



# Standard Operating Procedures Recommended Net Sanding Process



## PERSONAL SAFETY

• Comfort Particle Mask P3



• Hearing Protection



• Comfort Goggles



• Reusable Overall



• Safety Gloves



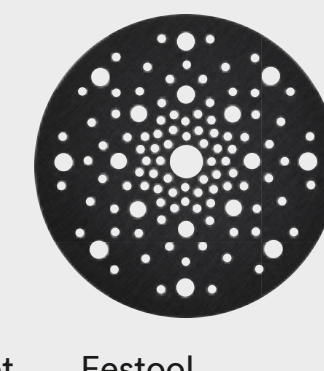
1 Sanding down the job area



- ▶ 3M™ Cubitron™ II Net Abrasive Disc 120+ - 150+.
- ▶ To prolong the life of the backup pad when sanding with net abrasive discs (150 mm), it is recommended that Festool Automotive Systems Protection Pad is used (PN 30089, Protection Pad PP-STF D150).
- ▶ Festool Automotive Systems electric sander ETS EC 150/5 or Festool Automotive Systems pneumatic sander LEX 3 150/5 or 150/7.



3M™ Cubitron™ II Net Abrasive Disc



Festool Protective Pad



Festool ETS EC 150/5 EQ



Festool LEX 3 150/5, Festool LEX 3 150/7

2 Fine sanding of the surface & feather edges



- ▶ 3M™ Cubitron™ II Net Abrasive Disc 220+ - 240+.
- ▶ 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.



3M™ Cubitron™ II Net Abrasive Disc



3M™ Dry Guide Coat

3 Sanding the body filler



- ▶ 3M™ Cubitron™ II Net Abrasive Disc 150+ - 240+.
- ▶ Initial shaping of the body filler.
- ▶ Ensure that you use dust extraction.
- ▶ Identify and highlight sanding scratches through the application of dry guide coat.



3M™ Cubitron™ II Net Abrasive Disc



3M™ Cubitron™ II Net Abrasive Sheets



3M™ Hookit™ Purple Hand Block

4 Pre-sanding of edges and borders



- ▶ 3M™ Hookit™ Flexible Abrasive Sheets P800 - P1000.
- Note: This product is recommended for maximum process safety.



3M™ Hookit™ Flexible Abrasive Sheets



3M™ Hookit™ Flexible Abrasive Sheets

5 Fine sanding of the surface & feather edges



- ▶ 3M™ Cubitron™ II Net Abrasive Disc 320+.
- ▶ 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, the finer the sanding before primer application.



3M™ Cubitron™ II Net Abrasive Disc



Festool Interface-Pad

6 Flat sanding of the primer above the body filler area



- ▶ 3M Hookit™ Hand Block and 3M Abrasives 320+ - 400+.
- ▶ Highlight the texture and structure of the primer using dry guide coat.
- ▶ For best result and the most efficient process always use dust extraction.



3M™ Cubitron™ II Net Abrasive Sheets



3M™ Cubitron™ II 737U Abrasive Sheets



3M™ Hookit™ Purple Hand Block



3M™ Dry Guide Coat

7 Pre-sanding of edges and borders



- ▶ 3M™ Hookit™ Flexible Abrasive Sheets P800-P1000
- Note: This product is recommended for maximum process safety.
- ▶ Identify and highlight sanding scratches through the application of dry guide coat.



3M™ Hookit™ Flexible Abrasive Sheets



3M™ Hookit™ Flexible Abrasive Sheets

8 Large area primer sanding



- ▶ Eccentric sanding with 3M Abrasives 400+ - P500.
- ▶ For critical colours use a 3M™ Hookit™ Flexible Foam Disc P600 as a last sanding step after 400+.
- ▶ Dedusting of the surface with 3M™ Scotch-Brite™ Abrasives Discs.
- Tip: It is advisable to work with a soft interface pad sanding curved areas.



3M™ Cubitron™ II 737U Disc



3M™ Scotch-Brite™ Abrasive Discs

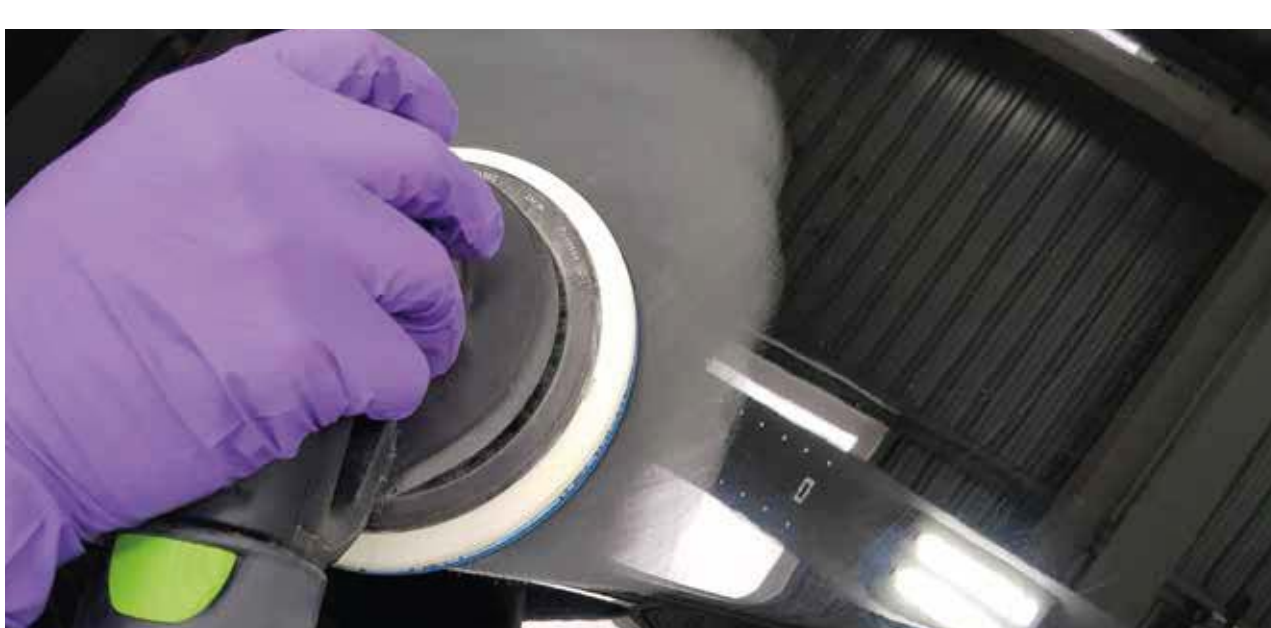


Festool ETS EC 150/3

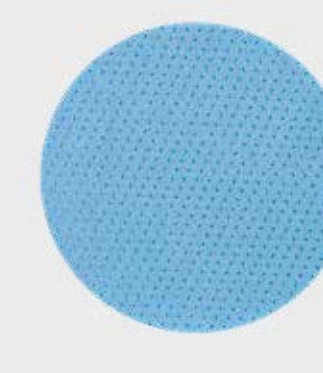


Festool LEX 3 150/3

9 Blending in to adjacent parts



- ▶ 3M™ Hookit™ Flexible Foam Disc P800 - P1000
- ▶ Prepare adjacent areas of the OEM clearcoat.
- Note: This product is recommended for maximum process safety.



3M™ Hookit™ Flexible Foam Disc