




Paint Finishing: Large Areas

1		<p>Initial Defect Removal Texture Match</p> <p>DA sand the repair area with a P1500/P2000 3M™ Purple Finishing Film Hookit™ Disc or P1500 3M™ Trizact™ Clearcoat Sanding Disc used damp. Remove all paint defects and match texture to adjacent OEM panels. Wipe panel clean.</p>
2		<p>Scratch Refinement 3000</p> <p>Refine the P1500/P2000 scratches with a DA and a 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean.</p>
3		<p>Scratch Refinement 5000 (Optional)</p> <p>To reduce your buffing time refine the 3000 scratches with a DA and a 5000 grit 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe panel clean. The use of 3000 is required prior to 5000 for best results.</p>
4		<p>Compound</p> <p>Compound the repair area with a high speed polisher set between 1200–2000 RPM. For faster results, use a foam compounding pad and the appropriate rubbing compound. To insure all sand scratches have been removed, inspect the surface by spraying with an Inspection Spray and wipe clean with a yellow microfiber cloth.</p>
5		<p>Machine Polish</p> <p>Polish the repair area with a high speed polisher set between 1200–2000 RPM. Use a black foam polishing pad and the appropriate machine polish. Wipe the panel clean with a yellow microfiber cloth.</p>
6		<p>Ultrafine Machine Polish</p> <p>Polish the repair area with a high speed polisher with the speed set between 1200–2000 RPM. Use a blue foam polishing pad and the appropriate ultrafine machine polish. Leave a light film of the polish on the panel and wipe clean with a blue microfiber cloth.</p>
7		<p>Final Detail</p> <p>Remove any masking material from the repair area and clean any residual sling from adjacent panels and door jamb areas. Cleaning the panel immediately after compounding and polishing will greatly improve the ease of cleaning. Inspect the surface using the 3M™ PPS™ SUN GUN™ II Light Kit.</p>

Product List

- 3M™ Purple Finishing Film Hookit™ Disc, 6 in., P1500, PN 30667; P2000, PN 30666 
- 3M™ Trizact™ Hookit™ Clearcoat Sanding Disc, 6 in., P1500, PN 02088 
- Festool D150 Thin Interface Pad, PN 29939 
- 3M™ Trizact™ Hookit™ Foam Disc, 6 in., 3000, PN 02085; 6 in., 5000 grit, PN 30662 
- 3M™ Perfect-It™ EX Rubbing Compound, 1 qt., PN 36060 
- 3M™ Perfect-It™ Foam Compounding Pad, Double Sided, Quick Connect, 9 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, 9 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, 9 in., PN 05708 
- 3M™ Perfect-It™ Detail Cloth, PN 06016; PN 06020 
- 3M™ PPS™ SUN GUN™ II Light Kit, PN 16550 
- 3M™ Perfect-It™ Clean and Shine, 16 fl. oz. bottle, PN 06084 

Think About Your Health

- 3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300 
 - 3M™ Half Facepiece Respirator, PN 07182 
 - 3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872 
- Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

Prime Parts (Aluminum, SMC, FRP, Composite)

<p>1</p>		<p>Assess and Sand Assess damaged area for flatness/straightness. Use P220 abrasive, if necessary, on a DA over the entire repaired area to guarantee the surface is ready to prime. Blow off the repair area with clean, dry air and a clean cloth. Then clean with a VOC-compliant wax and grease remover to remove any remaining surface contamination.</p>
<p>2</p>		<p>Apply Primer and Finish Sand Apply primer to repair area following manufacturers recommendations. Apply 3M™ Dry Guide Coat over the entire repaired area. Sand with P220 abrasive to ensure flatness.</p>
<p>3</p>		<p>Block Sand Double check flatness of the repair by block sanding it with P220 abrasive.</p>
<p>4</p>		<p>Paint Paint per manufacturer's recommendation.</p>

Product List

3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 220+ grade, PN 31481



3M™ Specialty Adhesive Remover, 15 oz. aerosol, PN 38987



3M™ Dry Guide Coat, PN 05861



3M™ Hookit™ Purple Clean Sanding Sheet Roll, 220 grade, 70mm x 12m, PN 30708



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



3M™ Accuspray™ ONE Spray Gun System with PPS™, PN 16578



Think About Your Health

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



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872



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