

Feather-Prime-Block Waterborne		
1		Featheredge Blow off repair area. Featheredge the surrounding repair area using P240 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 manufacturers 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 P320 abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, re-apply dry guide coat and continue block sanding to repair any defects as required.
7		Re-Apply Dry Guide Coat Re-apply 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.
9		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over hand blocked repair area.
10		DA Sand Primer DA Sand repair area using a P600–P800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed.
11		Clean the Damaged Area Clean the repair area with a VOC compliant surface cleaner.

Product List

3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 150mm, 180+ grade, PN 31374



3M™ Dry Guide Coat, 50g applicator kit, PN 05861



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



3M™ Hookit™ Purple Clean Sanding Roll, 70mm x 12M, P320, PN 30705



3M™ Soft Multihole Interface Pad, 150mm, 5mm PN 50545
150mm, 10mm PN 50544



3M™ Purple Clean Sanding Hookit™ Disc, 150mm, P320, PN 01812
P400, PN 01811
P600, PN 30761
P800, PN 30760



Think About Your Health

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



3M™ Half Face Welding Respirator Kit, PN 6228



3M™ Secure Fit™ 200 Series Anti-fog Eyewear, Clear Frame, PN 201AF-AS



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