<td>Apply a body shop safe spray detailer to the vehicle’s exterior surfaces by misting on and wiping off. Spray detailer will remove any compound residue, dust or fingerprints and will also improve gloss.</td>
<td>3M™ Half Facepiece Respirator, PN 07182</td>
</tr>
<tr>
<td></td>
<td>3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872</td>
</tr>
</tbody>
</table>

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