

3M Random Orbital Polishing Standard Operating Procedure

Important note on process safety

Always wear Personal Protective Equipment

Comfort Particle Mask P3



Hearing Protection



Comfort Goggles



Reusable Overal



Safety Gloves



Select Step 1a, 1b or 1c based on the size of your repair. Then continue on to Step 2 (Compound) and Step 3 (Polish).

Sanding Spot Defects



► Denib with 3M[™] Finesse-it[™] Trizact[™] A5 Disc, grade 3000 on denib tool

► Refine scratches with 3M[™] Trizact[™] Foam Disc, grade 8000, 75 mm on orbital sander.

► Proceed directly to Polish Step.



466LA Trizact™ A5 Discs 3000



3M™ Mini Orbital Sander, Air Pressure



Festool LEX 3 77



3M™ Trizact™ Foam Disc 8000, 75 mm

Sanding Small Area Defects



► Sand the area with a 3MTM HookitTM Purple Finishing Film Abrasive Disc 260L, grade P1500, 3" (75 mm). Use disc with a soft interface pad. Remove all panel defects and match texture to adjacent OEM panels. Wipe panel clean.

► Refine scratches with a dual action sander and a 3M[™] Trizact[™] Foam Disc, grade 3000, 3" (75 mm). Use disc damp with a soft interface pad. Sand each area 4-6 times.

Wipe panel clean. If scratches are still visible, continue refining.



3M[™] Hookit[™] 260L Purple Finishing



3M™ Trizact™ Foam Disc 3000, 3" (75 mm)



Festool LEX 3 77



Festool Interface-Pad

Sanding Large Area Defects



► Sand the area with a 3M[™] Hookit[™] Purple Finishing Film Abrasive Disc 260L, grade P1500 - P2000, 6" (150 mm). Use disc with a soft interface pad. Remove all panel defects and match texture to adjacent OEM panels. Wipe panel clean.

► Refine scratches with a dual action sander and a 3MTM TrizactTM Foam Disc, grade 3000, 6" (150 mm). Use disc damp with a soft interface pad. Go over each area 4-6 times.

► Wipe panel clean. If scratches are still visible, continue refining.



3M[™] Hookit[™] 260L Purple Finishing Film Disc, 6" (150 mm)



3M™ Trizact™ Foam Disc 3000, 6" (150mm)



Festool LEX 3 150/5

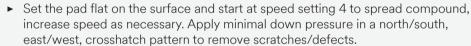


Festool Interface-Pad

Compound



► Apply the compound to the pad in a circular motion by using the cap from the bottle to help spread a small amount of compound throughout the pad. When applying compound to a new pad, its recommended starting at speed setting 1 for a few seconds, to ensure the pad is loaded evenly with compoun before starting the task.



- ► Compound small areas at a time. Approximately a 60 cm x 60 cm area is recommended to ensure adequate scratch/defect removal.
- ▶ Use a 3M[™] Perfect-It[™] Ultra Soft Cloth High Performance to remove the residual film from the surface. If scratches/defects remain, apply 4 drops of compound to the pad and continue compounding.
- ► Ensure all sand scratches have been completely removed. Inspect the surface by spraying with 3M[™] Perfect-It[™] Finish Control Spray and wipe with a clean microfiber cloth.

Note: Clean pads often with a conditioning brush for optimal performance.



3M™ Perfect-It™ Random Orbital Compound



3M[™] Perfect-It[™] Random Orbital Coarse Wool Compounding Pad 5" (130 mm) or 6" (150 mm)



3M™ Perfect-It™ Random Orbital Medium Wool Compounding Pad 5" (130 mm) or 6" (150 mm)



3M[™] Perfect-It[™] Random Orbital Foam Compounding Pad 5" (130 mm) or 6" (150 mm)



3M™ Perfect-It™ Random Orbital Polisher, 15 mm or 21 mm



3M™ Perfect-It™ Ultra Soft Cloth -High Performance



3M™ Perfect-It™ Finish Control Spray

Polish



- Apply the polish to the pad in a circle near the edge of the pad. When applying polish to a new pad, its recommended starting at speed setting 1 for a few seconds, to ensure the pad is loaded evenly before starting the task.
- ► Set the pad flat on the surface and start at speed setting 4 to spread polish. Reduce speed as necessary. Apply minimal down pressure in a north/south, east/west, crosshatch pattern to remove swirls/defects.
- ► Polish small areas at time. Approximately a 60 cm x 60 cm area is recommended to ensure adequate swirl/defect removal
- ► Use a 3MTM Perfect-ItTM Ultra Soft Cloth High Performance to remove the residual film from the surface. If swirls/defects remain, apply 4 drops of polish to the pad and continue polishing.



3M™ Perfect-It™ Random Orbital Polish



3M™ Perfect-It™ Random Orbital Polishing Pad 5" (130 mm) or 6" (150 mm)



3M™ Perfect-It™ Random Orbital Polisher, 15 mm or 21 mm



3M™ Perfect-It™ Ultra Soft Cloth -High Performance

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For additional information, including important safety and warranty information, regarding 3M Automotive Aftermarket Products, please visit: www.3m.co.uk/aad-info