

Personal Safety

• Comfort Particle Mask P3



• Hearing Protection



• Face Protection



• Reusable Workwear



• Safety Gloves



1 Sanding down the job area



- 3M™ Cubitron™ II 120+ - 150+
- Marking the sanding scratches - Application of dry guide coat



3M™ Hookit™ Cubitron™ II Abrasive Discs



3M™ Hookit™ Elite Spiral Multihole Back up Pad



3M™ Random Orbital Sander 150 mm, 5 or 8 mm Orbit



3M™ Electric Random Orbital Sander 150 mm, 5 mm Orbit

2 Fine sanding of the surface & feather edges



- Feather edge the repair area with 3M™ Cubitron™ II 220+ - 240+
- Refinement of previous sanding scratches and feathering 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.
- Optional Step: Based on OEM recommendation, Epoxy repair area as required.



3M™ Hookit™ Cubitron™ II Abrasive Discs



3M™ Dry Guide Coat

3 Sanding of the body filler



- Block Sand the filler with 3M™ Cubitron™ II 120+ followed by 3M™ Cubitron™ II 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™ Hookit™ Cubitron™ II Abrasive Discs



3M™ Hookit™ Purple hand block, 70 x 198 mm



3M™ Cubitron™ II Hookit™ Purple Abrasive Sheet Roll

4 Pre-sanding of edges and borders



- Sand the edges first with 3M™ Grippy Sanding Cloth, P800-P1000
- Note: Doing this step first enables any in line scratches can be picked up in the following steps.



3M™ Grippy Sanding Cloth, P800-P1000

5 Fine sanding of the surface & feather edges



- Refine the featheredge with 3M™ Cubitron™ II 320+ disc
- 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 solvent sensitivity of the original paint, the finer the sanding before primer application



3M™ Hookit™ Cubitron™ II Abrasive Discs



3M™ Hookit™ Soft Interface-Pad

6 Flat sanding of the primer above the body filler area



- Block sand the primer with 3M Hookit™ Hand block and 3M 320+ - P400
- Highlight the texture and structure of the primer with dry guide coat between sanding steps.
- For best result and the most efficient process always use dust extraction



3M™ Hookit™ Purple+ Multihole Handblock, 70 x 198 mm



3M™ Cubitron™ II Hookit™ Purple Abrasive Sheet Roll



3M™ Dry Guide Coat

7 Pre-sanding of edges and borders



- Sand the edges first with 3M™ Grippy Sanding Cloth, P800-P1000
- Identify and highlight sanding scratches through the application of dry guide coat
- Note: Doing this step first enables any in line scratches can be picked up in the following steps.



3M™ Grippy Sanding Cloth, P800-P1000

8 Large-area face grinding of the primer



- Large area sanding 3M Abrasives 400+ - P500
- For critical colours use a 3M™ Hookit™ Clean Sanding Disc P600 as a last sanding step after 400+. Follow paint company recommendation for final sanding step.
- Dedusting of the surface with 3M™ Scotch-Brite™ Abrasives Discs
- Tip: It is advisable to work with a soft interface pad when sanding curved areas



3M™ Hookit™ Cubitron™ II Abrasive Discs



3M™ Scotch-Brite™ Abrasive Discs



3M™ Hookit™ Interface-Pad Multihole

9 Blending in to adjacent parts



- 3M™ Flexible Abrasive P800 - P1000
- Prepare adjacent areas of the OEM clearcoat



3M™ Hookit™ Flexible Foam Abrasive Disc, P800 - P1000