

### PERSONAL SAFETY

• Comfort Particle Mask P2

• Hearing Protection

• Comfort Goggles

• Reusable Workwear

• Safety Gloves

<b>1</b> Pre-Sanding of the damaged area		<ul style="list-style-type: none"> <li>▶ Perform initial sanding using a handblock in order to spot high and low spots on the repair area</li> <li>▶ Mark the deepest points in the damaged area in order to place welding points</li> </ul> <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>
<b>2</b> Preparation		<ul style="list-style-type: none"> <li>▶ Remove paint/coating in the low points of the repair area, in preparation for dent pulling</li> </ul>	<p>3M™ Scotch-Brite™ Roloc™ Disc</p> <p>3M™ Body Repair Pistol Grip Disc Sander</p>
<b>3</b> Spot Application		<ul style="list-style-type: none"> <li>▶ Spot weld onto the repair area using your preferred and recommended method and/or equipment</li> </ul> <p>Note: Always ensure that the equipment is properly calibrated depending on the materials being repaired</p>	
<b>4</b> Dent Pulling		<ul style="list-style-type: none"> <li>▶ Pull the spots of dent using preferred dent pulling method and equipment</li> </ul> <p>Tip: To avoid surface imperfections or pinholes in the substrate, aim to distribute the load across the repair area</p>	
<b>5</b> Spot Removal		<ul style="list-style-type: none"> <li>▶ Spot removal by rotating the welded spot manually</li> </ul> <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>	
<b>6</b> Sanding down the job area		<ul style="list-style-type: none"> <li>▶ Sanding down the job area to bare metal</li> <li>▶ Switch to ROTEX motion for high abrasion first</li> <li>▶ For fine sanding step switch to ROTEX orbital random motion, without changing the sanding disc or grit!</li> </ul> <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>
<b>7</b> Cleaning of the surface		<ul style="list-style-type: none"> <li>▶ Degrease the surface</li> </ul>	<p>3M™ General Purpose Adhesive Cleaner</p> <p>3M™ Professional Panel Wipes</p>
<b>8</b> Application		<ul style="list-style-type: none"> <li>▶ Apply enough 3M™ FC Epoxy Metal Filler for dent filling</li> <li>▶ Recommended settings for applicators: pneumatic max. inlet pressure 5.5 bar / battery driven 3kN, max speed 180mm/min.</li> </ul> <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>
<b>9</b> Drying		<ul style="list-style-type: none"> <li>▶ 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</li> <li>▶ Airdrying: sandable ~ after 4 h @ 22 °C ambient temperatures</li> <li>▶ Tip for use: warming up the material &amp; surface to ~30°C before material application will help to accelerate curing, particularly at cold ambient temperatures</li> </ul>	
<b>10</b> Sanding of the filler area		<ul style="list-style-type: none"> <li>▶ 3M™ Cubitron™ II 80+ - 120+.</li> <li>▶ To remove coatings more quicker, use the ROTEX motion setting</li> <li>▶ To refine previous sanding scratches, switch to ROTEX orbital random motion, keeping the previous abrasive disc on the machine</li> </ul> <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>
<b>11</b> Cleaning of the surface		<ul style="list-style-type: none"> <li>▶ Thoroughly degrease the surface</li> </ul>	<p>3M™ General Purpose Adhesive Cleaner</p> <p>3M™ Professional Panel Wipes</p>
<b>Optional - second layer application</b>		<ul style="list-style-type: none"> <li>▶ Apply a further layer of 3M™ FC Epoxy Metal Filler if necessary and repeat drying and sanding steps as recommended in the previous steps</li> <li>▶ Maximum finished thickness should not exceed 4-6 mm, maximum layer thickness should not exceed 2-3 mm</li> <li>▶ Follow car manufacturer and paint company recommendations for subsequent steps</li> </ul>	<p>3M™ FC Epoxy Metal Filler</p> <p>3M™ Static Mixing Nozzle</p> <p>3M™ High Power Manual Gun</p>