

Standard Operating Procedures

for Collision Repair



Process for Success

Standard Operating Procedures

From metal and plastic repair, to sanding, paint finishing and car clean-up, 3M has the products and repair processes for you. Feel confident your repair is done professionally and efficiently using our **Standard Operating Procedures**. These procedures will help you consistently produce quality, time-proven solutions for any of your collision repair needs.

For more Standard Operating Procedures, visit 3MCollision.com.

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Important Note on VOCs: Volatile Organic Compound (VOC) regulations may exist that prohibit the use of certain alcohol solutions or solvents. You should check with your state environmental authorities to determine whether use of a solution or solvent is restricted or prohibited in your area.

Windshield Removal and Installation

1		Glass Removal Apply interior surface protection. Remove wiper blades and cowl panel. Remove windshield molding. Cut urethane with the appropriate tool. Remove glass.
2		Dry Set Glass Clean the pinchweld area of all loose pieces of urethane. Dry fit the glass. Use masking tape to mark proper alignment by applying two pieces of tape along the top edge of the glass, perpendicular to the pinchweld. Cut the masking tape and remove the glass.
3		Pinchweld Inspection & Preparation Close-cut the old urethane down to a thickness of 1mm–2mm. Clean with water and a clean cloth. Apply primer to any bare metal scratches if necessary and allow to dry for 5–10 minutes.
4		Clean and Prepare the Glass Clean glass with glass cleaner and a clean cloth.
5		Apply Primer to the New Windshield Check the expiration date on the primer. Shake the primer can well. Apply a continuous layer of primer to the new windshield and allow to dry for 5–10 minutes.
6		Apply Urethane & Install Windshield Check expiration date on urethane. Cut nozzle to desired width and shape. Apply a bead of new urethane to the old urethane on the pinchweld at an application angle of 90°. Paddle all joints/gaps in one direction.
7		Tape Removal Remove all tape before delivering the vehicle. For best results remove it in a slow, uniform motion. Remove it in the direction of the painted surface to the windshield, and remove the tape at an angle of approximately 135° to the surface. Tape removal works best if the temperature is above 60°F.
8		Reinstall Moldings and Panels Reinstall moldings and interior panels as needed. Reconnect electronics. Remove excess urethane. Keep vehicle out of service until the urethane builds strength per manufacturer recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Precision Masking Tape, 2 in. width, PN 06528



3M™ Single Step Primer, 30mL can, PN 08682



3M™ Urethane Primer Daubers, PN 08688



3M™ Glass Cleaner, 19 oz. aerosol, PN 08888



3M™ Fast Cure Auto Glass Urethane, 450mL Flex Pack, PN 08689; 10.5 fl. oz. cartridge, PN 08690



3M™ Flex Pack Heavy Duty 450mL Applicator Gun, PN 08991



3M™ Specialty Adhesive Remover, 1 qt. can, PN 38984; 15 oz. aerosol, PN 38987



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300














3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Stationary Auto Glass Removal and Installation

1		Glass Removal Apply interior surface protection. Remove interior trim pieces and disconnect electronics. Remove molding. Cut urethane with the appropriate tool. Remove glass.
2		Preparing Damaged Pinchweld Remove all of the old urethane from the damaged area only. For the undamaged pinchweld, leave the urethane intact at this time.
3		Additional Surface Protection Take time to add additional surface protection if needed. This will save time and money in the end.
4		Preparation of New Pinchweld Scuff pinchweld area with general purpose scuffing pad and apply two-part epoxy primer. Then, mask off the pinchweld prior to top coating. Check with paint manufacturer for two-part epoxy primer.
5		Dry Set Glass Clean the pinchweld area of all loose pieces of urethane. Dry fit the glass. Use masking tape to mark proper alignment by applying two pieces of tape along the top edge of the glass, perpendicular to the pinchweld. Cut the masking tape and remove the glass.
6		Clean and Prepare Glass Clean the existing glass. Close cut the urethane if it is in good condition to a thickness of 1mm–2mm. Clean with water and a clean cloth. For new glass, clean glass with glass cleaner and a clean cloth.
7		Preparation of Undamaged Pinchweld Close-cut the old urethane down to a thickness of 1mm–2mm. Clean the pinchweld area with water and a clean cloth.
8		Apply Primer to Pinchweld if Necessary Check the expiration date on the primer, and shake the primer well. For the undamaged pinchweld area, apply the primer to any bare metal scratches. For the damaged pinchweld area that has been repaired, apply a continuous layer of primer to the newly abraded and cleaned epoxy primer. Allow 5–10 minutes of dry time for the primer.
9		Apply Urethane and Install Glass Check the expiration date on the urethane. Cut the application nozzle to the desired width and shape and install the flex pack into the applicator gun. Apply urethane to either the close-cut urethane on the undamaged pinchweld area and/or the prepped epoxy primed area of the new pinchweld. Paddle all gaps in the urethane in one direction and install the glass.
10		Tape Removal Remove all tape before delivering the vehicle. For best results remove it in a slow, uniform motion. Remove it in the direction of the painted surface to the windshield, and remove the tape at an angle of approximately 135° to the surface. Tape removal works best if the temperature is above 60°F.
11		Reinstall Moldings and Panels Reinstall moldings and interior panels as needed. Reconnect electronics. Remove excess urethane. Keep vehicle out of service until the urethane builds strength per manufacturer recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ White Masking Paper, 12 in. x 750 ft., PN 06538



3M™ High Performance Welding Drape, PN 05919



Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



3M™ Precision Masking Tape, 2 in. width, PN 06528



3M™ Glass Cleaner, 19 oz. aerosol, PN 08888



3M™ Single Step Primer, 30mL can, PN 08682



3M™ Urethane Primer Daubers, PN 08688



3M™ Fast Cure Auto Glass Urethane, 450mL Flex Pack, PN 08689; 10.5 fl. oz. cartridge, PN 08690



3M™ Flex Pack Heavy Duty 450mL Applicator Gun, PN 08991



3M™ Specialty Adhesive Remover, 1 qt. can, PN 38984; 15 oz. aerosol, PN 38987



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Welding and Spark Protection

1



Clean

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2



Vertical Surface

Apply welding and spark deflection paper to vertical surfaces.

3



Horizontal Surface

Protect horizontal surfaces using cloth welding drape.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Welding and
Spark Deflection
Paper, PN 05916



3M™ Welding and
Spark Deflection
Dispenser, PN 05912



3M™ High Performance
Welding Drape, PN 05919



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3M™ E-A-R® Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Metal Working

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Surface Prep

Use a Scotch-Brite™ Clean and Strip disc or a Scotch-Brite™ Belt to remove paint/coating in low points of damage in preparation for dent pulling.

3



Dent Pulling

Pull low spots of dent using preferred dent pulling method and equipment.

4



Final Prep

Use a grade 80 Roloc™ grinding disc to remove weld nuggets from dent pulling operation.

5



Clean and Inspect

Clean with all purpose cleaner and degreaser. Blow off with clean, dry air. Inspect damage area to determine if additional metal straightening is required.

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Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Disc, PN 21552



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Extra Cut Disc,
PN 21555



3M™ File Belt Sander,
18 in., PN 33575



Scotch-Brite™ Durable
Flex Belt, CRS, PN 64475



3M™ Pistol Grip Disc
Sander, PN 33577



3M™ Cubitron™ II Roloc™
Fibre Disc, grade 80+,
3 in., PN 33392



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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: It will be necessary to apply cavity wax to back side of panel at heat effected areas to restore corrosion protection.

Steel Part Replacement

1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		Panel Cutting Identify OEM recommended sectioning location, scribe or mark with tape on the vehicle. Trim repair area using preferred cut-off wheel. Use grade 36 or 60 file belt in hard to reach areas to cut top panel and avoid damage to host panel.
3		Sealer/Coating Removal Use Scotch-Brite™ Clean and Strip disc to remove seam sealer and coatings from large easy to access areas. Use CRS Scotch-Brite™ Belt to remove coatings and seam sealers in hard to reach areas and along pinch weld flanges to expose spot weld locations.
4		Spot Weld Removal Using grade 36, 60, or 80 abrasive belt, grind spot weld to remove weld from top panel. Note top panel thickness. Use caution when grinding to only grind top panel and limit cutting into host/interior panel. Use belt thickness as a gauge — stop grinding when back of belt is flush with exterior panel. Grade 80 belt can be used to remove welds from thinner steels.
5		Panel Separation Separate exterior panel from the host panel. DO NOT force separation in areas where the weld isn't completely removed; go back to step 4 and finish weld removal before continuing.
6 _A		Surface Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel.
6 _B		Surface Preparation Clean and prep remaining mating flanges on host and replacement panel with a coarse Scotch-Brite™ Belt where necessary.
7 _A		MIG Plug Weld Dressing Use a grade 80 abrasive belt to dress replacement MIG welds. Grind weld. Use caution to avoid damage to adjacent areas.
7 _B		Continuous Weld Dressing Use a 3 in. grade 60 grinding disc to dress continuous MIG welds at sectioning joint. Grind weld. Use caution to limit amount of grinding done to adjacent areas.
8		Weld Cleaning Use a CRS Scotch-Brite™ Belt to clean weld site in preparation for subsequent operations.

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Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701

3M™ Cut-Off Wheel Tool,
3 in., PN 33579



3M™ Cubitron™ II
Cut-Off Wheel
3" x 1/16" x 3/8", PN 33455;
3" x 1/25" x 3/8", PN 33456



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Disc, PN 21552



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Extra Cut Disc,
PN 21555



3M™ File Belt Sander,
18 in., PN 33575



Scotch-Brite™ Durable
Flex Belt, CRS, PN 64475



3M™ Cubitron™ II File Belt,
grade 36+, PN 33443;
grade 60+, PN 33445;
grade 80+, PN 33446



3M™ Pistol Grip Disc
Sander, PN 33577



3M™ Cubitron™ II Roloc™
Fibre Disc, grade 60+,
3 in., PN 33391



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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Panel Bonding (Excluding Door Skin)




1		Host Panel Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt to remove all adhesive, corrosion and coatings.
2		Replacement Panel Preparation Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.
3		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas. Remove panel in preparation for adhesive application.
5		Weld-Thru Primer Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. Caution: Do not use Weld-Thru Primer in adhesive bonding areas.
6		Pre-Assembly NVH Replacement If vehicle construction necessitates, apply NVH material or foams at original locations as required.
7		Apply Bonding Adhesive Apply adhesive to mating flange areas on host panel and replacement panel, covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.
8		Install Replacement Panel Install replacement panel to host panel. Clamp in place and make required welds on rear vertical seams, cosmetic joints, or where otherwise recommended by the directions for use, or the OE manufacturer. Follow recommended adhesive clamp times.
9		Adhesive Clean Up Tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.
10		Post-Assembly Foam Replacement Apply foams at original locations as required.

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Product List

3M™ File Belt Sander, 18 in., PN 33575	
3M™ Cubitron™ II File Belt, grade 80+, PN 33446	
Scotch-Brite™ Durable Flex Belt, CRS, PN 64475	
Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552	
Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555	
3M™ Weld-Thru Coating II, PN 05917	
3M™ NVH Dampening Material, PN 04274	
3M™ Flexible Foam, 200mL, PN 08463	
3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115	
3M™ Impact Resistant Structural Adhesive 200mL, PN 07333; 450mL DMS, PN 57333	
3M™ Composite and Metal Bonding Adhesive, 200mL, PN 08219	
3M™ Rigid Pillar Foam, 200mL, PN 08458	

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3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07182	
3M™ Virtua™ Protective Eyewear, PN 11326	

Weld Bonding (Excluding Door Skin)

1		Host Panel Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt to remove all adhesive, corrosion and coatings.
2		Mating Flange Panel Preparation Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.
3		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
5		Weld-Thru Primer Use Scotch-Brite™ Belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. Caution: Do not use Weld-Thru Primer in adhesive bonding areas.
6		Spot Weld Surface Preparation Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ belt where spot weld tips will contact host and replacement panel. Remove panel once complete.
7		Pre-Assembly NVH Replacement If vehicle construction necessitates, apply NVH material or foams at original locations as required.
8		Apply Bonding Adhesive Apply adhesive to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of adhesive at mating flange areas.
9		Install Replacement Panel Install replacement panel to host panel. Clamp in place.
10		Spot Weld Spot weld while adhesive is uncured at prepared weld sites. Follow welder settings determined from test panel.
11		Adhesive Clean Up Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess adhesive can expose bare metal, causing corrosion.
12		Post-Assembly Foam Replacement Apply foams at original locations as required.

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⚠ WARNING

Follow OEM and/or welder manufacturers' recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

Product List

3M™ File Belt Sander,
18 in., PN 33575

3M™ Cubitron™ II File Belt,
grade 80+, PN 33446

Scotch-Brite™ Durable
Flex Belt, CRS, PN 64475

Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Disc, PN 21552

Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Extra Cut Disc,
PN 21555

3M™ Weld-Thru Coating II,
PN 05917

3M™ NVH Dampening
Material, PN 04274

3M™ Flexible Foam,
200mL, PN 08463

3M™ Panel Bonding Adhesive,
50mL, PN 38315;
200mL, PN 08115;
200mL, PN 08116;
450mL DMS, PN 58115

3M™ Impact Resistant
Structural Adhesive
200mL, PN 07333;
450mL DMS, PN 57333

3M™ Composite and
Metal Bonding Adhesive,
200mL, PN 08219

3M™ Rigid Pillar Foam,
200mL, PN 08458

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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300

3M™ Half Facepiece
Respirator, PN 07182

3M™ Virtua™ Protective
Eyewear, PN 11326

Weld Sealing

1		Host Panel Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from host panel. Prep remaining mating flanges on host panel with a coarse Scotch-Brite™ Belt.
2		Mating Flange Panel Preparation Remove E-coat from replacement panel mating flange areas using Scotch-Brite™ Belt or Clean and Strip disc.
3		Clean Clean host panel and replacement panel mating flange areas with a VOC compliant surface cleaner.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flanges areas.
5		Weld-Thru Primer Use Scotch-Brite™ belt to prepare metal surfaces. Clean and apply weld-thru primer to all areas requiring MIG welding. Caution: Do not use Weld-Thru Primer in adhesive bonding areas.
6		Spot Weld Surface Preparation Identify replacement spot weld sites and remove E-coat using Scotch-Brite™ Belt where spot weld tips will contact host and replacement panel. Remove panel once complete.
7		Pre-Assembly NVH Replacement If vehicle construction necessitates, apply NVH material or foams at original locations as required.
8		Apply Seam Sealer Apply urethane or MSP seam sealer to mating flange areas on host panel and replacement panel covering all bare metal areas. Apply additional bead of sealer at mating flange areas.
9		Install Replacement Panel Install replacement panel to host panel. Clamp in place.
10		Spot Weld Spot weld while sealer is uncured at prepared weld sites. Follow welder settings determined from test panel.
11		Sealer Clean Up Remove clamps and tool excess adhesive squeeze-out from repair area prior to curing to seal the repair. Note: Grinding to remove excess sealer can expose bare metal, causing corrosion.
12		Post-Assembly Foam Replacement Apply foams at original locations as required.

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⚠ WARNING

Follow OEM and/or welder manufacturers' recommended procedure for making and testing welds. Before welding on a vehicle, test welds must be made to ensure proper weld quality and welding machine settings.

Product List

3M™ File Belt Sander, 18 in., PN 33575



3M™ Cubitron™ II File Belt, grade 80+, PN 33446



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552



Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555



3M™ Weld-Thru Coating II, PN 05917



3M™ NVH Dampening Material, PN 04274



3M™ Flexible Foam, 200mL, PN 08463



3M™ Urethane Seam Sealer, PN 08361; PN 08362



3M™ MSP Seam Sealer, PN 08370



3M™ Rigid Pillar Foam, 200mL, PN 08458



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Note: Follow recommended internal corrosion protection processes prior to vehicle final assembly.

Door Skin Removal

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Parts Removal

Remove associated trim and parts. Use molding removal tool to remove and save side moldings and emblems.

3



Hem Flange Grinding

Use grade 60 fiber-backed abrasive disc to grind outer edge and separate door skin from door frame.

4



Hem Flange Spot Weld Removal

Use grade 60 file belt to remove any spot welds attaching hem flange to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.** Separate hem flange material from backside of door.

5



Door Skin Spot Weld Removal

Use grade 60 file belt to remove any spot welds attaching door skin to door frame. **Use caution when grinding to only grind top panel and avoid cutting into host/interior panel.**

6



Door Skin Removal

Separate door skin from door frame. Use a putty knife to help separate skin from adhesive and NVH material on intrusion beam. Heat may be used when required for softening. (Maintain original NVH material whenever possible.)

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Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Side Molding
and Emblem Removal
Tool, PN 08978



3M™ Disc Sander,
PN 28408



3M™ Cubitron™ II
Abrasive Fibre Disc,
grade 60+, 5 in.,
PN 33415



3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II
File Belt, grade 60+,
PN 33445



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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Door Skin Replacement

1		Door Frame Preparation Using a grade 80 abrasive belt, remove remaining weld nugget material from door frame. Clean and prep remaining mating flanges on door frame with a coarse Scotch-Brite™ belt.
2		Clean Clean door frame and replacement panel mating flange areas with a VOC compliant surface cleaner.
3		Replacement Skin Prep Scuff replacement skin mating flange areas using Scotch-Brite™ hand pad.
4		Dry Fit Panel Dry fit replacement panel and complete any necessary metal straightening at flange areas. Remove door skin in preparation for adhesive application.
5		NVH Replacement Apply NVH material at original locations on intrusion beam.
6		Apply Bonding Adhesive Re-clean bonding surfaces with a VOC compliant surface cleaner. Apply bonding adhesive to door frame covering all bare metal areas. Apply an additional bead of adhesive at mating flange areas to ensure proper bond line thickness.
7		Install Door Skin Install replacement door skin onto door frame. Crimp hem flange using hammer and dolly. Clamp as necessary. (For aluminum panels, follow OEM recommended flanging procedures.)
8		Clamp and Cure Follow recommended adhesive clamp and cure times. Clean any adhesive squeeze-out from hem flange area with a VOC compliant cleaner.
9		Seam Sealing Re-apply seam sealer to hem flange as required following general seam sealing guidelines.

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Product List

3M™ File Belt Sander, 18 in., PN 33575



3M™ Cubitron™ II File Belt, grade 80+, PN 33446



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926



3M™ NVH Dampening Material, PN 04274



3M™ Urethane Seam Sealer, PN 08361



3M™ MSP Seam Sealer, PN 08370



3M™ Panel Bonding Adhesive, 50mL, PN 38315; 200mL, PN 08115; 200mL, PN 08116; 450mL DMS, PN 58115



3M™ Composite and Metal Bonding Adhesive, 200mL, PN 08219



3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310



3M™ EZ Sand Multi-Purpose Repair Material, 200mL, PN 05887; 600mL DMS, PN 55887



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3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Express Damage Repair

1



Clean the Damaged Area

Clean the repair area with soap and water, followed by a VOC compliant surface cleaner. Use a recommended VOC compliant surface cleaner.

2



Initial Prep Sand

DA sand the repair using 3 in. grade 180 DA disc, being careful to not sand through the clear coat. Blow off with clean dry air and reclean with a surface cleaner.

3



Mix and Apply Glaze

Mix and apply polyester glaze per manufacturer's recommendation or use the 3M™ Dynamic Mixing System. Cure 15–20 minutes at 75°F.

4



Apply Dry Guide Coat

Apply 3M™ Dry Guide Coat over cured glaze. Re-apply as necessary during sanding process.

5



Sand Glaze

Using a grade 320 abrasive disc/sheet, hand block or DA sand glaze, completely removing 3M™ Dry Guide Coat.

6



Final Sand and Inspect

Blow off repair area and re-apply 3M™ Dry Guide Coat. Finish sanding the repair area and the surrounding area using a 3 in. grade 320 abrasive disc. Inspect the repair for quality.

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Product List

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 180+, PN 31364;
3 in., grade 320+, PN 31463



3M™ Platinum™ Plus
Finishing Glaze, 30 oz.
container, PN 31180



3M™ Platinum™ Glaze
for DMS, 10.3 oz.
cartridge, PN 05862



3M™ Dry Guide Coat,
50 gram applicator kit,
PN 05861



3M™ Cubitron™ II Hookit™
Clean Sanding Sheet Roll,
70mm x 12m, grade 320+,
PN 34449



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300










3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Small Damage Repair

1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		Initial Prep Sand DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.
3		Mix and Apply Filler Mix and apply filler per manufacturer's recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F.
4		Sand Filler Using a hand block, shape sand the body filler with grade 80 abrasive. Apply dry guide coat and finish block sanding with grade 150 abrasive. DA featheredge the repair area with grade 180 abrasive disc. Inspect the repair for quality, if glaze is not required, continue to step seven.
5		Mix and Apply Glaze Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer's recommendation or if using the 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.
6		Sand Glaze Sand polyester glaze with grade 180. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.
7		Final Sand and Inspect Blow off repair area. Featheredge the surrounding area using grade 180 abrasive. Inspect the repair for quality.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus, 1 gallon, PN D11101



Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 3 in., grade 80+, PN 31361; 3 in., grade 180+, PN 31364; 6 in., grade 80+, PN 31371; 6 in., grade 180+, PN 31374



3M™ Platinum™ Plus Body Filler, 1 gallon, PN 01131; for DMS, PN 05863



3M™ Platinum™ Select Body Filler, 1 gallon, PN 31131; for DMS, PN 35863



3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861



3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180; for DMS, PN 05862



3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 80+, PN 34442; grade 150+, PN 34445; grade 180+, PN 34446



3M™ Dynamic Mixing Applicator — Pneumatic, PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Large Damage Repair

1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		Initial Prep Sand DA sand the repair area using grade 80, removing paint beyond damage by 2–4 in. Blow off with clean, dry air and re-clean with surface cleaner.
3		Final Metal Prep Remove remaining paint/coatings in “low spots” using a Scotch-Brite™ Clean and Strip disc. Use a 3 in. grinding disc to remove weld nuggets or other surface imperfections. Blow off with clean, dry air and re-clean with surface cleaner.
4		Mix and Apply Filler Mix and apply filler per manufacturer’s recommendation or use the 3M™ Dynamic Mixing System. Keep the body filler within the primer featheredge area. Cure the body filler 15–20 minutes at 75°F.
5		Initial Sand Filler Block shape sand filler with grade 80. DA rough featheredge area with grade 80 abrasive. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Re-apply 3M™ Dry Guide Coat as necessary.
6		Final Sand Filler Final block sand filler with grade 150 abrasive. DA fine featheredge sand the repair area with grade 180 abrasive and blow off the area with clean, dry air. Use 3M™ Dry Guide Coat between sanding steps to highlight imperfections.
7		Mix and Apply Glaze Blow off the repair area completely removing sanding dust from the surface. Mix and apply glaze if required per manufacturer’s recommendation or if using the 3M™ Dynamic Mixing System. Keep the glaze within the primer featheredge area. Cure glaze for 15–20 minutes at 75°F.
8		Sand Glaze Block sand polyester glaze with grade 180 abrasive. Use 3M™ Dry Guide Coat to highlight imperfections. Re-apply glaze as necessary to fill minor imperfections.
9		Final Sand and Inspect Blow off repair area. Featheredge the surrounding area using grade 180 abrasive. Inspect the repair for quality.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar’s® Shampoo Plus,
1 gallon, PN D11101



Meguiar’s® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364;
6 in., grade 80+, PN 31371;
6 in., grade 180+, PN 31374



3M™ Platinum™ Plus Body
Filler, 1 gallon, PN 01131;
for DMS, PN 05863



3M™ Platinum™ Select Body
Filler, 1 gallon, PN 31131;
for DMS, PN 35863



3M™ Cubitron™ II Roloc™
Fibre Disc, 3 in., grade 80+,
PN 33392



3M™ Roloc™+ Holder,
PN 07500



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Disc, PN 21552



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Extra Cut Disc,
PN 21555



3M™ Platinum™ Plus
Finishing Glaze, 30 oz.,
PN 31180; for DMS,
PN 05862



3M™ Dry Guide Coat,
50 gram applicator kit,
PN 05861



3M™ Cubitron™ II Hookit™
Clean Sanding Sheet Roll,
70mm x 12m,
grade 80+, PN 34442;
grade 150+, PN 34445;
grade 180+, PN 34446



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Sealer Coating Removal

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Method A

Use Scotch-Brite™ Clean and Strip disc to remove seam sealer and coatings where accessible.

3



Method B

Use CRS Scotch-Brite™ belt to remove coatings and seam sealers in hard to reach areas.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Disc, PN 21552



Scotch-Brite™ Roloc™+
Clean and Strip XT
Pro Extra Cut Disc,
PN 21555



3M™ File Belt Sander,
18 in., PN 33575



Scotch-Brite™
Durable Flex Belt,
CRS, PN 64475



Think About Your Health

3M™ E-A-R® Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



General Seam Sealer Application: Direct to Metal

1



Surface Prep

Scuff the sealer application areas using a maroon Scotch-Brite™ hand pad. Blow off with clean, dry air.

2



Clean

Use a clean cloth or paper towel to clean repair area with All Purpose Cleaner and Degreaser followed by a VOC compliant wax and grease remover. **DO NOT spray or saturate seams with cleaner.**

3



Apply Tight Coat

Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing of the joint prior to creating the desired appearance.

4



Apply Seam Sealer

Apply seam sealer over the prepared seam. Tool to re-create OEM appearance.

Visit 3MCollision.com for more SOPs and videos

Product List

Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926



Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701



3M™ Urethane Seam Sealer, PN 08361; PN 08362



3M™ MSP Seam Sealer, PN 08370



3M™ Performance Manual Applicator, 200mL, PN 08117



3M™ Dynamic Mixing Applicator — Pneumatic, PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Properly dress and finish welded areas prior to applying direct to metal seam sealer.

General Seam Sealer Application: Non-Direct to Metal

1



Surface Prep

Cover all bare metal areas with a quality urethane or epoxy two-part primer. After allowing to cure as per manufacturers recommendations, scuff primer in sealer application areas using a maroon Scotch-Brite™ hand pad. Blow off with clean, dry air.

2



Clean

Use a clean cloth or paper towel to clean repair area with 3M™ All Purpose Cleaner and Degreaser followed by a VOC compliant wax and grease remover. **DO NOT spray or saturate seams with cleaner.**

3



Apply Seam Sealer

Apply seam sealer over the prepared seam. Tool to re-create OEM appearance.

Visit 3MCollision.com for more SOPs and videos

Product List

Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926



Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701



3M™ Urethane Seam Sealer, PN 08361



3M™ MSP Seam Sealer, PN 08370; Sprayable, PN 08374



3M™ Heavy-Bodied Seam Sealer, 200mL, PN 08308; 600mL DMS, PN 58308



3M™ EZ Sand Multi-Purpose Repair Material, 200mL, PN 05887; 600mL DMS, PN 55887



3M™ Performance Manual Applicator, 200mL, PN 08117



3M™ Dynamic Mixing Applicator — Pneumatic, PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Respirator Assembly/ Organic Vapor N95 Dual Cartridge, PN 07192



3M™ Virtua™ Protective Eyewear, PN 11326



Corrosion Protection (Cavity Wax)

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Shake Aerosol

Agitate the aerosol can thoroughly — one minute of shaking is required to mix the components prior to use. Attach the desired accessory extension and actuator if needed to access the areas inside the panel enclosure.

3



Application with Standard Actuator

If applying to new panels prior to installation use the standard actuator. Spray up to three (3) coats to ensure full coverage and maximize protection.

4



Mark Extension Wand

If using the 360° accessory wand, mark the extension about one inch from the end as a reference to reduce overspray.

5



Insert Wand Into Panel Opening

Insert the wand to the farthest point. Begin spraying as you remove the wand until the reference mark comes into view. Repeat up to three (3) times to ensure complete coverage and maximize corrosion protection.

6



Clean Accessory Nozzle

After application, invert the can and clear material from the accessory wand and nozzle by depressing the actuator.

7



Remove Excess Cavity Wax

Re-assemble the associated parts and wipe off any excess using a VOC compliant surface cleaner.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Cavity Wax Plus
18 oz. aerosol, PN 08852



3M™ Cavity Wax Plus
Applicator Wand Kit,
PN 08851



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Respirator Assembly/
Organic Vapor N95
Dual Cartridge, PN 07192



3M™ Virtua™ Protective
Eyewear, PN 11326



Corrosion Protection (Undercoating)

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



Surface Preparation

Use Scotch-Brite™ Clean and Strip disc to remove loose coatings from the repair area. Use CRS Scotch-Brite™ belt in hard to reach areas.

3



Clean and Inspect

Blow of area with clean dry compressed air to remove dust and loose surface contaminants. Use a VOC compliant surface cleaner to remove any remaining contaminants. **Note: Coatings must be applied over thoroughly cleaned substrates to maximize corrosion protection.**

4



Coating Application

Apply appropriate undercoating following local VOC regulations to the area. For maximum corrosion protection apply four medium coats of undercoating allowing flash time between coats.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus, 1 gallon, PN D11101



Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701



Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Disc, PN 21552



Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555



3M™ File Belt Sander, 18 in., PN 33575



Scotch-Brite™ Durable Flex Belt, CRS, PN 64475



3M™ Waterbased Paintable Undercoating Pouch, 5.5 fl. oz. (US), PN 08744



3M™ Paintable Undercoating Pouch, 5.5 fl. oz., PN 08747



3M™ Accuspray™ HGP Pressure Spray Gun, PN 16587



3M™ PPS™ Type H/O Pressure Cup, Large 28 oz., PN 16124; Mini 6 oz., PN 16121



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300






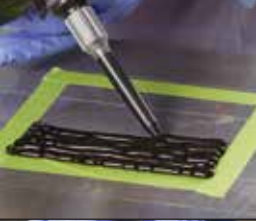

3M™ Respirator Assembly/Organic Vapor N95 Dual Cartridge, PN 07192



3M™ Virtua™ Protective Eyewear, PN 11326



Pre-Made LASD Replacement (Off Body)

1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		LASD Removal Remove sound deadening material from affected repair area using a scraper or chisel. Blow off area with compressed air and clean with APCD.
3 _A		Pre-Make Patch Apply packaging tape to smooth bench top surface as a release liner. Mask out desired patch size and shape over the top of packaging tape.
3 _B		Pre-Make Patch Dispense seam sealer material onto prepared surface.
3 _C		Pre-Make Patch Re-create desired appearance and texture of NVH material using tools of the trade (e.g., brushes, scuff pads, compressed air, etc.). Remove perimeter masking following the tooling process and prior to final cure.
4		Surface Prep Scuff surface with a maroon Scotch-Brite™ hand pad. Blow off area with compressed air and clean with APCD.
5		Install Replica (on body) After material cures, remove the LASD replica from the release liner, scuff with maroon Scotch-Brite™ hand pad, apply NVH material to the bottom of the replica. Bond in place at the correct location.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701

Scotch® Performance
Green Masking Tape 233+,
18mm x 55m (.75 in.),
PN 26334



3M™ Heavy-Bodied Seam
Sealer, 200mL, PN 08308;
600mL DMS, PN 58308



3M™ NVH Dampening
Material, PN 04274



Scotch-Brite™ Durable
Flex Hand Pad, MX-HP,
Very Fine, 4-1/2 in. x 9 in.,
PN 64659



Scotch-Brite™ 7447 PRO
Hand Pads, Very Fine,
6 in. x 9 in., PN 64926



3M™ Performance
Manual Applicator,
200mL, PN 08117



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



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3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Respirator Assembly/
Organic Vapor N95
Dual Cartridge, PN 07192



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: Pre-made LASD replacement patches are typically created off body for panels with complex surfaces.

LASD Replacement (On Body)

1



Pre-Cleaning

Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).

2



LASD Removal

Remove sound deadening material from affected repair area using a scraper or chisel.

3



Surface Prep

Scuff surface with a maroon Scotch-Brite™ hand pad. Blow off area with compressed air and clean with APCD.

4



Application

Mask area and apply seam sealer. Re-create desired appearance and texture of NVH material using tools of the trade (e.g., notched spreaders, brushes, scuff pads, compressed air, etc.). Remove perimeter masking following the tooling process and prior to final cure.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus, 1 gallon, PN D11101



Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701



Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659



Scotch-Brite™ 7447 PRO Hand Pads, Very Fine, 6 in. x 9 in., PN 64926



3M™ Heavy-Bodied Seam Sealer, 200mL, PN 08308; 600mL DMS, PN 58308



3M™ Urethane Seam Sealer, PN 08361



3M™ MSP Seam Sealer, PN 08370



3M™ NVH Dampening Material, PN 04274



3M™ Performance Manual Applicator, 200mL, PN 08117



3M™ Dynamic Mixing Applicator — Pneumatic, PN 05846



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3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Respirator Assembly/Organic Vapor N95 Dual Cartridge, PN 07192



3M™ Virtua™ Protective Eyewear, PN 11326



Plastic Tab Repair

1



Clean the Damaged Area

Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.

2



Initial Prep Sand

Grind the broken tab using a grade 36 file belt, creating a tapered edge. Using a 3 in. DA sander, sand the repair area with a grade 80 abrasive disc to refine grade 36 sand scratches and remove any melted plastic.

3



Prepare the Tab

Drill 1/8 in. pinning holes in the damaged area 1/4 in. from tapered edge and 1/4 in. apart. Apply aerosol adhesion promoter, allowing to dry for 10 minutes.

4



Mix and Apply Super-Fast Repair Material

Cut contour film 3 times the length of tab. Mix and apply adhesive to contour sheet and apply to damaged tab, shaping as you work. Allow to cure 5–10 minutes. Remove contour film.

5



Rough Shape Damaged Tab

Rough shape the repaired tab area with a grade 36 file belt. Using a 3 in. DA sander, sand the repair area with a grade 80 abrasive disc to restore original tab dimensions. Re-drill mounting holes as necessary.

6



Final Sand and Inspect

Using a 3 in. DA sander, finish sand the repair area and the surrounding area using a grade 180 abrasive disc. Blow off the repair area and inspect for quality.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II File Belt,
grade 36+, PN 33443



3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364



3M™ Polyolefin Adhesion
Promoter, 12 oz. aerosol,
PN 05907



3M™ Plastic Contour
Sheet, 5 in. x 12 ft.,
PN 04903



3M™ Super Fast Repair
Adhesive, 200mL,
PN 04247



3M™ Super Fast Repair
Adhesive — Black,
200mL, PN 04248



3M™ Performance
Manual Applicator,
200mL, PN 08117



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182






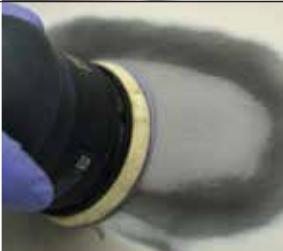


3M™ Virtua™ Protective
Eyewear, PN 11326



Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

Cosmetic Flexible Bumper Repair Scrapes, Gouges and Deformations

1		Clean the Damaged Area Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.
2		Initial Prep Sand “Dish Out” the damaged area using a grade 80 abrasive disc on a 3 in. DA sander. Keep the grade 80 abrasive scratches within the “Dish Out” area. DA sand with grade 180 abrasive to “feather” the repair area 2–3 in. from the “Dish Out” area.
3		Apply Adhesion Promoter Blow off the repair area with clean, dry air. Apply aerosol adhesion promoter, allowing to dry for 10 minutes. Always apply adhesion promoter before any filler material.
4		Mix and Apply Flexible Filler Mix and apply flexible filler with a “tight coat,” followed by additional coats to fill in all low areas. Allow to cure for 15 minutes at 75°F.
5		Sand Flexible Filler DA sand flexible repair material with grade 80 disc to roughly shape, staying on top of the flexible repair material only. Block sand the repair area with grade 180 sheet to finish shaping and featheredging the repair.
6		Final Sand and Inspect Finish sand the repair and the surrounding area using a grade 320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 3, 4 and 5 as necessary.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364;
3 in., grade 320+, PN 31463;
6 in., grade 80+, PN 31371;
6 in., grade 180+, PN 31374;
6 in., grade 320+, PN 31483



3M™ Polyolefin Adhesion
Promoter, 12 oz. aerosol,
PN 05907



3M™ EZ Sand Multi-Purpose
Repair Material,
200mL, PN 05887;
600mL DMS, PN 55887



3M™ Performance
Manual Applicator,
200mL, PN 08117



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



3M™ Cubitron™ II Hookit™
Clean Sanding Sheet Roll,
70mm x 12m, grade 180+,
PN 34446



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182







3M™ Virtua™ Protective
Eyewear, PN 11326



Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

Flexible Patch Non-Structural Bumper Repair

1		Clean the Damaged Area Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner. Be sure to remove any overspray from the back side of the repair area. A Scotch-Brite™ scuffing pad may be used to assist with stubborn overspray.
2		Initial Grinding Grind the front of the repair using a grade 36 file belt. Grind at a low speed creating a "Dish Out" area 3 in. wide that tapers to the bottom of the damage.
3		Initial Prep Sand Sand the "Dish Out" area using a grade 80 abrasive disc on a 3 in. DA sander, removing any melted plastic. Keep the grade 80 abrasive scratches within the "Dish Out" area. Using grade 180 abrasive, feather edge 2–4 in. from the "Dish Out" area.
4		Apply Reinforcement Patch On the back side of the repair area apply the flexible patch adhesion promoter sponge. Firmly apply the flexible reinforcement patch overlapping the damaged area by at least 1-1/2 in. on all sides of the repair.
5		Mix and Apply Flexible Filler Apply 3M™ Polyolefin Adhesion Promoter to the front side of the repair and allow to dry for 10 minutes. Mix and apply flexible filler with a "tight coat" followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.
6		Sand Flexible Filler DA sand flexible repair material with grade 80 disc to roughly shape, staying on top of the flexible repair material only. Block sand the repair area with grade 180 sheet to finish shaping and featheredging the repair.
7		Final Sand and Inspect Using a DA sander, finish sand the repair and the surrounding area using a grade 320 abrasive disc. Blow off and inspect the repair for quality. Repeat steps 5 and 6 as necessary.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II File Belt,
grade 36+, PN 33443



3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364;
3 in., grade 320+, PN 31463;
6 in., grade 80+, PN 31371;
6 in., grade 180+, PN 31374;
6 in., grade 320+, PN 31483



3M™ Automotive Adhesion
Promoter, Sponge Applicator
Packets, 2.5mL per packet,
PN 06396



3M™ EZ Fix Flexible Patch Kit
(with adhesion promoter wipes),
4 in. x 8 in., PN 05888



3M™ Polyolefin Adhesion
Promoter, 12 oz. aerosol,
PN 05907



3M™ EZ Sand Multi-Purpose
Repair Material,
200mL, PN 05887;
600mL DMS, PN 55887



3M™ Performance Manual
Applicator, 200mL, PN 08117



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

Two-Sided Bumper Repair Cracks, Holes & Punctures

1		Clean the Damaged Area Clean the front and back of the repair area with soap and water, followed by a VOC compliant surface cleaner.
2		Prepare for Reinforcement Material Apply aluminum autobody repair tape to the front side of the repair to align and secure the damage while the back side reinforcement is being completed. On the back side, use a DA with grade 80 abrasive disc to sand the repair area where the reinforcement patch will be applied. Blow off with clean, dry air and apply adhesion promoter, allowing 10 minutes to dry.
3		Apply Reinforcement Material Apply alternating applications of thin, wet coats of semi-rigid plastic repair material and reinforcement cloth on the damaged area. Allow dry time of 15 minutes at 75°F.
4		Tapering the Front Side Remove the aluminum tape. Grind the front damage using a grade 36 file belt at a low speed to create a gradual "Dish Out" area 3 in. wide and deep enough to expose a 1/4-inch wide strip of the back side reinforcement material through the center of the damage.
5		Preparing the Repair Area Use a 3 in. DA with grade 80 abrasive disc to create a smooth transition into the dished area, remove any melted plastic and create a fuzzy surface for the adhesive. No shiny plastic areas should remain. Abrade with grade 180 around the dished out area where the adhesive will eventually be featheredged.
6		Mix and Apply Flexible Filler Blow off the front side repair area with clean dry air, apply aerosol adhesion promoter and allow to dry for 10 minutes. Mix and apply flexible filler material with an initial "tight coat" immediately followed by additional coats to fill in all low areas. Allow 15 minutes to cure at 75°F.
7		Sand Flexible Filler DA sand flexible repair material with grade 80 disc to roughly shape, staying on top of the flexible repair material only. Block sand the repair area with grade 180 sheet to finish shaping and featheredging the repair.
8		Final Sand and Inspect Use a DA sander to finish sand the repair area using grade 320 abrasive disc. Blow off and inspect the repair quality. Repeat steps 6 and 7 as necessary.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
3 in., grade 80+, PN 31361;
3 in., grade 180+, PN 31364;
3 in., grade 320+, PN 31463;
6 in., grade 80+, PN 31371;
6 in., grade 180+, PN 31374;
6 in., grade 320+, PN 31483



3M™ Semi-Rigid Plastic
Repair Material, 200mL
cartridge, PN 04240



3M™ Reinforcement
Patch, 5 in. x 12 ft. roll,
PN 04904



3M™ File Belt Sander,
18 in., PN 33575



3M™ Cubitron™ II File Belt,
grade 36+, PN 33443



3M™ Polyolefin Adhesion
Promoter, 12 oz. aerosol,
PN 05907



3M™ EZ Sand Multi-Purpose
Repair Material,
200mL, PN 05887;
600mL DMS, PN 55887



3M™ Performance
Manual Applicator,
200mL, PN 08117



3M™ Dynamic Mixing
Applicator — Pneumatic,
PN 05846



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: We do not recommend a final coat of 3M™ Polyolefin Adhesion Promoter (PN 05907) after the final sanding. The paint companies all recommend their own paint adhesion promoters and applying the PN 05907 may cause a compatibility issue.

General Masking

1



Clean Area

Clean the area with water based cleaner. Wipe area with a VOC compliant solvent prep cleaner. Dry the area. The preferable surface temperature for masking is 60°–80°F.

2



Critical Edge Masking

Mask the areas that require fineline tape first. Mask the rest of the repair and backup the fineline with creped tape. Protect any nearby moldings with trim masking tape.

3



Overspray Protection

Ensure that the car is completely dry prior to applying plastic sheeting. Mask entire vehicle with plastic sheeting. Cut out the repair area with a razor blade. Tape the plastic sheeting directly to critical masking edge.

4



Masking Removal

After painting, remove the masking tape at a 90° angle to the vehicle's surface.

Visit 3MCollision.com for more SOPs and videos

Product List

Scotch® Performance Green Masking Tape 233+, 18mm x 55m (3/4 in. applications), PN 26334; 36mm x 55m (1-1/2 in. applications), PN 26338; 48mm x 55m (2 in. applications), PN 26340



3M™ Vinyl Tape 471+, 1/4 in. width (6.4mm), PN 06405



3M™ Perforated Trim Masking Tape, 5mm, PN 06345; 7mm, PN 06347; 10mm, PN 06349; 15mm, PN 06348



3M™ Overspray Protective Sheeting, 12 ft. x 400 ft. roll, PN 06727; 16 ft. x 350 ft. roll, PN 06728; 20 ft. x 250 ft. roll, PN 06742



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Jamb Masking

1



Clean Area

Clean the area with water based cleaner. Wipe area with a VOC compliant solvent prep cleaner. Dry the area. The preferable surface temperature for masking is 60°–80°F.

2



STT Application

Apply strip of 3M™ Smooth Transition Tape. Set in the jamb so that the tape cannot be felt when running your hand parallel to the panel. Subsequently, when running your hand at a 45 degree angle across the jamb, the tape can be felt. Leave a tab available for easy removal after sealer application.

3



Seal Jamb

Apply 3M™ Soft Edge Foam Masking Tape PLUS to the moving part of the repair area. Position foam tape overlap as necessary to completely seal the jamb against the 3M™ Smooth Transition Tape. Do not stretch foam tape while applying. Once the desired position is achieved, firmly press down along the length of the foam tape to secure. Close the moving part.

4



Positioning the Foam Tape

Press foam into the jamb with fingers to set appropriate depth. In order to avoid sealer creep the foam can be pressed further into the jamb with a spreader after the initial coats are applied.

5



STT Removal

Carefully remove strip of 3M™ Smooth Transition Tape following sealer application.

6



Masking Removal

Remove 3M™ Soft Edge Foam Masking Tape PLUS by stretching the foam parallel to its direction.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Smooth Transition Tape, 1/4 in. x 30 ft. roll, PN 06800



3M™ Soft Edge Foam Masking Tape PLUS, 21mm x 49m (.8 in.), box, PN 06293



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Mask Openings

1



Clean

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2



Back Masking

Back mask outer edge of opening using wide width tape, ensuring that half of tape width is exposed to the opening.

3



Overspray Protection

Cover opening with overspray masking film. Pull tight and adhere film to exposed edge of back masking.

4



Trim Opening

Trim film around inner panel opening.

5



Seal Edge

Seal edge of masking film using wide width masking tape.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



Scotch® Performance
Green Masking Tape 233+,
18mm x 55m
(3/4 in. applications),
PN 26334;
36mm x 55m
(1-1/2 in. applications),
PN 26338;
48mm x 55m
(2 in. applications),
PN 26340



3M™ Overspray Protective Sheeting,
12 ft. x 400 ft. roll, PN 06727;
16 ft. x 350 ft. roll, PN 06728;
20 ft. x 250 ft. roll, PN 06742



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



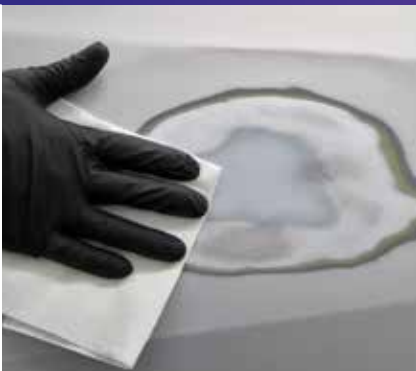
3M™ Virtua™ Protective
Eyewear, PN 11326



Note: All critical edge, jamb masking and general masking should be completed prior to masking openings.

Primer Masking

1



Clean

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2



Begin Back Masking

Begin back mask primer application area using tape and paper. Firmly apply the taped edge of the paper first.

3



Continue Back Masking

Flip paper over to reveal the soft and tapered edge. Tack down with piece of tape on outer edge.

4



Finish Back Masking

Finish back masking the entire perimeter of the repair area.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ ScotchbloK™
Masking Paper,
18 in. x 750 ft.,
PN 06718



Scotch® Performance
Green Masking Tape 233+,
18mm x 55m
(3/4 in. applications),
PN 26334;
36mm x 55m
(1-1/2 in. applications),
PN 26338;
48mm x 55m
(2 in. applications),
PN 26340



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Refinish Bumper Prep

1



Cleaning

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2_A



Surface Prep Hand

Sand edges and other hard to reach areas using grade 800–1000 flexible abrasive sheet until the surface is matte and all sheen has been removed.

2_B



Surface Prep Machine

Sand remaining surfaces using grade 800–1000 flexible abrasives on an orbital sander until the surface is matte and all sheen has been removed.

3



Re-Clean

Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

4



Apply Top Coats

Seal and paint bumper following paint company recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Hookit™ Flexible
Abrasive Sheet,
grade P800, PN 34340;
grade P1000, PN 34341



3M™ Hookit™ Flexible
Abrasive Foam Pad,
PN 34349



3M™ Hookit™ Flexible
Abrasive Interface
Foam Pad, PN 34350



3M™ Orbital Sander,
3 in. x 4 in. Non-Vacuum,
10,000 RPM, PN 20331



3M™ Accuspray™ ONE
Pro Spray Gun Kit for
3M™ PPS™ 2.0, PN 26578



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: Follow paint company recommended procedures for new raw plastic bumpers.

New Primed Bumper Prep

1



Cleaning

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2_A



Surface Prep Hand

Sand edges and other hard to reach areas using grade 400 flexible abrasive sheet until the surface is matte and all sheen has been removed.

2_B



Surface Prep Machine

Sand remaining surfaces using grade 400 flexible abrasives on an orbital sander until the surface is matte and all sheen has been removed.

3



Re-clean

Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

4



Apply Top Coats

Seal and paint bumper following paint company recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Hookit™ Flexible
Abrasive Sheet, grade P400,
5.5 in. x 6.8 in., PN 34337



3M™ Hookit™ Flexible
Abrasive Foam Pad,
PN 34349



3M™ Hookit™ Flexible
Abrasive Interface
Foam Pad, PN 34350



3M™ Orbital Sander,
3 in. x 4 in. Non-Vacuum,
10,000 RPM, PN 20331



3M™ Accuspray™ ONE
Pro Spray Gun Kit for
3M™ PPS™ 2.0, PN 26578



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: Follow paint company recommended procedures for new raw plastic bumpers.

E-Coat Panel Prep

1



Cleaning

Clean part with soap and water, followed by a VOC compliant surface cleaner.

2_A



Surface Prep Hand

Sand edges and other hard to reach areas using grade 400 flexible abrasive sheet or Scotch-Brite™ hand pad until the surface is matte and all sheen has been removed.

2_B



Surface Prep Machine

Sand remaining surfaces using grade 400 abrasive on a DA sander until the surface is matte and all sheen has been removed.

3



Re-clean

Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.

4



Apply Top Coats

Seal and paint following paint company recommendations.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



3M™ Hookit™ Flexible
Abrasive Sheet,
5.5 in. x 6.8 in., grade
P400, PN 34337



Scotch-Brite™ Durable
Flex Hand Pad, MX-HP,
4-1/2 in. x 9 in., Very Fine,
PN 64659



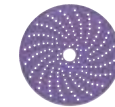
Scotch-Brite™ 7447 PRO
Hand Pads, Very Fine,
6 in. x 9 in., PN 64926



3M™ Hookit™ Flexible
Abrasive Foam Pad,
PN 34349



3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive
Disc, 6 in., grade 400+,
PN 31484



3M™ Accuspray™ ONE
Pro Spray Gun Kit for
3M™ PPS™ 2.0, PN 26578



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300







3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Feather-Prime-Block		
1		Featheredge Blow off repair area. Featheredge the surrounding repair area using grade 180 abrasive.
2		Final Sand and Inspect Final sand surrounding area using grade 320 abrasive disc on a DA sander. Blow off with clean, dry air. Clean with wax and grease remover. Inspect the repair for quality.
3		Mask for Primer Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.
4		Apply Primer Apply primer to repair area following manufacturers recommendations. Allow to cure.
5		Apply Dry Guide Coat Apply 3M™ Dry Guide Coat over cured primer.
6		Hand Block Repair Hand sand or “check block” sand the repair area using a grade 320 abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, re-apply dry guide coat and continue block sanding to repair any defects as required.
7		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over entire repair area.
8		DA Sand Primer DA sand repair area using a grade 400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed.
9		Clean the Damaged Area Clean the repair area with a VOC compliant surface cleaner.
Visit 3MCollision.com for more SOPs and videos		

Product List	
3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 6 in., grade 180+, PN 31374; 6 in., grade 320+, PN 31483 6 in., grade 400+, PN 31484	
3M™ Accuspray™ ONE Pro Spray Gun Kit for 3M™ PPS™ 2.0, PN 26578	
3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861	
3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 320+, PN 34449	

Think About Your Health	
3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300	
3M™ Half Facepiece Respirator, PN 07182	
3M™ Virtua™ Protective Eyewear, PN 11326	

Feather-Prime-Block Waterborne

1		Featheredge Blow off repair area. Featheredge the surrounding repair area using grade 180 abrasive.
2		Final Sand and Inspect Final sand surrounding area using grade 320 abrasive disc on a DA sander. Blow off, with clean, dry air. Clean with wax and grease remover. Inspect the repair for quality.
3		Mask for Primer Mask repair area as necessary. Refer to Primer Masking SOP for 3M specific recommendations.
4		Apply Primer Apply primer to repair area following manufacturer's recommendations. Allow to cure.
5		Apply Dry Guide Coat Apply 3M™ Dry Guide Coat over cured primer.
6		Hand Block Repair Hand sand or "check block" sand the repair area using a grade 320 abrasive sheet on an appropriately sized hand block. Look for imperfections in the repair area highlighted by the dry guide coat. If necessary, re-apply dry guide coat and continue block sanding to repair any defects as required.
7		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over entire repair area.
8		DA Sand Primer DA sand repair area using a grade 400 disc and a soft interface pad until all 3M™ Dry Guide Coat is removed.
9		Re-Apply Dry Guide Coat Re-apply 3M™ Dry Guide Coat over hand blocked repair area.
10		DA Sand Primer DA Sand repair area using a grade 600–800 disc and a soft interface pad until all the 3M™ Dry Guide Coat is removed.
11		Clean the Damaged Area Clean the repair area with a VOC compliant surface cleaner.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
6 in., grade 180+, PN 31374;
6 in., grade 320+, PN 31483;
6 in., grade 400+, PN 31484



3M™ Accuspray™ ONE
Pro Spray Gun Kit for
3M™ PPS™ 2.0, PN 26578



3M™ Dry Guide Coat,
50 gram applicator kit,
PN 05861



3M™ Cubitron™ II Hookit™
Clean Sanding Sheet Roll,
70mm x 12m, grade 320+,
PN 34449



Festool D150 Thin
Interface Pad, PN 30092



3M™ Hookit™ Purple Clean
Sanding Disc 334U,
6 in., grade P600, PN 30761;
6 in., grade P800, PN 30760



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Blend Panel Sanding Process

1



Hand Sand Edges

Scuff hard to reach areas and panel edges by hand with grade 800–1000 abrasive disc or flexible abrasive sheet.

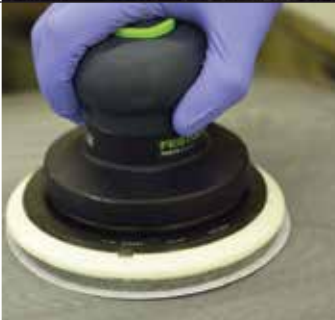
2



Clean and Inspect

Clean the repair area with a VOC compliant or paint manufacturer recommended surface cleaner. Blow dry the repair area with clean, dry air. Inspect the repair area and re-sand any shiny spots as necessary.

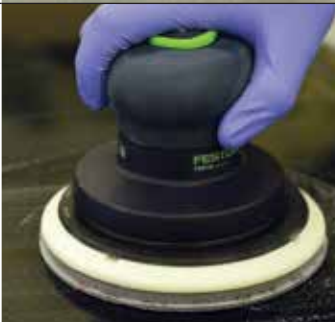
3



DA Sand Color Blend Area

DA sand the color blend area using a grade 800 abrasive disc and a soft interface pad. For best results, sand back into primer surfacer. **Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the top coat surface.**

4



DA Sand Adjacent Panels

DA sand the remainder of the blend panel(s) using a grade 1000 abrasive disc.

5



Clean the Repair Area

Clean the repair area with soap and water, followed by a VOC compliant surface cleaner.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Hookit™ Flexible Abrasive Sheet, 5.5 in. x 6.8 in., grade P800, PN 34340



Festool D150 Thin Interface Pad, PN 30092



3M™ Hookit™ Purple Clean Sanding Disc 334U, 6 in., grade P800, PN 30760



3M™ Hookit™ Flexible Abrasive Disc, 17 hole, 6 in., grade P800, PN 34802; 6 in., grade P1000, PN 34803



3M™ Trizact™ Hookit™ Blending Disc, 6 in., grade P1000, PN 02090



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Anti-Chip Coating

1		Pre-Cleaning Pre-wash/clean vehicle prior to disassembly (power wash undercarriage area at repair).
2		Removal of Heavy Surface Contaminates Clean to remove heavy contaminants from repair area.
3		OEM Coating Removal Remove OEM coating as needed using Scotch-Brite™ Clean and Strip disc. Featheredge using grade 80 abrasive on DA sander. Blow off surface with clean, dry air. Clean surface with 3M™ All Purpose Cleaner and Degreaser.
4		Filling/Leveling Surface Use polyester glaze to fill the repair area, bringing it the same level as the surrounding coating.
5		Sanding and Primer Sand glaze using grade 150 on a hand block. Final featheredge area using grade 320 abrasive on a DA sander. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover. Apply primer following paint company recommendations.
6		Sanding Primer Apply 3M™ Dry Guide Coat to primed surface. Sand primer using grade 320 on a DA sander with an interface pad. Blow off with clean, dry air. Final clean with VOC compliant wax and grease remover.
7		Masking Apply soft edge foam masking tape following existing coating edge. Final mask the area using tape and paper to protect from overspray.
8		Coating Test Panel Apply the coating to a test panel. Always apply a light coat first, allow it to flash, and adjust the spray equipment to deliver the texture required to match the OEM appearance.
9		Apply Coating Apply anti chip coating to the repair area using settings from test panel, blending the material into surrounding area as needed.
10		Blend Sanding Use grade 1000 3M™ Trizact™ Disc on a DA sander to smooth the blend edges. This operation produces a smooth transition without removing chip coating profile.

Visit 3MCollision.com for more SOPs and videos

Product List

Meguiar's® Shampoo Plus, 1 gallon, PN D11101

Meguiar's® Citrus Power Cleaner Plus, 1 gallon, PN D10701

3M™ General Purpose Adhesive Cleaner, aerosol, PN 08987; Adhesive Remover, PN 38983

Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc, PN 21555

3M™ Cubitron™ II Hookit™ Clean Sanding Abrasive Disc, 6 in., grade 80+, PN 31371; 6 in., grade 320+, PN 31483

3M™ Platinum™ Plus Finishing Glaze, 30 oz., PN 31180; Glaze for DMS, PN 05862

3M™ Hookit™ Sanding Block Dust Free, 70mm x 127mm, PN 05207

3M™ Cubitron™ II Hookit™ Clean Sanding Sheet Roll, 70mm x 12m, grade 150+, PN 34445

3M™ Dry Guide Coat, 50 gram applicator kit, PN 05861

Festool D150 Thin Interface Pad, PN 30092

3M™ Soft Edge Foam Masking Tape PLUS, 21mm (.8 in.), PN 06293

3M™ ScotchbloK™ Masking Paper, 18 in. x 750 ft., PN 06718

Scotch® Performance Green Masking Tape 233+, width 12.7mm (.5 in.), PN 26332

3M™ Waterbased Paintable Undercoating Pouch, 5.5 fl. oz. (US), PN 08744

3M™ Rocker Protector Pouch, 3 fl. oz. (US), PN 08733; 5.5 fl. oz. (US), PN 08734

3M™ Accuspray™ HGP Pressure Spray Gun, PN 16587

3M™ PPS™ Type H/O Pressure Cup, 28 oz., PN 16124; 6 oz., PN 16121

3M™ Trizact™ Hookit™ Blending Disc, 6 in., grade P1000, PN 02090

Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

3M™ Respirator Assembly/ Organic Vapor N95 Dual Cartridge, PN 07192

3M™ Virtua™ Protective Eyewear, PN 11326

Base-Coat Denibbing

1



Identify Defects

Identify surface defects and dirt nibs between applications of base coat.

2



Remove Defects

Sand to remove defect using grade 1000 flexible abrasive sheet on foam pad.
Note: Sand in one direction when removing defect to prevent trapping defect.

3



Clean

Blow off surface with clean, dry air.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ Hookit™
Flexible Abrasive
Sheet, grade P1000,
PN 34341



3M™ Hookit™ Flexible
Abrasive Foam Pad,
PN 34349



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



3M™ PPS™ Series 2.0 Spray Cup System

An innovative, all-in-one disposable system that enables painters to eliminate expensive liquid coating waste left on mixing cups and filters by mixing directly in the 3M™ PPS™ cup. Mix, measure, filter and spray your coating materials.

Most Common Part Numbers and Ordering Information

Part No.	Description	Items/ Kit	Kits/ Case	Predecessor Part No.
200 Micron Liner Cup System Kits				
26024	Large (28 oz, 850mL) Lids and Liners – 200 micron filter	50	1	16024
26000	Standard (22 oz, 650mL) Lids and Liners – 200 micron filter	50	1	16000
26112	Midi (13.5 oz, 400mL) Lids and Liners – 200 micron filter	50	1	16112
26114	Mini (6.8 oz, 200mL) Lids and Liners – 200 micron filter	50	1	16114
26028	Micro (3 oz, 90mL) Lids and Liners – 200 micron filter	50	1	16028
Note: Each kit contains 32 sealing plugs and 1 cup; each lid includes a quarter-turn lid locking system				
125 Micron Liner Cup System Kits				
26325	Large (28 oz, 850mL) Lids and Liners – 125 micron filter	50	1	16324/16325
26301	Standard (22 oz, 650mL) Lids and Liners – 125 micron filter	50	1	16301/16300
26312	Midi (13.5 oz, 400mL) Lids and Liners – 125 micron filter	50	1	16312
26314	Mini (6.8 oz, 200mL) Lids and Liners – 125 micron filter	50	1	16314
26328	Micro (3 oz, 90mL) Lids and Liners – 125 micron filter	50	1	16328
Note: Each kit contains 32 sealing plugs and 1 cup; each lid includes a quarter-turn lid locking system				
Lids Only (with Quarter-Turn Lid Locking System)				
26200	Large / Standard Lids – 200 micron filter	25	1	16200
26199	Large / Standard Lids – 125 micron filter	25	1	16199
26204	Midi / Mini / Micro Lids – 200 micron filter	25	1	16204
26205	Midi / Mini / Micro Lids – 125 micron filter	25	1	16205
Hard Cups – Ratios Now Printed on Cups!				
26023	Large Cups (28 oz, 850mL)	2	4	16023
26001	Standard Cups (22 oz, 650mL)	2	4	16001
26122	Midi Cups (13.5 oz, 400mL)	2	4	16122
26115	Mini Cups (6.8 oz, 200mL & 3 oz, 90mL)	2	4	16115
Most Popular Adapters for 3M™ PPS™ Series 2.0*				
26003	PPS™ Series 2.0 Adapter, #S2	4	1	16003
26016	PPS™ Series 2.0 Adapter, #S9	4	1	16016
26046	PPS™ Series 2.0 Adapter, #S15	4	1	16046
26135	PPS™ Series 2.0 Adapter, #S40	4	1	16135
26139	PPS™ Series 2.0 Adapter, #S43	4	1	16139
3M™ Accuspray™ ONE Pro Spray Gun for 3M™ PPS™ Series 2.0*				
26578	Accuspray™ ONE Pro Spray Gun	1	2	16578
26580	Accuspray™ ONE Spray Gun System with PPS™ Series 2.0	1	2	16580
26612	Atomizing Head Refill Pack, 1.2mm, Blue	4	6	16615
26613	Atomizing Head Refill Pack, 1.3mm, Green	4	6	16614
26614	Atomizing Head Refill Pack, 1.4mm, Orange	4	6	16612
26618	Atomizing Head Refill Pack, 1.8mm, Clear	4	6	16611
26620	Atomizing Head Refill Pack, 2.0mm, Red	4	6	16609



***Need a new 3M™ PPS™ Series 2.0 Adapter for your spray gun?**
Find a complete list of adapters at 3MCollision.com/PPSadapters

Cut your costs by picking the cup that fits the job.

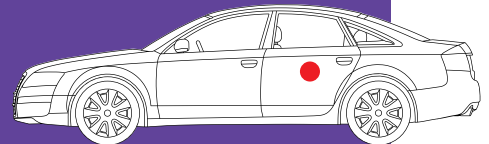
Save money both on cups (smaller cups cost less) and paint (less chance of over-mixing) by always having a ready supply of a variety of 3M™ PPS™ Series 2.0 Kits. Five sizes are available to fit the most common repairs in your shop. Stock them all to maximize your savings!



Spot Repair

Micro Cups

Ideal for areas requiring 3 fluid ounces (90mL) or less of material. EPA 6H compliant.



1-Panel Repair

Mini Cups

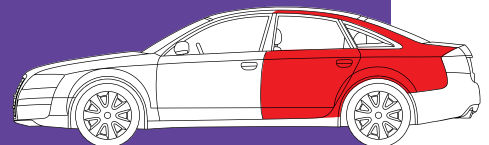
Ideal for areas requiring 6.8 fluid ounces (200mL) or less of material.



2-Panel Repair

Midi Cups

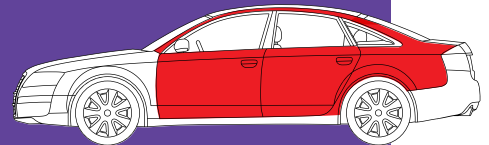
Ideal for areas requiring 13.5 fluid ounces (400mL) or less of material, such as bumpers.



3-Panel Repair

Standard Cups

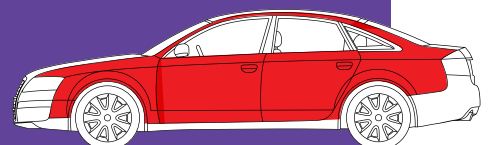
Ideal for areas requiring 22 fluid ounces (650mL) or less of material.



4-Panel Repair

Large Cups

Ideal for areas requiring 28 fluid ounces (850mL) or less of material, including large, clear coat batches.



Pro Tips and Tricks

- Use the 3M™ PPS™ Series 2.0 Shaker Core to remove the lid more easily.
- When removing the lid and liner from the hard cup, twist lid to unlock, place fingers through hole in bottom of cup and push liner upwards, releasing lid and liner together.
- Use the wide base on your 3M™ PPS™ Series 2.0 Cup Sealing Plugs to stand your cups upside down when not in use, helping to keep the filter mesh wet.
- Eliminate traditional mixing cups and filters by mixing materials right inside your 3M™ PPS™ Series 2.0 Cups. Each lid contains a clean, welded-in filter.
- Stock all 5 Kit sizes to always have the right size cup for the job, reducing your cost per use.
- Maintain Compliance with EPA 6H Rule by using the 3 oz/90mL size 3M™ PPS™ Series 2.0 Cups.
- Keep your red 3M™ PPS™ Dispensers. They still work with all 3M™ PPS™ Series 2.0 Lids and Liners.

Paint Mixing and Storage

1		Insert a disposable liner in the cup.
2		Mix paint right inside the 3M™ PPS™ Series 2.0 Cup and Liner. (Note: Reduce material waste by not using a traditional mixing cup or pre-filtering.)
3		Place lid on top of cup, align black portion of quarter-turn lid locking system with cup access window and push down. Twist to lock.
4		Optional: Insert cup sealing plug into lid spout. Use the 3M™ PPS™ Series 2.0 Universal Shaker Core on top of any size cup and place into paint shaker. When paint is mixed, remove shaker core and sealing plug.
5		Choose the right adapter for your spray gun. Push down and twist until adapter locks into lid. (Go to 3MCollision.com/PPSAdapters to find the adapter that fits your spray gun.)
6		When finished spraying, disconnect air line, invert gun and pull trigger to return excess paint to cup. Gently tap 3M™ PPS™ Series 2.0 Lid and Liner on a surface to help break surface tension of liquid and allow it to flow back into liner.
7		Use the 3M™ PPS™ Series 2.0 Cup Sealing Plug to seal and protect coatings not in use, in accordance with local regulations or authorities. Be sure to see Pro Tips section (pg. 39) for easy lid and liner removal from hard cup.
8		Consult paint or solvent Safety Data Sheets (SDS) in addition to local regulations or authorities for safe use and proper disposal.

Visit 3MCollision.com for more SOPs and videos

Product List

3M™ PPS™ Series 2.0
Spray Cup System,
200 Micron Filter,
28oz, PN 26024;
22oz, PN 26000;
13.5oz, PN 26112;
6.8oz, PN 26114;
3oz, PN 26028



3M™ PPS™ Series 2.0
Spray Cup System,
125 Micron Filter,
28oz, PN 26325;
22oz, PN 26301;
13.5oz, PN 26312;
6.8oz, PN 26314;
3oz, PN 26328



3M™ Accuspray™ ONE
Pro Spray Gun Kit for
3M™ PPS™ 2.0, PN 26578



3M™ PPS™ 2.0 Adaptors,
Find your spray gun adapter at:
3MCollision.com/PPSAdapters



Think About Your Health

3M™ Dual Cartridge
Respirator Assembly,
Organic Vapor/P95,
Small, PN 07191;
Medium, PN 07192;
Large, PN 07193



3M™ Full Face-piece
Reusable Respirator
6000 Series,
Small, PN 06700;
Medium, PN 06800;
Large, PN 06900



3M™ Versaflo™ Powered
Air Purifying Respirator
Painters Kit TR-800-PSK,
PN 94248(AAD)



Paint Finish Small Area Process

1		Initial Defect Removal DA sand the repair area with a 3 in. grade 1500/2000 3M™ Hookit™ Purple Finishing Film Disc. Wipe panel clean.
2		Scratch Refinement Refine the grade 1500/2000 scratches with a DA and a 3 in. grade 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area 4–6 times. Wipe panel clean.
3		Compound Compound the repair area with a 3 in. polisher. Use a 4 in. wool or foam compounding pad with 3M™ Perfect-It™ EX AC Rubbing Compound. To insure all sand scratches have been removed, inspect the surface with 3M™ Inspection Spray and wipe with a yellow microfiber cloth.
4		Polish Polish the repair area with a 3 in. polisher. Use a 4 in. foam polishing pad with 3M™ Perfect-It™ EX Machine Polish. Wipe clean with a yellow microfiber cloth.
5		Ultrafine Machine Polish Polish the repair area with a 3 in. polisher. Use a 4 in. ultrafine foam polishing pad with 3M™ Perfect-It™ EX Ultrafine Machine Polish. Wipe clean with a yellow microfiber cloth.
6		Final Detail Clean residual material from adjacent panels and door jamb areas. Cleaning immediately after the repair will greatly improve the ease of clean-up. Inspect the surface using the 3M™ SUN GUN™ II.

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Product List

3M™ Hookit™ Purple Finishing Film Disc, 3 in., grade P1500, PN 30367; grade P2000, PN 30366



3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771



3M™ Trizact™ Hookit™ Foam Disc, 3 in., grade 3000, PN 02087



3M™ Perfect-It™ EX AC Rubbing Compound, 1 qt., PN 36060



3M™ Perfect-It™ Low Lint Wool Compounding Pad, 4 in., PN 30040



3M™ Perfect-It™ Foam Compounding Pad, Single Sided with Inset, Hookit™ attachment, 4 in., PN 30041



3M™ Perfect-It™ EX Machine Polish, 1 qt., PN 06094



3M™ Perfect-It™ Foam Polishing Pad, Single Sided with Insert, Hookit™ attachment, 4 in., PN 30042



3M™ Perfect-It™ Detail Cloth, PN 06016



3M™ Perfect-It™ EX Ultrafine Machine Polish, 1 qt., PN 06068



3M™ Perfect-It™ Ultrafine Foam Polishing Pad, Single Sided with Insert, Hookit™ attachment, 4 in., PN 30043



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ Protective Eyewear, PN 11326



Note: For best results use a process dedicated microfiber cloth.

No Compound Paint Finish Small Area Process

1



Initial Defect Removal

DA sand the repair area with a 3 in. grade 1500/2000 3M™ Hookit™ Purple Finishing Film Disc. Wipe panel clean.

2



Scratch Refinement 3000

Refine the grade 1500/2000 scratches with a DA and a 3 in. grade 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area 4–6 times. Wipe panel clean.

3



Scratch Refinement 8000

Eliminate compounding by refining the grade 3000 scratches with a DA and a grade 8000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area 4–6 times. Wipe panel clean.

4



Finishing Material

Finish the entire repair area with a polisher set at 1200–2000 RPM. For fastest results use a 6 in. 3M™ Perfect-It™ 1-Step Foam Finishing Pad and 3M™ Perfect-It™ 1-Step Finishing Material to remove the previous grade 8000 sand scratches. To ensure all sand scratches have been removed, inspect the repair area by spraying it with 3M™ Inspection Spray and wipe with a yellow microfiber cloth.

5



Final Detail

Clean residual material from adjacent panels and door jamb areas. Cleaning immediately after the repair will greatly improve the ease of clean-up. Inspect the surface using the 3M™ SUN GUN™ II.

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Product List

3M™ Hookit™ Purple Finishing Film Disc, 3 in., grade P1500, PN 30367; grade P2000, PN 30366



3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 3 in., grade P1500, PN 02094



3M™ Trizact™ Hookit™ Foam Disc, 3 in., grade 3000, PN 02087; grade 8000, PN 30804



3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771



3M™ Perfect-It™ 1-Step Finishing Material, 1 qt., PN 33039



3M™ Perfect-It™ 1-Step Foam Finishing Pad, Double Sided, Quick Connect, 6 in., PN 33034; 4 in., PN 33033



3M™ Inspection Spray, 1 gallon, PN 06082



3M™ Quick Connect Adaptor, 14mm Thread, PN 33271



3M™ Perfect-It™ Detail Cloth, PN 06016



3M™ SUN GUN™ II Light Kit, PN 16550



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Particulate Respirator N95, PN 07185



3M™ Virtua™ Protective Eyewear, PN 11326



Paint Finish Full Panel Process

1		Initial Defect Removal Texture Match DA sand the repair area with a grade 1500/2000 3M™ Hookit™ Purple Finishing Film Disc. Remove all paint defects and match texture to adjacent OEM panels. Wipe panel clean.
2		Scratch Refinement 3000 Refine the grade 1500/2000 scratches with a DA and a grade 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. Wipe panel clean.
3		Scratch Refinement 5000 (Optional) To reduce your buffing time refine the grade 3000 scratches with a DA and a grade 5000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. Wipe panel clean. The use of grade 3000 disc is required prior to grade 5000 disc for best results.
4		Compound Compound the repair area with a polisher set between 1200–2000 RPM. For faster results, use a 3M™ Perfect-It™ Foam Compounding Pad and the 3M™ Perfect-It™ EX AC Rubbing Compound. To insure all sand scratches have been removed, inspect the surface by spraying with 3M™ Inspection Spray and wipe with a yellow microfiber cloth.
5		Machine Polish Polish the repair area with a polisher set between 1200–2000 RPM. Use a 3M™ Perfect-It™ Foam Polishing Pad and the 3M™ Perfect-It™ EX Machine Polish. Wipe the panel clean with a yellow microfiber cloth.
6		Ultrafine Machine Polish Polish the repair area with a polisher set between 1200–2000 RPM. Use a 3M™ Perfect-It™ Ultrafine Foam Polishing Pad and 3M™ Perfect-It™ EX Ultrafine Machine Polish. Leave a light film of Ultrafine Machine Polish on the panel and wipe clean with a blue microfiber cloth.
7		Final Detail Clean residual material from adjacent panels and door jamb areas. Cleaning immediately after the repair will greatly improve the ease of clean-up. Inspect the surface using the 3M™ SUN GUN™ II.

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Note: For best results use a process dedicated microfiber cloth.

Product List

3M™ Hookit™ Purple Finishing Film Disc, 6 in., grade P1500, PN 30667; grade P2000, PN 30666

3M™ Trizact™ Hookit™ Clearcoat Sanding Disc, 6 in., grade P1500, PN 02088

Festool D150 Thin Interface Pad, PN 30092

3M™ Trizact™ Hookit™ Foam Disc, 6 in., grade 3000, PN 02085; 6 in., grade 5000, PN 30662

3M™ Perfect-It™ EX AC Rubbing Compound, 1 qt., PN 36060

3M™ Perfect-It™ Foam Compounding Pad, Double Sided, Quick Connect, 8 in., PN 05706

3M™ Perfect-It™ Low Linting 100% Wool Compound Pad, Double Sided, Quick Connect, PN 33279

3M™ Quick Connect Adaptor, 14mm thread, PN 33271

3M™ Perfect-It™ EX Machine Polish, 1 qt., PN 06094

3M™ Perfect-It™ Foam Polishing Pad, Double Sided, Quick Connect, 8 in., PN 05707

3M™ Inspection Spray, 1 gallon, PN 06082

3M™ Perfect-It™ EX Ultrafine Machine Polish, 1 qt., PN 06068

3M™ Perfect-It™ Ultrafine Foam Polishing Pad, Double Sided, Quick Connect, 8 in., PN 05708

3M™ Perfect-It™ Detail Cloth, PN 06016; PN 06020

3M™ SUN GUN™ II Light Kit, PN 16550

Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

3M™ Particulate Respirator N95, PN 07185

3M™ Virtua™ Protective Eyewear, PN 11326

No Compound Paint Finish Full Panel Process

1



Initial Defect Removal

DA sand the repair area with a 6 in. grade 1500/2000 3M™ Hookit™ Purple Finishing Film Disc. Wipe panel clean.

2



Scratch Refinement 3000

Refine the grade 1500/2000 scratches with a DA and a 6 in. grade 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area 4–6 times. Wipe panel clean.

3



Scratch Refinement 8000

Eliminate compounding by refining the grade 3000 scratches with a DA and a grade 8000 3M™ Trizact™ Hookit™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area 4–6 times. Wipe panel clean.

4



Finishing Material

Finish the entire repair area with a polisher set at 1200–2000 RPM. For fastest results use a 8 in. 3M™ Perfect-It™ 1-Step Foam Finishing Pad and 3M™ Perfect-It™ 1-Step Finishing Material to remove the previous grade 8000 sand scratches. To ensure all sand scratches have been removed, inspect the repair area by spraying it with 3M™ Inspection Spray and wipe with a yellow microfiber cloth.

5



Final Detail

Clean residual material from adjacent panels and door jamb areas. Cleaning immediately after the repair will greatly improve the ease of clean-up. Inspect the surface using the 3M™ SUN GUN™ II.

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Product List

3M™ Hookit™ Purple Finishing Film Disc, 6 in., grade P1500, PN 30667; grade P2000, PN 30666



3M™ Trizact™ Hookit™ Clearcoat Sanding Disc, 6 in., grade P1500, PN 02088



Festool D150 Thin Interface Pad, PN 30092



3M™ Trizact™ Hookit™ Foam Disc, 6 in., grade 3000, PN 02085; 6 in., grade 8000, PN 30806



3M™ Perfect-It™ 1-Step Finishing Material, 1 qt., PN 33039



3M™ Perfect-It™ 1-Step Foam Finishing Pad, Double Sided, Quick Connect, 8 in., PN 33035



3M™ Inspection Spray, 1 gallon, PN 06082



3M™ Quick Connect Adaptor, 14mm Thread, PN 33271



3M™ Perfect-It™ Detail Cloth, PN 06016



3M™ SUN GUN™ II Light Kit, PN 16550



Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Particulate Respirator N95, PN 07185



3M™ Virtua™ Protective Eyewear, PN 11326



Headlight Lens Restoration Process

1		Clean and Mask Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.
2		Sand to Remove Yellowing and Defects Dry DA sand the damaged headlight lens with a 3 in. grade 500 3M™ Hookit™ Purple Clean Sanding Disc using a soft interface pad. Completely remove any yellowing and/or surface defects.
3		1st Step Scratch Refinement Refine the grade 500 sand scratches by dry DA sanding with a 3 in. grade 800 3M™ Hookit™ Purple Clean Sanding Disc on a soft interface pad. Wipe the headlight lens clean.
4		2nd Step Scratch Refinement Refine the grade 800 sand scratches by DA sanding with a 3 in. grade 1000 3M™ Trizact™ Hookit™ Blending Disc on a soft interface pad. Use water to lubricate the grade 1000 foam abrasive disc. Spend extra time on this step to ensure removal of all grade 800 sand scratches. Wipe the headlight lens clean.
5		3rd Step Scratch Refinement Refine the grade 1000 sand scratches by DA sanding with a 3 in. grade 3000 3M™ Trizact™ Hookit™ Foam Disc on a soft interface pad. Use water to lubricate the grade 3000 foam abrasive disc. Spend extra time on this step to ensure removal of all grade 1000 sand scratches. Wipe the headlight lens clean.
6		Compound Lens Completely remove the grade 3000 sand scratches using a 3 in. polisher with a 4 in. 3M™ Perfect-It™ Foam Compounding Pad and 3M™ Perfect-It™ EX AC Rubbing Compound. Wipe the headlight lens with a clean microfiber cloth.
7		Polish Lens Polish the headlight lens using a 4 in. 3M™ Perfect-It™ Foam Polishing Pad and 3M™ Perfect-It™ EX Machine Polish. Wipe the headlight lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.

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Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Scotch® Performance
Masking Tape 233+,
18mm x 55m (.75 in.),
PN 26334



3M™ Hookit™ Soft Interface
Pad, 3 in., PN 05771



3M™ Hookit™ Purple
Clean Sanding Disc,
3 in., grade P500, PN 30272;
3 in., grade P800, PN 30260



3M™ Trizact™ Hookit™
Blending Disc, 3 in.,
grade P1000, PN 02091



3M™ Trizact™ Hookit™
Foam Disc, 3 in., 3000,
PN 02087



3M™ Perfect-It™ EX AC
Rubbing Compound,
8 oz., PN 36058



3M™ Perfect-It™ Foam
Buffing Pad, 4 in., PN 30041



3M™ Perfect-It™ EX
Machine Polish, 8 oz.,
PN 06093

3M™ Perfect-It™ Foam
Polishing Pad, 4 in., PN 30042



3M™ Perfect-It™ Detail
Cloth, PN 06016

Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Half Facepiece
Respirator, PN 07182



3M™ Virtua™ Protective
Eyewear, PN 11326



Note: For best results use a process dedicated microfiber cloth.

Vehicle Clean-Up Process

1		Inspect Interior Remove any trash from the vehicle and blow out the air vents. Vacuum the interior of the vehicle including the ashtray, seat folds and trunk. Inspect the carpet and upholstery for any heavily-soiled stains that may require a pre-spot treatment.
2		Clean Interior Carpet and Fabric Dry brush and vacuum. Using Meguiar's® All Purpose Cleaner (10:1), scrub with nylon brush. Use a towel or extractor with hot water only to remove product from carpet mat.
3		Pre-Clean Exterior Apply Meguiar's® Wheel and Tire Cleaner (10:1) to wheel rim area in order to clean brake dust and debris from wheels. Apply Meguiar's® All Purpose Cleaner (10:1) or Meguiar's® Citrus Power Cleaner Plus (10:1) to engine, engine compartment, door jambs, wheels, tires and other hard to clean areas.
4		Rinse Vehicle Exterior Scrub, pressure wash, and rinse any areas where pre-cleaner was applied. Rinse the entire vehicle to remove loose dirt and debris.
5		Wash Vehicle Exterior Pre-soak any remaining bugs, soiled areas or compound residue using Meguiar's® All Purpose Cleaner (10:1). Wash the entire vehicle using a foam or microfiber hand mitt and Meguiar's® Shampoo Plus mixed appropriately with water in a pail. Rinse thoroughly. Dry, using a water blade or chamois as needed.
6		Apply Tire Dressing Dress the tires with a silicone-free tire dressing, being sure to remove the excess with an absorbent cloth.
7		Clean Interior Working from top down, clean all vinyl and plastic surfaces with Meguiar's® All Purpose Cleaner (10:1), excluding clear plastics. Use interior brush and detail brush where required. Dry with cotton towel. Do not use All Purpose Cleaner on clear plastics.
8		Clean Glass Wipe down all interior and exterior glass surfaces with Meguiar's® Glass Cleaner (10:1). Using the two towel method, first clean with a cotton terry towel followed by a dry microfiber towel. Make sure the final wipe is in vertical motion on the outside of the windows and horizontal motion on the inside of the windows.
9		Final Detail Apply a body shop safe spray detailer to the vehicle's exterior surfaces by misting on and wiping off. Spray detailer will remove any compound residue, dust or fingerprints and will also improve gloss.

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Product List

Meguiar's® Shampoo Plus,
1 gallon, PN D11101



Meguiar's® Citrus Power
Cleaner Plus, 1 gallon,
PN D10701



Meguiar's® All Purpose
Cleaner, 1 gallon,
PN D10101



Meguiar's® Non-Acid
Wheel & Tire Cleaner, 1
gallon, PN D14301



Meguiar's® Hyper
Dressing, 1 gallon,
PN D17001



Meguiar's® Glass Cleaner
Concentrate, 1 gallon,
PN D12001



3M™ Perfect-It™ Clean
and Shine, 16 fl. oz.
bottle, PN 06084



3M™ Perfect-It™ Detail
Cloth, PN 06020



Think About Your Health

3M™ E-A-R™ Skull Screws™
Ear Plug, PN P1300



3M™ Virtua™ Protective
Eyewear, PN 11326



Individual Product Instruction and Safety Information

For individual product instructions and applicable precautions see product labels and associated literature for the individual product at **3MCollision.com**

For product material safety data sheets see **3MCollision.com**

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