

## Personal Safety

• Comfort Particle Mask P2



• Hearing Protection



• Face Protection



• 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> <li>• 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.</li> </ul>	<p>3M™ Cubitron™ II Hookit™ Purple Abrasive Sheet Roll 3M™ Hookit™ Purple+ Multihole Handblock, 70 × 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™ Body Repair Pistol Grip Disc Sander 3M™ Scotch-Brite™ Roloc™ Disc</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> <li>• Note: Always ensure that the equipment is properly calibrated depending on the materials being repaired</li> </ul>	
<b>4</b> Dent Pulling		<ul style="list-style-type: none"> <li>• Using the preferred method and equipment, pull the spots on the dent area.</li> <li>• Tip: To avoid surface imperfections or pinholes in the substrate, aim to distribute the load across the repair area</li> </ul>	
<b>5</b> Spot Removal		<ul style="list-style-type: none"> <li>• Rotate the welded spot manually to remove from the panel.</li> <li>• Note: This modern method will reduce the likelihood of causing holes in the substrate and avoid the thinning out the panel due to a coarse sanding step for the removal</li> </ul>	
<b>6</b> Sanding down the job area		<ul style="list-style-type: none"> <li>• Sand down the repair area to bare metal. It is recommended that the painted area around the bare metal should be feathered out.</li> <li>Note: For aluminium substrates, always use a pneumatic sanding tool. Conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, ATEX etc.).</li> </ul>	<p>3M™ Hookit™ Cubitron™ II 80+ -120+ -150mm 3M™ Random Orbital Sander, 150 mm (6 in), 8 mm (5/16) Orb 3M™ Electric Random Orbital Sander, 33766, 150 mm (6 in), 5 mm (3/16) Orbit</p>
<b>7</b> Cleaning of the surface		<ul style="list-style-type: none"> <li>• Degrease the surface with a recommended cleaner.</li> </ul>	<p>3M™ Professional Panel Wipes</p>
<b>8</b> Application of body filler		<ul style="list-style-type: none"> <li>• Mix and apply body filler to the damaged area, avoiding surrounding paintwork.</li> <li>• Note: In general it is recommended to apply body filler to bare metal surface or epoxy primer. Always follow OEM recommendations around body filler application.</li> <li>• Allow filler to cure. The curing of the filler can be accelerated using IR &amp; Short Wave drying after the initial gelling period. Follow manufacturer's recommendations.</li> </ul>	<p>3M™ Light Weight Body Filler</p>
<b>9</b> Sanding of the body filler area		<ul style="list-style-type: none"> <li>• Sand area with grade 120 - 240 abrasives. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections and coarse grade sand scratches.</li> <li>• Fine sanding of featheredge and the repair area with grade 320 abrasive.</li> <li>• Optional: Apply a fine filler to prevent and fill pinholes &amp; other imperfections</li> </ul>	<p>3M™ Hookit™ Purple+ Multihole Handblock, 70 × 198 mm 3M™ Cubitron™ II Hookit™ Purple Abrasive Sheet Roll 3M™ Dry Guide Coat</p>
<b>10</b> Fine sanding of the surface & feather edges		<ul style="list-style-type: none"> <li>• Using 3M™ Cubitron™ II 320+, sand the surrounding area</li> <li>• It is advisable to work with a soft interface pad when sanding curved areas.</li> <li>• Follow OEM and paint company recommendations for subsequent steps.</li> </ul>	<p>3M™ Hookit™ Cubitron™ II 320+ -150mm 3M™ Hookit™ Interface-Pad Multihole</p>