






Cosmetic Repair (SMC, FRP, Composites)		
1		<p>Clean the Damaged Area</p> <p>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.</p>
2		<p>Rough Grind</p> <p>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.</p>
3		<p>Feather-edge</p> <p>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.</p>
4		<p>Adhesion Promoter</p> <p>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.</p>
5		<p>Apply</p> <p>Following product instructions, apply a tight coat of adhesive/filler to the repair area to ensure 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 65°C for 15 minutes.</p>
6		<p>Rough Sand and Shape Filler</p> <p>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.</p>
7		<p>Final Sand and Inspect</p> <p>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.</p>

Product List	
3M™ Car Wash Soap Concentrate, 3.7L, PN 38377	
3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 75mm, PN 33391	
3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 150mm 180+ grade, PN 31374 220+ grade, PN 31481	
3M™ Polyolefin Adhesion Promoter, PN 05907	
3M™ Automix EZ Sand Rigid Parts Repair, 200ml, PN 05885	
3M™ Dynatron® Yellow Spreaders, PN 344	
3M™ Dry Guide Coat, PN 05861	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Face Welding Respirator Kit, PN 6228	
3M™ Solus™ 1000 Series Scotchgard™ Anti-fog Eyewear, PN S1201SGAF	
<p>Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>	