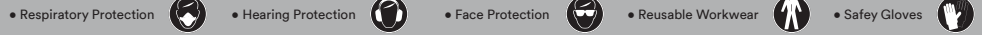


Personal Safety



Safety First! Always select appropriate personal protective equipment - eyewear, gloves, hearing and respiratory protection for your job and workplace.

Cleaning the surface		<ul style="list-style-type: none"> • Degrease the surface using paint company or other recommended VOC-compliant water-based and solvent-based products. Always follow the manufacturer's instructions for surface cleaning instructions. 	
Sanding the repair area		<ul style="list-style-type: none"> • Remove paint 2 - 3 inches beyond the repair to prepare the surface for body filler application. Use 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 80 - 120 affixed to a dual action sander. • To remove paint from hard to reach or deep portions of the damaged area, consider using 3M™ Cubitron™ II Roloc™ Discs, grade 80 or 3M™ Cubitron™ II File Belt Abrasive, grade 80. 	<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 3M™ Scotch-Brite™ Roloc Disc 3M™ Cubitron™ II 80 File Belts</p>
Fine sanding of the surface & feather edges		<ul style="list-style-type: none"> • Refine previous sanding scratches to reduce the possibility of solvents from the body filler penetrating into the OEM paint layers using 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc grades 180 - 320. Solvents can contribute to surface swelling around the repair which may become visible in the completed repair • Clean with a VOC-Compliant cleaner and a dry lint free cloth. Apply cleaner to the towel NOT the substrate. Wipe on wet, turn cloth over and dry thoroughly. 	<p>Festool ETS EC 150/5 EQ Festool LEX 3 150/7 3M™ Pistol Grip Disc Sander 3M™ File Belt Tool</p>
Body filler application		<ul style="list-style-type: none"> • 3M recommends application of epoxy primer prior to applying filler. Follow the paint manufacturer's recommendations for applying filler over epoxy primers. • Apply a thin tight coat using firm pressure to ensure maximum adhesion being sure to "wet out" the surface completely. Apply additional filler in layers, building up the damaged area higher than the surrounding surface. Maximum filler thickness should not exceed 1/4 inch. Allow curing time of 20 minutes. • Apply body filler to the repair area, avoiding surrounding paintwork • Note: Avoid application of solvents & body filler over feathered layers of paint to avoid repair mapping. Always follow OEM recommendations. 	<p>3M™ Platinum™ Select Body Filler 3M™ Disposable Paper Mixing Board 3M™ Spreaders</p>
Body filler shaping		<ul style="list-style-type: none"> • Using an appropriately sized hand block, shape sand using 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, grades 80 - 120. • Highlight sand scratches and high & low spots using 3M™ Dry Guide Coat. • For best results and the most-efficient process, always use dust extraction 	<p>3M™ Hookit™ Hand Block 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll 3M™ Dry Guide Coat</p>
Scratch refinement		<ul style="list-style-type: none"> • Refine the sand scratches from the previous shaping step using 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Discs grades P150 - P180. • Continue to use 3M™ Dry Guide Coat to highlight sand scratches and surface imperfections. 	<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 3M™ Platinum™ Plus Finishing Glaze 3M™ Dry Guide Coat</p>
Repair feather edge		<ul style="list-style-type: none"> • Complete the final refinement of coarse grade scratches within the repair area and around the feather edge perimeter using 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Discs grade 320 • It is advisable to work with a soft Interface Pad when sanding curved areas. • Continue to use 3M™ Dry Guide Coat to highlight sand scratches and surface imperfections 	<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc Festool Interface-Pad</p>
Prime and block		<ul style="list-style-type: none"> • Use 3M™ Dry Guide Coat to highlight the texture of the primer. • Using an appropriately sized hand block and 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 320 grade, level primer-surfacer texture paying attention to body lines, high & low spots, and sand scratches. • For best results and the most efficient process always use dust extraction. 	<p>3M™ Hookit™ Hand Block 3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll 3M™ Dry Guide Coat</p>
Edge Sanding		<ul style="list-style-type: none"> • Sand edges and hard-to-reach areas using 3M™ Hookit™ Flexible Abrasive Hand Sheets grade 800-1000 	<p>3M™ Hookit™ Flexible Abrasive Sheets P800-P1000</p>
Scratch refinement		<ul style="list-style-type: none"> • Use 3M™ Dry Guide Coat to highlight the surface of the primer. Remove all directional hand-sanding scratches from previous steps using 3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Discs grade 400 - 500 attached to a dual-action sander equipped with a soft interface pad. • Use your dust extraction system and a DA sander with a 3M™ Scotch-Brite™ Clean and Finish Disc attached to de-dust / clean all surface areas 	<p>3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc 3M™ Scotch-Brite™ Clean and Finish Disc Festool ETS EC 150/5 EQ Festool LEX 3 150/5 Festool Interface-Pad 3M™ Dry Guide Coat</p>
Blend Prep		<ul style="list-style-type: none"> • Level / de-gloss adjacent areas of the OEM clear coat using 3M™ Hookit™ Purple Finishing Film Abrasive Disc 260L, grade 800 - 1000 on a dual action sander equipped with a soft interface pad 	<p>3M™ Hookit™ Purple Finishing Film Abrasive Disc 260L Festool Interface-Pad</p>