






Large Damage Repair		
1		<p>Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).</p>
2		<p>Initial Prep Sand DA sand the repair area using grade 80, removing paint beyond damage by 24 - 48mm. Blow off with clean, dry air and re-clean with surface cleaner.</p>
3		<p>Final Metal Prep Remove remaining paint/coatings in "low spots" using a Scotch-Brite™ Clean N Strip disc. Use a 75mm grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.</p>
4		<p>Mix and Apply Filler Mix and apply filler per manufacturer's recommendation. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 24°C.</p>
5		<p>Initial Sand Filler Block shape sand filler with P80. DA rough featheredge area with P80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.</p>
6		<p>Final Sand Filler Final block sand filler with P180 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.</p>
7		<p>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. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 24°C.</p>
8		<p>Sand Glaze Block sand polyester glaze with P180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.</p>
9		<p>Final Sand and Inspect Blow off repair area. Featheredge the surrounding area using P180 abrasive. Inspect the repair for quality.</p>

Product List
<p>3M™ Car Wash Soap Concentrate, 3.7L, PN 38377</p> 
<p>3M™ All Purpose Cleaner and Degreaser Concentrate, 3.7L, PN 38350</p> 
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc, 76mm, 80+ grade, PN 31361 150mm, 80+ grade, PN 31371</p> 
<p>3M™ Platinum™ Plus Body Filler, 3.7L, PN 01131</p> 
<p>3M™ Cubitron™ II Fibre Roloc™ Disc, 76mm, 80+ grade, PN 33392</p> 
<p>Scotch-Brite™ Roloc™ Clean N Strip XT Disc CX-DR</p> 
<p>Scotch-Brite™ Roloc™ + Clean N Strip TR Disc, PN 07466</p> 
<p>3M™ Platinum™ Plus Finishing Glaze, 887ml, PN 31180</p> 
<p>3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861</p> 
<p>3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12M, 80+ grade, PN 34442 180+ grade, PN 34446</p> 
<p>3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 150mm, 180+ grade, PN 31374</p> 

Think About Your Health
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p> 
<p>3M™ Half Face Welding Respirator Kit, PN 6228</p> 
<p>3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS</p> 
<p>Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.</p>