3M Sanding Process

PERSONAL SAFETY
- Comfort Particle Mask P3
- Hearing Protection
- Comfort Goggles
- Reusable Overall
- Nitrile Gloves

1 Cleaning surface
- Degrease the surface using paint company or other recommended product. Always follow the manufacturer’s instructions.

2 Sanding edges
- 3M™ Hookit™ 255P+ P80 - P120.
- Identify and highlight sanding scratches through the application of dry guide coat.
- 3M™ Hookit™ P180 - P320.
- Refine previous sanding scratches which reduces the possibility of solvents from the body filler penetrating into the OEM paint layers. If this happens it can lead to surface swelling around the repair.

3 Application of dry guide coat
- Apply body filler to damaged area, avoiding surrounding paintwork.
- Note: In general it is recommended to apply body filler to bare metal to avoid swelling. If this is not possible, the painted area around the bare metal should be sanded lightly prior to body filler application. Always follow OEM recommendations.

4 Pre-sanding area
- Highlight low and high spots in the filler through the application of dry guide coat.

5 Pre-sanding edges
- 3M™ Hookit™ 255P+ P80 - P120.
- Identify and highlight sanding scratches through the application of dry guide coat.

6 Fine sanding
- 3M™ Hookit™ Flexible Abrasive Sheets P800-P1000.
- Note: For maximum process safety.

7 Sanding curved areas
- 3M™ Hookit™ 255P+ P240 - P320.
- It is advisable to work with a soft interface pad when sanding curved areas.
- Tip: The choice of the fine grit has to be adjusted to the solvent sensitivity of the original paint. The higher the solvent sensitivity of the original paint, as finer the sanding before primer application.

8 Sanding the primer
- 3M Hookit™ Hand Block and 3M™ Hookit™ 255P+ P320.
- Highlight the texture and structure of the primer using dry guide coat.

9 Pre-sanding the primer
- 3M™ Hookit™ Flexible Abrasive Sheets P1000.
- Marking the sanding scratches - application of dry guide coat.

10 Sanding the body filler
- Eccentric sanding with 3M™ Hookit™ 255P+ P400 - P500.
- Tip: when sanding curved areas please use a soft interface pad.
- Dedusting of the surface with 3M™ Scotch-Brite™ Abrasive Discs.

11 Finishing the body filler
- 3M™ Hookit™ Flexible Foam Disc P800-P1000 large area sanding of the original paint.
- Note: For maximum process safety.