





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>

Visit 3MCollision.com for more SOPs and videos

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.