



Standard Operating Procedures

Advanced Net Sanding Process

PERSONAL SAFETY

- Comfort Particle Mask P3
- Hearing Protection
- Comfort Goggles
- Reusable Overall
- Safety Gloves

1 Sanding down the job area



- ▶ 3M™ Blue Net Abrasives Disc 120 - 150.
- ▶ Marking the sanding scratches - Application of dry guide coat



3M™ Blue Net Abrasives Disc



Festool Protection 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™ Blue Net Abrasives 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™ Blue Net Abrasives Disc



3M™ Dry Guide Coat

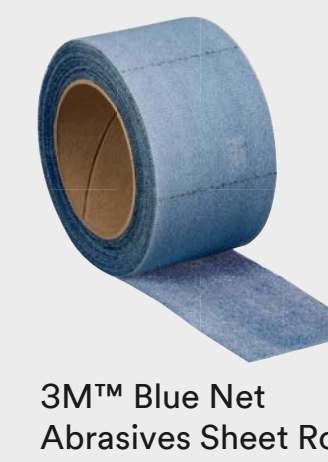
3 Sanding the body filler



- ▶ 3M™ Blue Net Abrasives 120 - 240.
- ▶ Initial shaping of the body filler.
- ▶ Initial shaping of the body filler.
- ▶ Identify and highlight sanding scratches through the application of dry guide coat.



3M™ Blue Net Abrasives Disc



3M™ Blue Net Abrasives Sheet Rolls



3M™ Hookit™ Purple Hand Block

4 Pre-sanding of edges and borders



- ▶ 3M™ Grippy Sanding Cloth, P800 - P1000.
- Note: This product is recommended for maximum process safety.



3M™ Grippy Sanding Cloth, P800



3M™ Grippy Sanding Cloth, P1000

5 Fine sanding of the surface & feather edges



- ▶ 3M™ Blue Net Abrasive Disc 320.
- ▶ It is advisable to work with a soft interface pad when sanding curved areas.
- Tip: The choice of the grit has to be adjusted to the solvent sensitivity of the original paint. The higher the sanding before primer application.



3M™ Blue Net Abrasives 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™ Blue Net Abrasives Sheet Rolls



3M™ Cubitron™ II 737U Abrasive Sheets



3M™ Hookit™ Purple Hand Block



3M™ Dry Guide Coat

7 Pre-sanding of edges and borders



- ▶ 3M™ Grippy Sanding Cloth, P800 - P1000.
- Note: This product is recommended for maximum process safety.
- ▶ Identify and highlight sanding scratches through the application of dry guide coat.



3M™ Grippy Sanding Cloth, P800

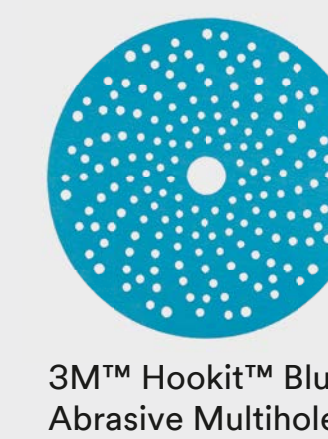


3M™ Grippy Sanding Cloth, P1000

8 Large area primer sanding



- ▶ 3M™ Hookit™ Blue Abrasive Multihole 400 - 500.
- ▶ 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™ Hookit™ Blue Abrasive Multihole 325U



3M™ Scotch-Brite™ Abrasive Discs

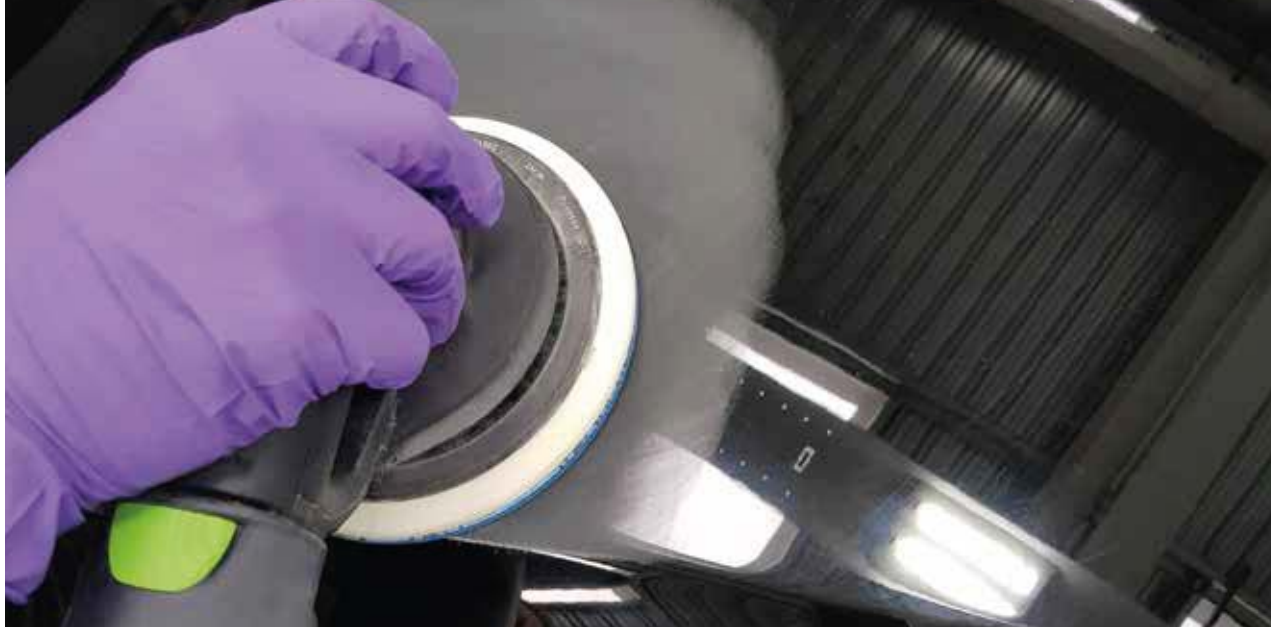


Festool ETS EC 150/3



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