Standard Operating Procedures Body Repair

Large Damage Repair



Pre-Cleaning

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



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.



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.



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.



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.



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.



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.



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.



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

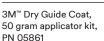


Pro Disc, PN 21552 Scotch-Brite[™] Roloc[™]+

Clean and Strip XT Pro Extra Cut Disc, PN 21555



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





3M™ 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



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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