3M Science. Applied to Life.™

Panel Repair & Paint Prep

Personal Safety

• Respiratory Protection • Hearing Protection • Face Protection • Reusable Workwear • Safety Gloves

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

Cleaning the surface

- 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

- Remove paint 2 - 3 inches (50 - 75mm) beyond the repair to prepare the surface for body filler application using a 80 - 120 grit abrasive disc affixed to a dual action sander.
- To remove paint from hard to reach or deep portions of the damaged area, consider using grade 80 grinding discs or grade 80 file belt.

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc

3M™ Scotch-Brite™ Roloc Disc

3M™ Cubitron™ II 80 File Belts

Fine sanding of the surface & feather edges

- Refine previous sanding scratches using a 180 - 320 grade abrasive disc.
- 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.

3M™ Precision Random Orbital Sander, 150 mm (6 in)

3M™ Electric Random Orbital Sander

3M™ Pistol Grip Disc Sander

3M™ File Belt Tool

Body filler application

- 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 / 6mm. 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.

3M™ Platinum™ Select Body Filler

3M™ Disposable Paper Mixing Board

3M™ Spreaders

Body filler shaping

- Using an appropriately sized hand block, shape sand using grade 80 - 120 sanding sheets.
- Highlight sand scratches and high & low spots using guide coat.
- For best results and the most-efficient process, always use dust extraction

3M™ Hookit™ Hand Block

3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll

3M™ Dry Guide Coat

Scratch refinement

- Refine the sand scratches from the previous shaping step using grade 150 - 180 sanding discs.
- Continue to use guide coat to highlight sand scratches and surface imperfections.

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc

3M™ Platinum™ Plus Finishing Glaze

3M™ Dry Guide Coat

Repair feather edge

- Complete the final refinement of coarse grade scratches within the repair area and around the feather edge perimeter using a grade 320 abrasive disc.
- It is advisable to work with a soft interface pad when sanding curved areas.
- Continue to use guide coat to highlight sand scratches and surface imperfections.

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc

3M™ Interface-Pad

Prime and block

- Use guide coat to highlight the texture of the primer.
- Using an appropriately sized hand block and a grade 320 abrasive sheet, 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.

3M™ Hookit™ Hand Block

3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll

3M™ Dry Guide Coat

Edge Sanding

- Sand edges and hard-to-reach areas using abrasive hand sheets grade, 800-1000.

3M™ Hookit™ Flexible Abrasive Sheets P800-P1000

Scratch refinement

- Use guide coat to highlight the surface of the primer. Remove all directional hand-sanding scratches from previous steps using a grade 400 - 500 abrasive disc attached to a dual-action sander equipped with a soft interface pad.
- For critical colors, consider using grade 600 flexible foam backed abrasives for additional refinement
- Using your dust extraction system and a white non-woven disc attached to a DA sander to de-dust / clean all surface areas.

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc

3M™ Flexible Foam Abrasive Disc

3M™ Precision Random Orbital Sander, 150 mm (6 in)

3M™ Electric Random Orbital Sander

3M™ Interface-Pad

3M™ Dry Guide Coat

Blend Prep

- Level & de-gloss adjacent areas of the OEM clear coat using a grade 800 - 1000 paper abrasive disc on a dual action sander equipped with a soft interface pad.
- Use an abrasive disc with an integrated foam backing to retain factory orange peel for improved texture matching.

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc

3M™ Flexible Foam Abrasive Disc

3M™ Interface-Pad

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Always follow OEM procedures. For ordering information, contact your 3M Sales Representative or your preferred distributor.