



3M Paint Application Process

PERSONAL SAFETY

• Reusable Respirators with full face protection



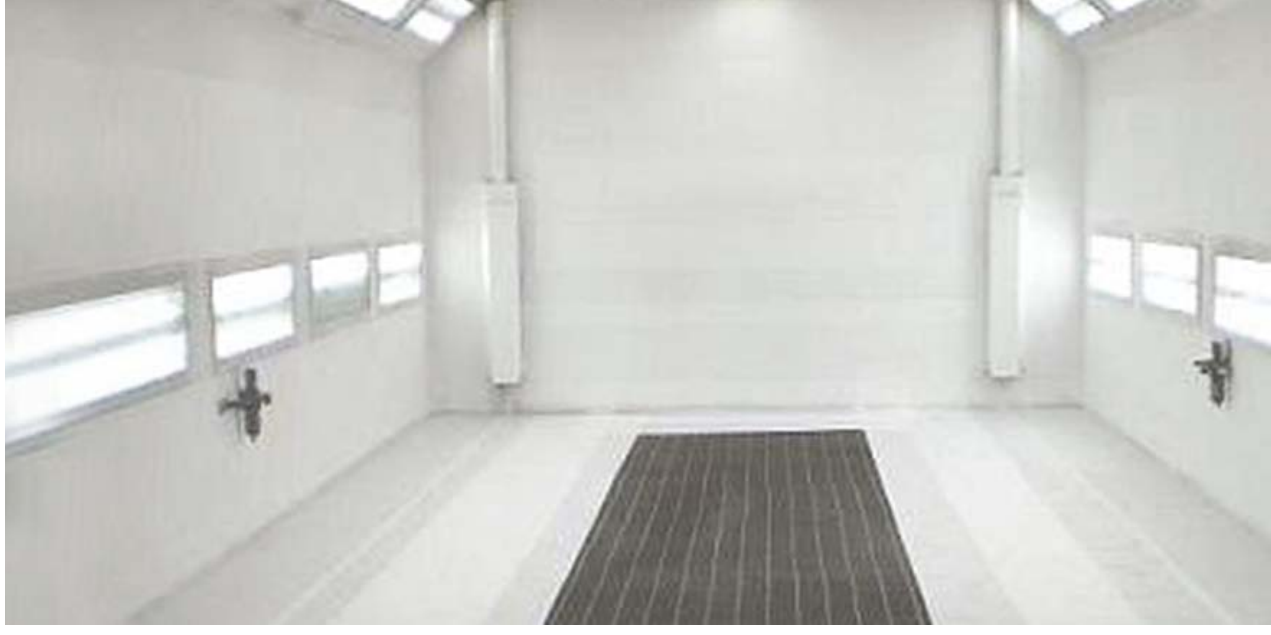
• Reusable Coveralls



• Nitrile Gloves



Requirements for Best Results and Quality



- ▶ Apply Dirt Trap Protection Film in order to keep a clean environment in the spray booth.
- ▶ Use 3M Aircare ACU-03 to obtain proper pressurized air.
- ▶ Use 3M Protective Coveralls to protect the operator and get a cleaner job.



3M™ Dirt Trap Protection Film – Clear, 3M™ Dirt Trap Protection Material

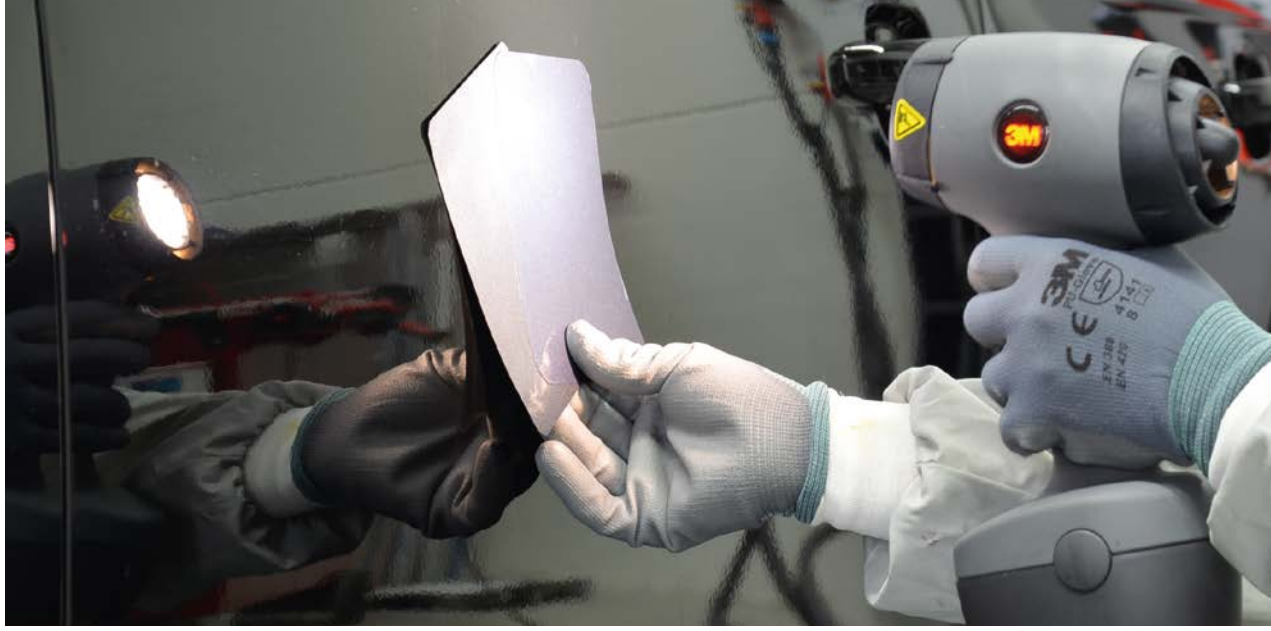


3M™ Aircare ACU-03



3M™ Protective Coverall 4540+

Determination of Colour



- ▶ Use 3M™ Perfect It™ Fast Cut Plus Extreme to restore original surface condition for an accurate colour match.
 - ▶ If you are using the latest spectrometer technology, it is recommended to do an additional polishing step after 3M™ Perfect It™ Fast Cut Plus Extreme with 3M™ Perfect-It™ Ultrafina SE (blue cap).
- Tip: The creation of a personal colour library will make life easier for you in the future as you can reuse your own sprayout cards.



3M™ Perfect-it™ Fast Cut Plus Extreme

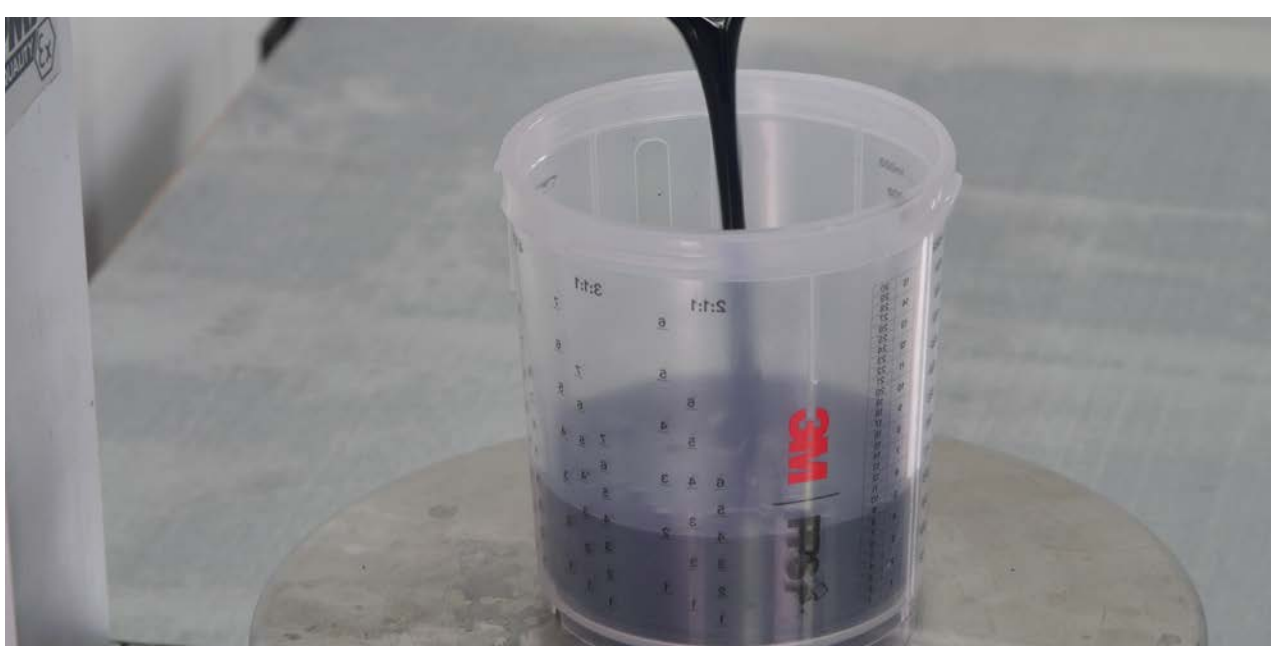


3M™ Hookit™ Convoluted Foam, 75mm



3M™ PPS™ Colour Check Light II

1 Mixing of Base Coat



- ▶ Four 3M™ PPS™ Series 2.0 sizes are available to suit the most common repairs sizes in your shop.
 - ▶ By using 3M™ PPS™ Series 2.0 no additional mixing cup is needed.
 - ▶ As the filter is directly integrated to the 3M™ PPS™ Series 2.0 lid, no additional filtering stage is required.
- Note: Selecting the right size 3M™ PPS™ Series 2.0 Spray Cups for your needs, will reduce the chance of overmixing.



3M™ PPS™ Series 2.0 Spray Cup System Kit Large 850ml, Standard 650ml, Midi 400ml, Mini 200ml



3M™ PPS™ Lid & Liner Dispensers

2 Setup 3M™ Performance Spray Gun



- ▶ Pull the trigger back
- ▶ Making sure locking collar is in the “+ configuration”
- ▶ Slide the atomizing head over the fluid needle and push towards the spray gun body
- ▶ Secure the atomizing head by rotating the retainer ring, clockwise until the retainer ring tabs are locked in the “X configuration”
- ▶ HVLP max inlet pressure 1.38 bar (20 psi)
Fine Finish Operating Pressure 2.0 bar (29 psi)
- ▶ The Operating Pressure Range is 0.5 bar (7 psi) – 2.6 bar (37 psi) max



3M™ Performance Spray Gun



3M™ Performance HVLP Atomising Heads 0.9, 1.2, 1.3, 1.4, 1.6, 1.8, 2.0



3M™ Performance Gravity Fine Finish Atomising Heads 1.2, 1.3, 1.4

3 Base Coat Application



- ▶ Degrease the surface using paint company or other recommended product. Always follow the manufacturer's instructions.
- ▶ Clean the surface prior to base coat application with tack cloth.
- ▶ Always follow paint company recommendations regarding basecoat application process.
- ▶ When finished spraying, disconnect the air line, invert the spray gun, pull the trigger and gently tap 3M™ PPS™ Series 2.0 Lid and Liner on a surface to help break surface tension of liquid and allow it to flow back into liner.



3M™ Professional Panel Wipes



3M™ Tack Cloth Aqua

4 Mixing of Clear Coat



- ▶ Four 3M™ PPS™ Series 2.0 sizes are available for the most common size repairs in your shop.
- Note: Modern clear coat technology should be mixed on demand, due to short pot life! Select the right size 3M™ PPS™ Series 2.0 Spray Cups for your needs, reducing the chance of over applying or wasting clear coat.



3M™ PPS™ Series 2.0 Spray Cup System Kit Large 850ml, Standard 650ml, Midi 400ml, Mini 200ml



3M™ PPS™ Series 2.0 UV Kit

5 Clear Coat Application



- ▶ Always follow paint company recommendations regarding clearcoat application process.
 - ▶ 3M™ PPS™ Series 2.0 reduces cleaning time considerably and lowers your solvent consumption.
- Tip: Consult paint or solvent Safety Data Sheets (SDS) in addition to local regulations or authorities for safe use and proper disposal.



3M™ PPS™ Series 2.0 UV Kit



3M™ PPS™ Series 2.0

6 Cleaning 3M™ Performance Spray Gun

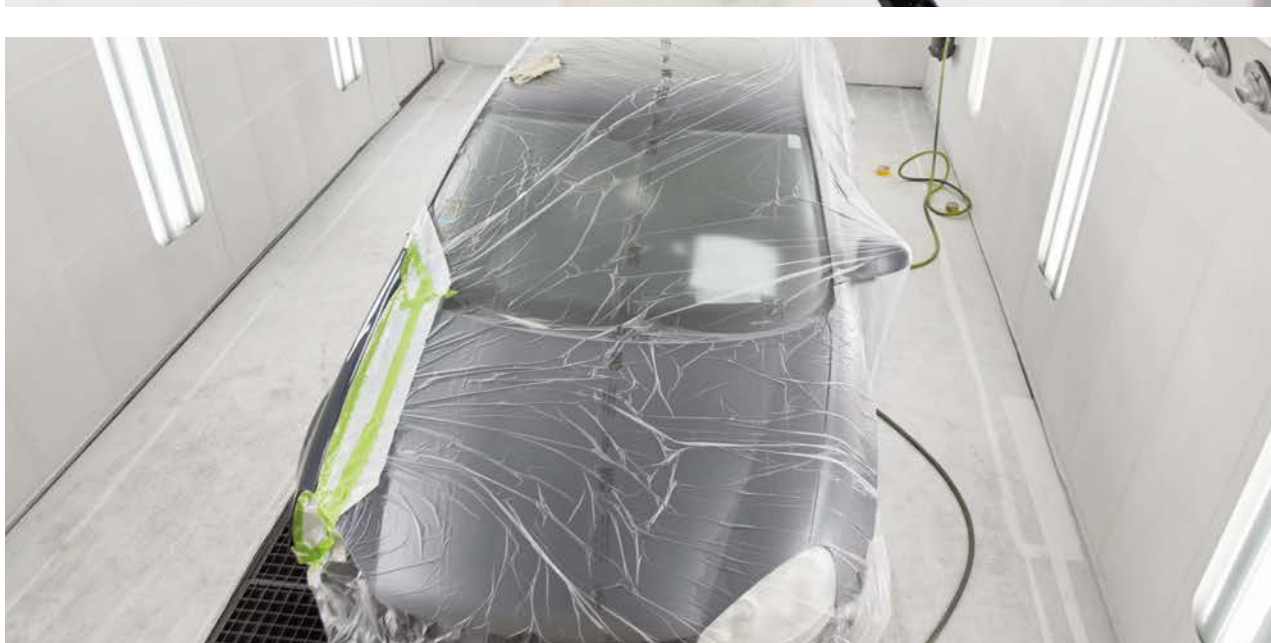


- ▶ Pull the trigger back
- ▶ Rotate the locking collar counter-clockwise and pull the atomizing head away from the gun body
- ▶ Clean the needle with solvent on a cloth.
- ▶ Simply put on the new nozzle and you're done
- ▶ 3M™ Performance Spray Gun & PPS™ reduce cleaning time considerably and lower your solvent consumption.



3M™ Professional Panel Wipes PN 34567

7 Forced Drying



- ▶ Please do observe the recommendations of your paint manufacturer concerning: object temperature & drying time.
- Note: The quality of drying has a positive influence on the later finishing properties of the surface. Forced drying accelerates the finish process and at the same time ensures an even drying of the paint. A clear coat, which has hardened evenly and well can be finished a lot easier.