

PERSONAL SAFETY

• Comfort Particle Mask P2



• Hearing Protection



• Comfort Goggles



• Reusable Workwear



• Safety Gloves



1 Pre-Sanding of the damaged area		<ul style="list-style-type: none"> ▶ Perform initial sanding using a handblock in order to spot high and low spots on the repair area ▶ Mark the deepest points in the damaged area in order to place welding points <p>Tip: Don't remove the paint completely from the damaged area as this will allow you to better complete the dent pulling process and reduce the likelihood of causing holes in the substrate</p>	<p>3M™ Hookit™ Purple+ Abrasive Sheet Multihole 70 x 396mm</p> <p>3M™ Hookit™ Purple+ Multihole Handblock, 70 x 396mm</p>
2 Preparation		<ul style="list-style-type: none"> ▶ Remove paint/coating in the low points of the repair area, in preparation for dent pulling 	<p>3M™ Scotch-Brite™ Roloc™ Disc</p> <p>3M™ Body Repair Pistol Grip Disc Sander</p>
3 Spot Application		<ul style="list-style-type: none"> ▶ Spot weld onto the repair area using your preferred and recommended method and/or equipment <p>Note: Always ensure that the equipment is properly calibrated depending on the materials being repaired</p>	
4 Dent Pulling		<ul style="list-style-type: none"> ▶ Pull the spots of dent using preferred dent pulling method and equipment <p>Tip: To avoid surface imperfections or pinholes in the substrate, aim to distribute the load across the repair area</p>	
5 Spot Removal		<ul style="list-style-type: none"> ▶ Spot removal by rotating the welded spot manually <p>Note: This modern method will reduce the likelihood of causing holes in the substrate and avoid the thin out of the substrate due to a coarse sanding step for the removal</p>	
6 Sanding down the job area		<ul style="list-style-type: none"> ▶ Sanding down the job area to bare metal ▶ Switch to ROTEX motion for high abrasion first ▶ For fine sanding step switch to ROTEX orbital random motion, without changing the sanding disc or grit! <p>Note: For aluminium substrates, always use a pneumatic sanding tool such as Festool Automotive Systems LEX 3 150/7 and follow instructions of ATEX directive 94/9/EG for Zone 22 areas</p>	<p>3M™ Hookit™ Cubitron™ II 80+ - 120+ - 125mm</p> <p>Festool RO 125</p> <p>3M™ Hookit™ Cubitron™ II 80+ - 120+ - 150mm</p> <p>Festool LEX 3 150/7</p>
7 Cleaning of the surface		<ul style="list-style-type: none"> ▶ Degrease the surface 	<p>3M™ General Purpose Adhesive Cleaner</p> <p>3M™ Professional Panel Wipes</p>
8 Application		<ul style="list-style-type: none"> ▶ Apply enough 3M™ FC Epoxy Metal Filler for dent filling ▶ Recommended settings for applicators: pneumatic max. inlet pressure 5.5 bar / battery driven 3kN, max speed 180mm/min. <p>Note: A new cartridge needs to be equalised before the first application to ensure thorough mixing of the product. After the first use, no further equalisation is necessary</p>	<p>3M™ FC Epoxy Metal Filler</p> <p>3M™ Static Mixing Nozzle</p> <p>3M™ Plastic Spreader</p> <p>3M™ High Power Manual Gun</p>
9 Drying		<ul style="list-style-type: none"> ▶ The curing of 3M™ FC Epoxy Metal Filler can be accelerated using IR drying after the initial gelling period. Wait 10 minutes before using an IR dryer to heat for 10-20 minutes with a panel temperature of 70 °C ▶ Airdrying: sandable ~ after 4 h @ 22 °C ambient temperatures ▶ Tip for use: warming up the material & surface to ~30°C before material application will help to accelerate curing, particularly at cold ambient temperatures 	
10 Sanding of the filler area		<ul style="list-style-type: none"> ▶ 3M™ Cubitron™ II 80+ - 120+. ▶ To remove coatings more quicker, use the ROTEX motion setting ▶ To refine previous sanding scratches, switch to ROTEX orbital random motion, keeping the previous abrasive disc on the machine <p>Tip: Pre-sanding step can also be done by using traditional body files if necessary</p>	<p>3M™ Hookit™ Cubitron™ II 80+ - 120+ - 125mm</p> <p>Festool RO 125</p> <p>3M™ Hookit™ Cubitron™ II 80+ - 120+ - 150mm</p> <p>Festool LEX 3 150/7</p>
11 Cleaning of the surface		<ul style="list-style-type: none"> ▶ Thoroughly degrease the surface 	<p>3M™ General Purpose Adhesive Cleaner</p> <p>3M™ Professional Panel Wipes</p>
Optional - second layer application		<ul style="list-style-type: none"> ▶ Apply a further layer of 3M™ FC Epoxy Metal Filler if necessary and repeat drying and sanding steps as recommended in the previous steps ▶ Maximum finished thickness should not exceed 4-6 mm, maximum layer thickness should not exceed 2-3 mm ▶ Follow car manufacturer and paint company recommendations for subsequent steps 	<p>3M™ FC Epoxy Metal Filler</p> <p>3M™ Static Mixing Nozzle</p> <p>3M™ High Power Manual Gun</p>