






Headlight Restoration

1		<p>Clean and Mask</p> <p>Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.</p>
2		<p>Sand to Remove Yellowing and Defects</p> <p>Dry DA sand the damaged headlight lens with a 3 in. P500 abrasive disc using a soft interface pad. Completely remove any yellowing and/or surface defects.</p>
3		<p>1st Step Scratch Refinement</p> <p>Refine the P500 sand scratches by dry DA sanding with a 3 in. P800 abrasive disc on a soft interface pad. Wipe the headlight lens clean.</p>
4		<p>2nd Step Scratch Refinement</p> <p>Refine the P800 sand scratches by DA sanding with a 3 in. P1000 foam disc on a soft interface pad. Use water to lubricate the P1000 foam abrasive disc. Spend extra time on this step to ensure removal of all P800 sand scratches. Wipe the headlight lens clean.</p>
5		<p>3rd Step Scratch Refinement</p> <p>Refine the P1000 sand scratches by DA sanding with a 3 in. P3000 foam abrasive disc on a soft interface pad. Use water to lubricate the P3000 foam abrasive disc. Spend extra time on this step to ensure removal of all P1000 sand scratches. Wipe the headlight lens clean.</p>
6		<p>Compound Lens</p> <p>Completely remove the P3000 sand scratches using a 3 in. polishing tool with a foam compounding pad and rubbing compound. Wipe the headlight lens with a clean microfiber cloth.</p>
7		<p>Polish Lens</p> <p>Polish the headlight lens using a 3 in. foam polishing pad and machine polish. Wipe the headlight lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.</p>

Product List

3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377



Scotch® Performance Masking Tape 233+, 18mm x 55m, PN 26334



3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771



3M™ Purple Clean Sanding Hookit™ Disc, 3 in., P500, PN 30272; 3 in., P800, PN 30260



3M™ Trizact™ Hookit™ Blending Disc, 3 in., P1000, PN 02091



3M™ Trizact™ Hookit™ Foam Disc, 3 in., 3000, PN 02087



3M™ Perfect-It™ EX Rubbing Compound, 8 oz., PN 36058



3M™ Perfect-It™ Foam Buffing Pad, 3 in., PN 30041



3M™ Perfect-It™ EX Machine Polish, 8 oz., PN 06093



3M™ Perfect-It™ Foam Polishing Pad, 3 in, PN 30042



3M™ Perfect-It™ Detail Cloth, PN 06016



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.

Properly dress and finish welded areas prior to applying direct to metal sealer.

Seam Sealer Installation: Direct to Metal

1



Surface Prep

Scuff sealer application areas using a maroon Scotch-Brite™ Hand Pad. Blow off with clean, dry air.

2



Clean

Use a clean cloth or paper towel to clean repair area with all purpose cleaner and degreaser followed by a VOC compliant wax and grease remover. **Note: DO NOT spray or saturate seams with cleaner.**

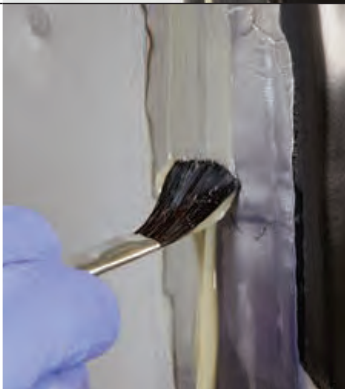
3



Apply Tight Coat

Apply thin bead of sealer to desired joint. Tool sealer into seam ensuring proper sealing and adhesive qualities.

4



Apply Seam Sealer

Apply seam sealer over the prepared seam. Tool to recreate OEM appearance.

Product List

Scotch-Brite™ Hand Pads 7447 PRO, Very Fine grade, 6 in. x 9 in., PN 64926



3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350



Marson® Yellow Spreaders, PN 20395



3M™ Urethane Seam Sealer, PN 08361; PN 08362



3M™ MSP Seam Sealer, PN 08370



3M™ Bare-Metal Seam Sealer 200mL, PN 08310; 600mL DMS, PN 58310



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