

Cosmetic Repair (SMC, FRP, Composites)

1



Clean the Damaged Area

Clean the repair area with soap and water followed by a VOC compliant surface cleaner making sure to minimize the exposure of damaged or exposed fibers to the cleaners. Thoroughly dry the part. **DO NOT** apply any other cleaners throughout the remainder of the repair procedure.

2



Rough Grind

Dish out the repair area with a grade 60 3M™ Roloc™ Abrasive Disc on a pistol grip sander set at a lower speed. Finish dishing out the repair area using a P80 abrasive disc on a DA.

3



Feather-edge

Finish the dish-out process using a P180 abrasive disc and feather well into the surrounding area. Blow off the repair area with clean, dry air and a clean cloth.

4



Adhesion Promoter

SMC and Fiberglass do not require an adhesion promoter. If repairing Metton® Liquid Molding Resin, apply a light, consistent coat of 3M™ Polyolefin Adhesion Promoter, to the repair area. Allow adhesion promoter to dry for 5 minutes before applying the adhesive/filler.

5



Apply

Following product instructions, apply a tight coat of adhesive/filler to the repair area to insure good contact with the composite. Continue to build until the repair area is slightly higher than the surrounding area. For best results heat set at 150°F for 15 minutes.

6



Rough Sand and Shape Filler

Rough shape the filler once it has cooled using a DA or a hand block with a P80 abrasive. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections.

7



Final Sand and Inspect

Final DA or block sand the filler with P180 abrasive and feather into the surrounding composite and paint. Apply 3M™ Dry Guide Coat between sanding steps to highlight imperfections. Finish sanding with a P220 abrasive sanding well into the surrounding surface. **Note: Contact your paint manufacturer for final sand preparation.**

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Product List

3M™ Car Wash Soap Concentrate, 5 gallons, PN 38378



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



3M™ Cubitron™ II Fibre Roloc™ Disc, grade 60+, 3 in. (75mm), PN 33391



3M™ Cubitron™ II Clean Sanding Hookit™ Disc, 6 in., 180+ grade, PN 31374; 220+ grade, PN 31481



3M™ Polyolefin Adhesion Promoter, PN 05907



3M™ Rigid Parts Repair, 400mL, PN 08275



Marson® Yellow Spreaders, PN 20395



3M™ Dry Guide Coat, PN 05861



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.

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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IMPORTANT NOTE: There are of course many factors and variables that can affect an individual repair, so the technician and repair facility need to evaluate each specific application and repair process, including relevant vehicle, part and OEM guidelines, and determine what is appropriate for that repair.



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