

**3M** Science.  
Applied to Life.™

**3M**

**CUBITRON II**

Abrasives

*Now in finer grades!*

*240+ and 320+*

# 3M Body Repair Solutions Guide

Trusted Collision Repair Products



# CUBITRON™ II

## Abrasives

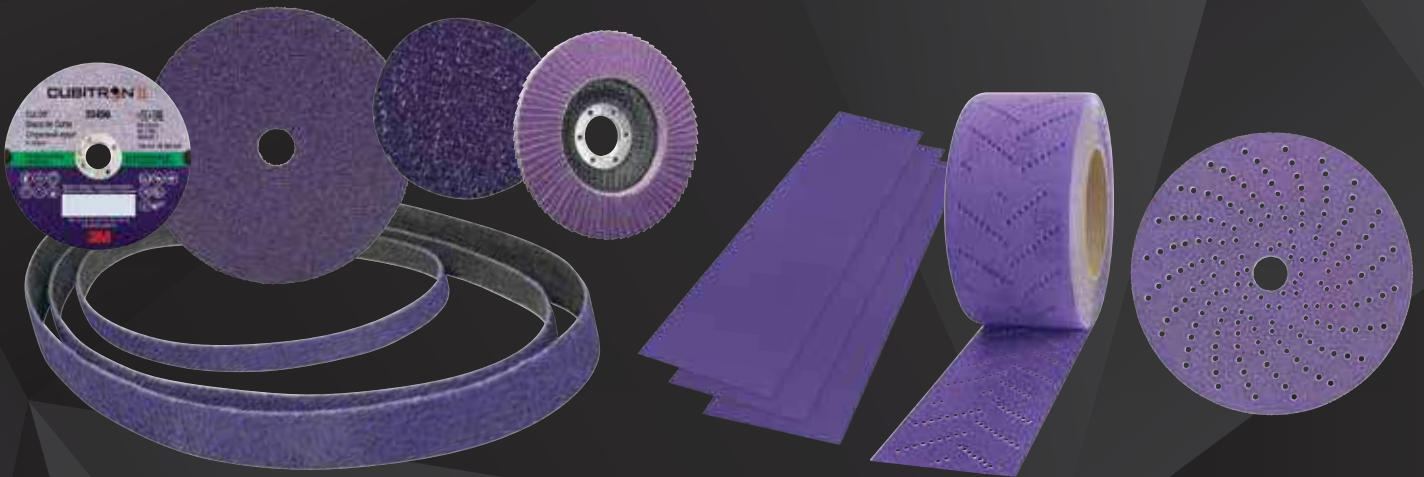
**Now in finer grades  
for your body shop!**

240+

320+

Available in discs and sheet rolls. See pages 2–3.

**Our best performing abrasives!**



## 5 Reasons to switch to Cubitron™ II abrasives:

1

Cuts 30% faster than conventional ceramic abrasives with less technician effort.

2

Lasts twice as long as other high-performance abrasives because of 3M patented technology.

3

Runs cooler than conventional abrasives, resulting in lower chance of warping the panel or degrading the metal.

4

Delivers a finer, more-uniform finish than conventional abrasives.

5

Saves time and money with improved productivity.

### 3M technologies applied to Cubitron™ II abrasives

Ce

Ceramics

3M has decades of experience creating minerals that match hardness and toughness of the mineral to the application.

Mr

Micro-replication

Microreplication allows the same mineral structure to be repeated for all 3M Precision-Shaped Grains.

Pp

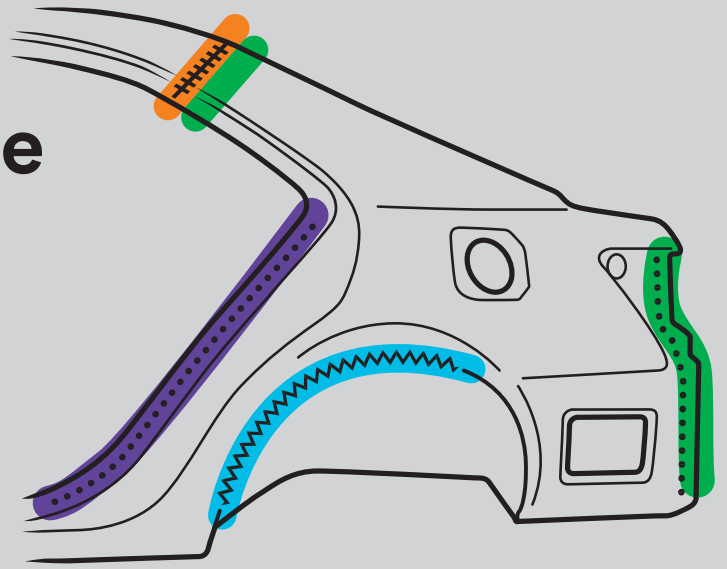
Precision Processing

Precision processing deposits uniform mineral structures on the right locations, regardless of the product substrate.





# Choose the right 3M product for the right application.



-  Surface Preparation
-  Spot Weld Removal
-  Weld Grinding
-  Sectioning
-  Hem Flange Removal




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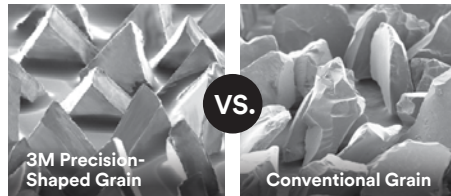
# CUBITRON™ II

Abrasive Discs, Sheets and Rolls

# Surface Preparation

### PSG

3M Precision-Shaped Grain continuously fractures to form sharp points and edges — slicing cleaner, faster, staying cooler and lasting many times longer.



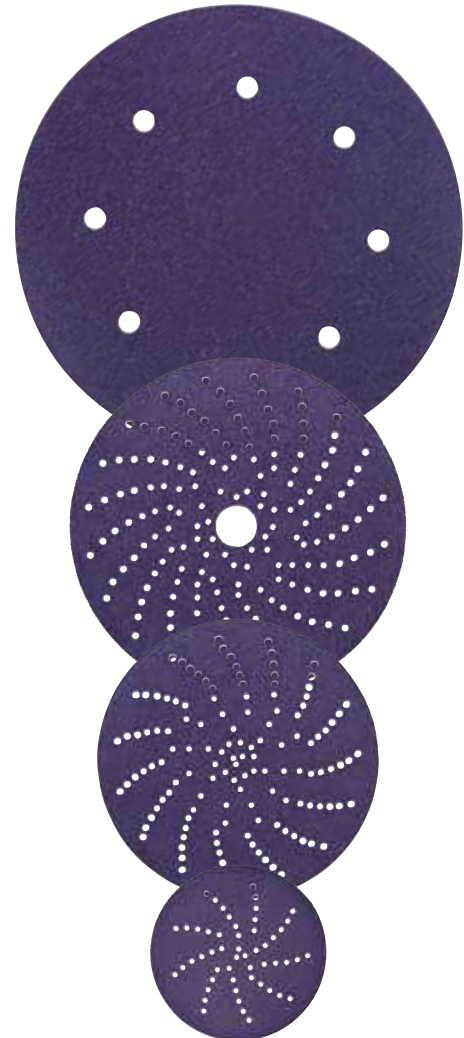
**New finer grades:  
240+ and 320+**

*Same cut and life you've grown to love, now in finer grades for the paint shop. Available in discs and sheet rolls.*

## 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Discs

Use for paint stripping, body filler sanding and featheredging. 3M Precision-Shaped Grain (PSG) slices through paint and body filler, wears evenly, and provides long life and consistency. Discs utilize the 3M™ Hookit™ Attachment System for simple application and easy reuse.

Part No.	Grade	Discs per Box	Boxes per Case	Dia.
Use with Festool Disc Pads				
31375	40+	25	4	8"
31376	80+			
31370	40+			
31371	80+			
31372	120+	50	4	6"
31373	150+			
31374	180+			
31481	220+			
31482	240+	50	4	5"
31483	320+			
31366	80+			
31367	120+			
31368	150+	50	4	3"
31369	180+			
31471	220+			
31472	240+			
31473	320+	50	4	3"
31361	80+			
31362	120+			
31363	150+			
31364	180+	50	4	3"
31461	220+			
31462	240+			
31463	320+			



### 3M™ Cubitron™ II Hookit™ File Sheets

Featuring 3M Precision-Shaped Grain technology, these ceramic abrasives cut much more efficiently than other conventional ceramic abrasives — allowing users to realize significant improvements in the cut speed and life of each sheet.



Part No.	Grade	Sheets per Box	Boxes per Case	Size
Use with 3M™ Hookit™ Sanding Blocks				
<b>34490</b>	40+	25	4	2-3/4" x 16-1/2"
<b>34492</b>	80+			
<b>34494</b>	120+			
<b>34495</b>	150+			
<b>34496</b>	180+			
<b>34497</b>	220+			

For accessories, see page 13.

### 3M™ Cubitron™ II Clean Sanding Hookit™ Sheet Rolls

Featuring a unique “kiss cut” technology that allows multiple product lengths to be extracted from a single roll. Chevron type holes allow for clean sanding. Can be used on any 3M™ Hookit™ Sanding Block.



Part No.	Grade	Rolls per Box	Boxes per Case	Size
Use with 3M™ Hookit™ Sanding Blocks				
<b>34440</b>	40+	1	5	2-3/4" x 8.75 yd
<b>34442</b>	80+			
<b>34444</b>	120+			
<b>34445</b>	150+			
<b>34446</b>	180+			
<b>34447</b>	220+			
<b>34448</b>	240+			2-3/4" x 13 yd
<b>34449</b>	320+			

For accessories, see page 13.

### 3M™ Dry Guide Coat

An important step in any repair to ensure superior results. Helps reduce possible costly rework. No masking, no overspray, no solvents and no dry-time. No loading during sanding and ideal for wet or dry sanding. Total and proper coverage into surface imperfections.



Part No.	Description	Units per Case
<b>05860</b>	Cartridge	10
<b>05861</b>	Kit	6



3M™ Platinum™ Select Filler  
31131



3M™ Platinum™ Plus Finishing Glaze  
31180



3M™ Cubitron™ II Flap Disc — T29  
33470



3M™ Hookit™ Sanding Block, Dust Free  
05208

## Related Products



**CUBITRON™ II**

**Abrasive File Belts**

# Spot Weld Removal

3M™ Cubitron™ II File Belts are ideally suited for use with the 3M™ File Belt Sander for a variety of metalworking applications in the auto body shop.

## 3M™ Cubitron™ II File Belts

Our most advanced file belts for use with the 3M™ File Belt Sander as an alternative to spot weld drilling, providing improved control and ease of use for spot weld removal and many common body shop metal grinding applications. 3M Precision-Shaped Grain technology provides improved cut, a more consistent finish and two times longer belt life while running cooler than conventional ceramic abrasives.



Part No.	Grade	W x L	Belts per Box	Boxes per Case
<b>33437</b>	36+			
<b>33439</b>	60+	3/8" x 13"	10	5
<b>33440</b>	80+			
<b>33443</b>	36+			
<b>33445</b>	60+	1/2" x 18"	10	5
<b>33446</b>	80+			
<b>33449</b>	36+			
<b>33451</b>	60+	3/4" x 20-1/2"	10	5
<b>33452</b>	80+			

For tools, see page 10.







## Scotch-Brite™ Durable Flex Belt

Aggressive and long-lasting non-woven belt is reinforced with low stretch backing for durability. Produces a fine and consistent finish. Great for general surface prep for welding and adhesive bonding. Cleans welds and hot spots. Feathers edges for plastic repair.



Part No.	Grade	W x L	Belts per Case
<b>77257</b>	A CRS		
<b>77256</b>	A MED	3/8" x 13"	40
<b>77255</b>	A FIN		
<b>64475</b>	A CRS		
<b>66458</b>	A MED	1/2" x 18"	20
<b>64467</b>	A FIN		

For tools, see page 10.



3M™ Mini File Belt Sander 33573



3M™ File Belt Sander 33575



3M™ Heavy-Bodied Seam Sealer 08308



Adhesive 08115

## Related Products



CUBITRON™ II


# Weld Grinding

## Abrasive Discs

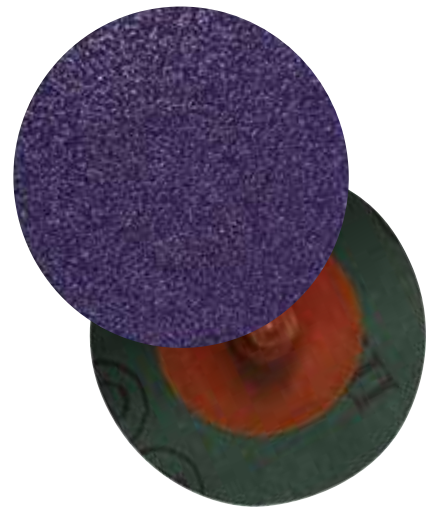
Versatility is key to productivity. With 3M™ Roloc™ Discs, a quick 1/2 turn on, 1/2 turn off speeds up disc changing. 3M™ Flap Discs, 3M™ Fibre Discs (page 9) and 3M™ File Belts (pages 4–5) can also be used for weld grinding.

### 3M™ Cubitron™ II Fibre Roloc™ Discs

Our most advanced Roloc disc, the 3M™ Cubitron™ II Fibre Roloc™ Disc is designed for heavy duty metalworking applications such as weld grinding and clean-up. Features rigid fibre backing for increased cut performance.

Part No.	Grade	Dia.	Max. RPM	Discs per Box	Boxes per Case
Roloc TR (Plastic Button) 					
<b>33377</b>	36+				
<b>33379</b>	60+	2"	25,000	15	6
<b>33380</b>	80+				
<b>33389</b>	36+				
<b>33391</b>	60+	3"	20,000	15	6
<b>33392</b>	80+				

For tools and accessories, see page 11.



### 3M™ Cubitron™ II Flap Discs — T29

Combining 3M Precision-Shaped Grain with a durable yet flexible backing; this 3M™ Cubitron™ II Flap Disc is an outstanding choice for rapidly removing welds, grinding edges, finishing metal and removing paint.

Part No.	Grade	Dia.	Discs per Box	Boxes per Case
<b>33470</b>	40+			
<b>33471</b>	60+	4-1/2" x 7/8"	5	6
<b>33472</b>	80+			


For tools and accessories, see page 12.





## Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Extra Cut Disc

Features aluminum oxide abrasive mineral incorporated into an open nylon web. It is designed to remove heavy rust, thick paint and corrosion while also scratching the base material underneath, which can save you time.


Part No.	Grade	Type	Size	Units per Case
Roloc TR (Plastic Button) 				
<b>21543</b>		TR	2" x NH	60 (10/inner)
<b>21544</b>	A XCS		3" x NH	10
<b>21555</b>		TR+	4" x 1/2"	

For tools and accessories, see page 11.



## Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Disc

Features silicon carbide abrasive mineral incorporated into an open nylon web. It effectively removes rust, paint, mill scale, coatings and adhesives from surfaces without significantly altering the base material.


Part No.	Grade	Type	Size	Units per Case
Roloc TR (Plastic Button) 				
<b>21538</b>		TR	2" x NH	60 (10/inner)
<b>21540</b>	S XCS		3" x NH	10
<b>21552</b>		TR+	4" x 1/2"	

For tools and accessories, see page 11.



## Scotch-Brite™ Roloc™ Surface Conditioning Disc

These non-woven surface conditioning discs give you a finish that can meet the highest standards of quality control. Open web construction resists loading, providing up to twice the service life with an easy-to-handle blend on aluminum, oily carbon and other soft metal surfaces.

Part No.	Grade	Type	Size	Discs per Box	Boxes per Case
Roloc TR (Plastic Button) 					
<b>07480</b>	A CRS				
<b>07481</b>	A MED	TR	2" x NH	25	4
<b>07515</b>	A VFN				
<b>07485</b>	A CRS				
<b>07486</b>	A MED	TR	3" x NH	25	4
<b>07513</b>	A VFN				

For tools and accessories, see page 11.



3M™ Pistol Grip Disc Sander 33577



3M™ Disc Sander 28408



3M™ Bare-Metal Seam Sealer 08310



3M™ Impact Resistant Structural Adhesive 07333

## Related Products



# CUBITRON™ II

## Abrasive Discs and Wheels

# Sectioning

3M™ Cubitron™ II Cut-Off Wheels are designed for cutting and heavy stock removal of metals and fiberglass.

### 3M™ Cubitron™ II Cut-Off Wheels

Used for cutting autobody sheet metal, frame rails, exhaust pipes, clamps and rusted bolts. Constructed with 3M Precision-Shaped Grain for fast-cutting, longer lasting and cooler running performance than conventional ceramic abrasives. **DO NOT USE WITHOUT GUARDS!**



Part No.	Size	Max. RPM	Wheels per Box	Boxes per Case
ALWAYS USE WITH GUARD				
33456	3" x 1/25" x 3/8"	25,465	5	6
33455	3" x 1/16" x 3/8"			
33460	4" x 1/25" x 3/8"	19,100		
33467	4-1/2" x 1/25" x 7/8"	13,300		

For tools, see page 10.







# Hem Flange Removal

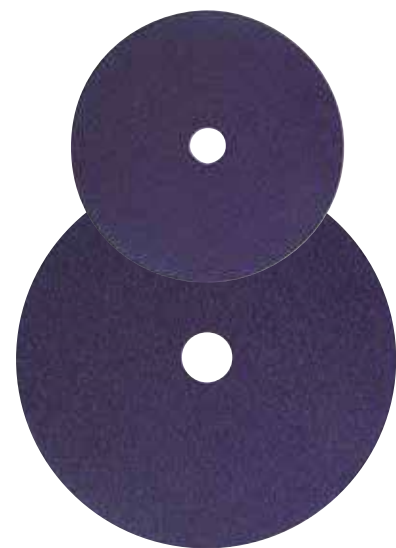
Designed for use with the appropriate disc sander, 3M™ Cubitron™ II Fibre Discs provide fast cut and speed, offering low total cost per grind.

## 3M™ Cubitron™ II Abrasive Fibre Discs

Performance class abrasive utilizes 3M Precision-Shaped Grain ceramic abrasive technology, which allows for faster cutting of welds and door skin removal. When stripping paint, the improved construction resists loading while generating less heat.

Part No.	Grade	Dia. x Ctr.	Max. RPM	Discs per Box	Boxes per Case
<b>33413</b>	36+				
<b>33415</b>	60+	5" x 7/8"	12,000	5	5
<b>33416</b>	80+				
<b>33425</b>	36+				
<b>33427</b>	60+	7" x 7/8"	8,600	5	5
<b>33428</b>	80+				

For tools and accessories, see page 12.



3M™ Cut-Off Wheel  
Tool 33579



3M™ Disc Sander  
28408



3M™ Composite  
and Metal Bonding  
Adhesive 08219



3M™ EZ Sand Multi  
Purpose Repair  
Material 05887

## Related Products



# 3M™ Body Repair Tools

## 3M™ Mini File Belt Sander and File Belt Sander

3M™ File Belt Sanders allow technicians to access hard-to-reach areas and are great for spot weld removal, deburring, cleaning, and finishing. Remove spot welds cleanly and quickly with 3M™ Cubitron™ II File Belts — replacing the need for expensive drills and bits. Adjustable arm for user comfort and multiple applications. Available in 13" and 18" sizes.



Part No.	Belt Size in (mm)	Max RPM	Weight lb (kg)	Height in (mm)	Length in (mm)	Motor hp (W)
Belt Speed: 4100 SFPM (1250 SMPM)						
<b>33573</b>	3/8 × 13 (10 × 330)	17,000	2.07 (0.94)	2.87 (73)	12.50 (320)	0.65 (485)
<b>33575</b>	1/2 × 18 (13 × 457)		2.16 (0.98)		15.15 (385)	

For belts, see pages 4–5.

## 3M™ Cut-Off Wheel Tools

3M™ Cut-Off Wheel Tools deliver the performance you need when working with tough automotive substrates. When paired with 3M™ Cubitron™ II Cut-Off Wheels, technicians can even slice through high-strength steel and aluminum with clean, straight lines and minimal effort. Power with a Cubitron II cut-off wheel for a cleaner cut that runs cooler. Compact design with built-in safety features for easy handling. Featuring a light-weight composite body for greater user comfort. Available in 3" and 4" sizes.



Part No.	Wheel Size in (mm)	Max RPM	Thread Size	Weight lb (kg)	Height in (mm)	Length in (mm)	Motor hp (W)
ALWAYS USE WITH GUARD							
<b>33579</b>	3 (75)	20,000	1/4" – 28	1.91 (0.87)	3.14 (79.6)	7.73 (196)	0.70 (522)
<b>33581</b>	4 (100)			2.00 (0.91)	3.42 (86.9)		

For wheels, see page 8.

## Related Products



3M™ Cubitron™ II File Belt 33437



3M™ Cubitron™ II Cut-Off Wheel 33456



3M™ Cubitron™ II Fibre Roloc™ Disc 33389



3M™ Panel Bonding Adhesive 08115

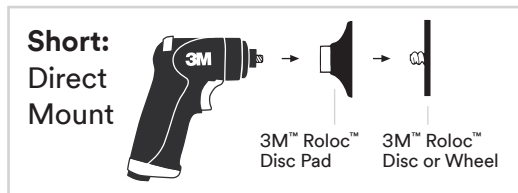
### 3M™ Pistol Grip Disc Sander

Light-weight tool with the power to grind welds. Conveniently sized to access small and hard-to-reach areas. Perfect for grinding and sanding applications with our 3M™ Cubitron™ II Fibre Roloc™ Discs. Variable speed adjustment for optimal finish.



Part No.	Max RPM	Thread Size	Weight lb (kg)	Height in (mm)	Length in (mm)	Motor hp (W)
Use with 2" (50mm) and 3" (75mm) discs*						
<b>33577</b>	18,000	1/4" - 20	1.76 (0.8)	2.05 (52)	7.50 (189)	0.45 (336)

\*Tool includes a 2" (50mm) and 3" (75mm) 3M™ Roloc™ Disc Pad. For discs, see page 6-7.

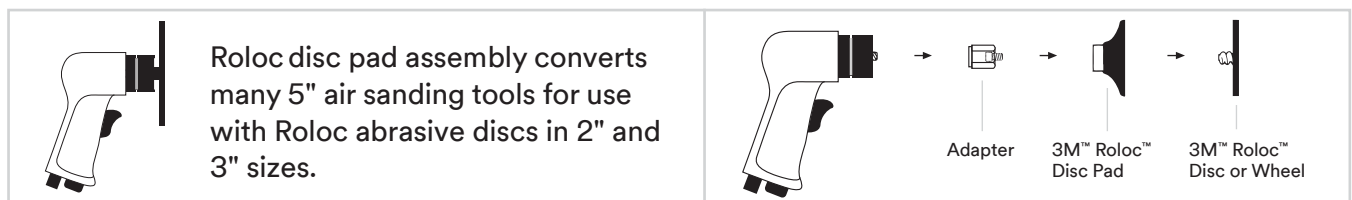


### 3M™ Roloc™ Disc Pad Assembly

Hard rubber backup pad provides firm support for 3M™ Roloc™ Abrasive Discs. Pad has a 1/4-20 INT thread which allows it to be mounted directly to tools with 1/4-20 EXT threaded shafts. Assembly includes a 2" or 3" 3M™ Roloc™ Disc Pad, shaft and adapter.



Part No.	Size	Max. RPM	Unit	Units per Case
<b>05539</b>	2"	25,000	Assembly	10
<b>05540</b>	3"	20,000		



### 3M™ Roloc™ + Holder

Allows use of Scotch-Brite™ Roloc™ + Clean and Strip Disc on your tool. The 1/4" shank fits into any recommended standard tool with 1/4" collet. Quick and easy to use.



Part No.	Size	Unit	Units per Case
<b>07500</b>	2"	Each	10

# 3M™ Body Repair Tools

## 3M™ Disc Sander

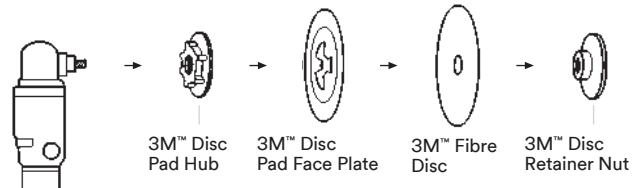
Designed to perfectly match 3M's coated and surface conditioning discs. 3M™ Gripping Material molded into tool housing for greater operator comfort. Removable side handle furnished with tool. Right angle steel gear head with grease fitting for increased gear life. Rear exhaust.



Part No.	Desc.	Motor HP	Max RPM	Weight lb (kg)	Length in (mm)	Height in (mm)	Thread	Air Inlet Thread	Units per Case
<b>28408</b>	Rotary	1	12,000	3.10 (1.4)	8.25 (209.6)	9.23 (107.4)	5/8-11 EXT	3/8" NPT*	1

\*3/8" – 1/4" air inlet reducer included with tool. For flap discs, see page 6. For discs, see page 9.

The following accessories are available to help optimize the performance of your 3M disc sander and abrasives.



## 3M™ Disc Pad Hubs

Has a threaded metal insert and can be used on most 5/8-11 shafts.

Part No.	Size	For Use With	Unit	Units per Case
<b>45205</b>	2-1/2" x 5/8-11 INT	All 4"-9" face plates	Each	10
<b>45190</b>	4-1/2" x 5/8-11 INT	7", 8" and 9" face plates		



## 3M™ Disc Pad Face Plates — Ribbed

Use with 3M™ Fibre Discs and Disc Pad Hubs for heavy metal removal, large welds, etc. 3M™ Disc Pad Face Plates can be easily changed without removing the hub.

Part No.	Size	Desc.	Max RPM	Unit	Units per Case
<b>81733</b>	5"		12,000	Each	10
<b>80515</b>	7"	Hard Black	8,600		
<b>81729</b>	9"		6,600		



## 3M™ Disc Retainer Nuts

Use with 3M™ Disc Pad Face Plates, Disc Pad Hubs and Fibre Disc Holders. Has 1/4" diameter holes for use with a spanner wrench.

Part No.	Size	Unit	Units per Case
<b>02618</b>	5/16" x 5/8-11 INT	Each	10
<b>05622</b>	3/8" x 5/8-11 INT		





## 3M™ Hookit™ Sanding Blocks, Dust Free

Use with 3M™ Hookit™ Clean Sanding Sheet Rolls for sanding applications involving body filler, putty and primer. Attaches to vacuum hose for dust removal.

Part No.	Size	Inner Pack	Units per Case
05207	2-3/4" x 5"		5
05208	2-3/4" x 7-1/2"	1 Block	
05209	2-3/4" x 16"		1

For abrasive sheets, see page 3.



## 3M™ Hookit™ Sanding Blocks

Foam blocks make sanding easier in difficult locations. Comfortable and easy-to-use, these blocks can be used with 3M™ Hookit™ Clean Sanding Sheet Rolls to complete everyday repairs. The bright yellow color helps make them easy to find in dusty shop conditions.

Part No.	Size	Inner Pack	Units per Case
05685	7/8" x 1-3/8" x 10-3/4"		24
05686	1-1/2" x 2-5/8" x 5-1/4"		12
05687	1-1/2" x 2-5/8" x 10-3/4"		8
05688	1-1/2" x 2-5/8" x 16"	1 Block	
05689	Round, 1-1/4" x 10-3/4"		24
05690	5/8" x 2-1/2" x 5-3/8"		12
05691	Teardrop, 2-1/8" x 10-3/4"		

For abrasive sheets, see page 3.

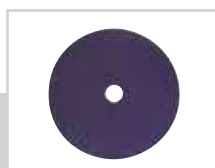


## 3M™ Hookit™ Sanding Block Kit

This kit contains the top seven most popular blocks in a blister pack shipper. These are to be used as an accessory item with our 3M™ Hookit™ Abrasives for sanding filler, primer and other substrates.

Part No.	Description	Inner Pack	Units per Case
05684	<p><b>Kit contains one (1) each:</b>                      05685, 7/8" x 1-3/8" x 10-3/4"                      05686, 1-1/2" x 2-5/8" x 5-1/4"                      05687, 1-1/2" x 2-5/8" x 10-3/4"                      05689, Round, 1-1/4" x 10-3/4"                      05691, Teardrop, 2-1/8" x 10-3/4"</p> <p><b>Kit contains two (2) each:</b>                      05690, 5/8" x 2-1/2" x 5-3/8"</p>	1 Kit	6

For abrasive sheets, see page 3.



3M™ Cubitron™ II  
Abrasive Fibre Disc  
33413



3M™ Cubitron™ II  
Clean Sanding Hookit™  
Sheet Roll 34445



3M™ Impact Resistant  
Structural Adhesive  
07333



3M™ Bare-Metal  
Seam Sealer 08310

## Related Products

# Body Fillers and Glazes

## 3M™ Platinum™ Select Filler

3M™ Platinum™ Select Filler is a premium body filler that offers fast surface adhesion to properly prepared aluminum, steel, galvanized steel, e-coat, fiberglass, SMC and silicone bronze MIG brazed joints. With Platinum Select filler's fine surface, it reduces the amount of primer used to cover micro pinholes over traditional filler. Platinum Select filler is stain-free and is perfect for use under all basecoat/clearcoat, including water-borne. Platinum Select filler offers excellent corrosion-resistant properties.

Part No.	Size	Units per Case
31131	1 Gallon	4
31130	3 Gallon	1
31128	5 Gallon	1



## 3M™ Platinum™ Plus Body Filler

3M™ Platinum™ Plus Body Filler is a super creamy formula that achieves extreme adhesion to properly prepared galvanized steel, aluminum, e-coat, Fiberglass, SMC, cured epoxy, urethane primers and silicon bronze MIG brazed joints. Platinum Plus filler is manufactured with only the highest quality ingredients, including our proprietary adhesion promoter.

Part No.	Description	Size	Units per Case
01131	-	1 Gallon	4
01130	-	3 Gallon	1
01132	Air Cartridge		2
31139	Air Pail with Hardener	5 Gallon	1



## 3M™ Quick Grip Filler

3M™ Quick Grip Filler reduces the time to shape and sand, and delivers rapid adhesion to multiple surfaces. Vacuum processed to reduce pinholes. Stain-free/tack-free finish helps avoid extreme loading of sandpaper. Easy to sand and bonds rapidly to galvanized steel, aluminum, e-coat, fiberglass, SMC, cured epoxy and urethane primers. Adheres to all substrates quickly and creates a great feather edge.

Part No.	Description	Size	Units per Case
33177	-	1 Quart	12
33181	-	1 Gallon	4
33183	Air Cartridge	3 Gallon	1
33185	Air Pail	5 Gallon	1





### 3M™ Platinum™ Plus Finishing Glaze

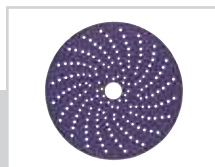
3M™ Platinum™ Plus Finishing Glaze achieves extreme adhesion to galvanized steel, aluminum, e-coat, fiberglass, SMC, cured epoxy, and urethane primers. Platinum Plus glaze cuts the sanding time to as little as 15 minutes.



Part No.	Description	Size	Units per Case
<b>31180</b>	Finishing Glaze	30 oz	6
<b>03180</b>		24 oz	
<b>03080</b>		16 oz	
<b>12011</b>	Glaze	24 oz	



3M™ Dry Guide Coat Kit 05861



3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Disc 31373



3M™ Cubitron™ II Clean Sanding Hookit™ Sheet Roll 34445



3M™ Hookit™ Sanding Block, Dust Free 05208

## Related Products



# Plastic Repair

## 3M™ Semi-Rigid Plastic Repair

Effectively repairs both one-sided and two-sided damage on a variety of automotive plastic components. This adhesive is commonly used for backside reinforcement repair, as well as general bonding. We recommend our high-performance, two-component urethane adhesive for repairing damaged bumpers and re-building tabs.

Part No.	Color	Size	Units per Case
34240	Black	50mL	6
04240		200mL	



## 3M™ EZ Sand Multi Purpose Repair Material

Two-part epoxy used to repair most flexible parts. May also be used as a seam sealer where a rounded edge seam is required. This semi-flowable material creates the perfect bead matching many OEM applications.

Part No.	Color	Size	Units per Case
35887	Grey	50mL	6
05887		200mL	

Approved  
as Seam  
Sealer



## 3M™ Super Fast Plastic Repair Adhesive

Super fast-setting adhesive which does not require a separate accelerator like cyanoacrylate adhesives. Has excellent wide gap filling capabilities and withstands a wide range of temperatures. Will not run or sag.

Part No.	Color	Size	Units per Case
04747	Clear	50mL	6
04248	Black	200mL	
04247	Clear		



# Plastic Repair Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Sand/ Handling Time	Cure Time	Features
3M™ EZ Sand Multi Purpose Repair Material	35887	50mL	Grey	Two-Part Epoxy	5 min	15 min	24 hrs	<ul style="list-style-type: none"> <li>• Use with 3M™ Polyolefin Adhesion Promoter 05907</li> <li>• Flexible for use on exterior bumper covers</li> <li>• Excellent sandability</li> </ul>
	05887	200mL						
3M™ Flexible Bumper Patch	05888	4" x 8"	Black	TPO	N/A	N/A	No cure time delay	<ul style="list-style-type: none"> <li>• Excellent adhesion properties</li> <li>• Use on plastics for additional reinforcement</li> </ul>
3M™ Super Fast Plastic Repair Adhesive	04747	50mL	Clear	Two-Part Urethane	20 sec	5 min	1 hr	<ul style="list-style-type: none"> <li>• Super-fast setting</li> <li>• Use for rebuilding tabs and fixing broken eyelets</li> <li>• Excellent gap-filling capabilities</li> <li>• Withstands wide temperature range (unlike cyanoacrylate)</li> </ul>
	04248	200mL	Black					
	04247		Clear					
3M™ Semi-Rigid Plastic Repair	34240	50mL	Black	Two-Part Urethane	50 sec	15 min	1 hr	<ul style="list-style-type: none"> <li>• Very rigid material</li> <li>• Use to reinforce backside</li> </ul>
	04240	200mL						
3M™ Semi-Rigid Parts Repair – 1	08235	200mL	Black	Two-Part Urethane	50 sec	30 min	1 hr	<ul style="list-style-type: none"> <li>• Reinforcement strips, patch bonding, small bonding apps</li> <li>• Fix Xenoy, RRIM, GTX, PPO, ABS and other semi-rigid plastics and bumper covers</li> </ul>
3M™ Semi-Rigid Parts Repair – 3	08237				3 min		4 hrs	

## Did You Know?

- Using 3M™ Super Fast Plastic Repair Adhesive on the front side of a flexible patch repair before skim coating with 3M™ EZ Sand Multi Purpose Repair Material 05887 adds strength and rigidity thus expanding the utility of the flexible repair patch.
- 3M plastic repair products use both urethane and epoxy technology to provide strength, flexibility and excellent sanding qualities.
- When unknown plastics require special attention due to adhesion issues 3M™ Panel Bonding Adhesive 08115 can be an excellent repair solution.
- When repairing semi rigid reinforced plastics such as RIM (reinforced injection molded) you use the same method and 3M plastic repair products as with flexible plastic such a PP (polypropylene) or TPO (thermoplastic polyolefin).



3M™ Reinforcement Patch 04904



3M™ Plastic Contour Sheet 04903



3M™ Polyolefin Adhesion Promoter 05907



3M™ Cubitron™ II Clean Sanding Hookit™ Sheet Roll 34445

## Related Products

# Adhesives

## 3M™ Panel Bonding Adhesive

Designed to meet specific strength requirements for outer sheet metal panel replacement; panel bonding adhesive is typically used in conjunction with welding, rivets or hem flange joints. Panel bonding adhesives do not offer the same level of impact resistance as impact resistant structural adhesives and should not be used for structural repairs unless recommended by the specific automotive manufacturer.



Part No.	Color	Size	Units per Case
38315		50mL	
08115	Black		6
08116		200mL	

## 3M™ Impact Resistant Structural Adhesive

Designed to meet specific strength requirements for parts such as frame rails, strut towers, rocker panels, pillars and other members where impact resistance is important. This type of adhesive possesses a much greater ability than traditional bonding adhesives to absorb and manage energy under a variety of forces, especially peel and cleavage stresses in extreme temperature conditions. Typically impact resistant structural adhesive is used in conjunction with rivets, spot welds or mechanical fasteners.

Part No.	Color	Size	Units per Case
07333	Dispenses Silver, Cures Purple	200mL	3



**Color Change Feature**  
Curing process has begun, as indicated by silver to purple color change (30 min at 175°F)

## 3M™ Composite and Metal Bonding Adhesive

Approved for bonding door skins. Two-part urethane adhesive that is used to bond SMC and FRP (traditional fiberglass) body panels to each other and to metal. This product is a fast drying product with a 35 minute worktime. It is designed to bond composite and metal to each other, along with metal to metal applications.

**Approved for Direct to Bare Metal**



Part No.	Color	Size	Units per Case
08219	Green	200mL	6



# Adhesives Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Clamp/ Handling Time	Cure Time
3M™ Panel Bonding Adhesive (Direct to Metal Bonder)	38315	50mL	Black	Epoxy	90 min @ 70°F* 45 min @ 90°F*	4 hrs*	24 hrs
	08115	200mL					
	08116	200mL	Black	Epoxy	2 hrs @ 70°F* 1 hr @ 90°F*	6 hrs*	24 hrs
3M™ Impact Resistant Structural Adhesive	07333	200mL	Disp. Silver, Cures Purple	Epoxy	60 min	8 hrs*	24 hrs
3M™ Composite and Metal Bonding Adhesive – 35 (Direct to Metal Bonder)	08219	200mL	Green	Urethane	35 min	90 min	3 hrs
3M™ Quick Fix Adhesive Kit with Accelerator	08224	0.7 oz Adhesive/ 2 oz Accelerator	Clear	Cyano- acrylate	1 min	2 min	1 hr
3M™ Universal Adhesive	08107	50mL	Clear	Epoxy	3 min	30 min	1 hr
	08217	200mL					
	08223	200mL	Black	Urethane	3 min	30 min	4 hrs
	08214	200mL	Black	Urethane	10 min	1 hr	4 hrs
3M™ Channel Bonding and Sidelite Adhesive	08641	50mL	Black	Epoxy	5 min	1 hr	24 hrs

\*May be accelerated with heat.

## OEM Recommendations

Product Name	Part No.	Fiat/ Chrysler	Ford	General Motors	Honda	Hyundai/ Kia	Jaguar/ Land Rover	Tesla	Toyota	Volvo
3M™ Panel Bonding Adhesive	08115		✓		✓	✓			✓	
	08116	✓		✓						✓
3M™ Impact Resistant Structural Adhesive	07333			✓	✓	✓	✓	✓		

**Please reference OEM Repair Procedures:** Collision repair shops should follow OEM recommendations. Always reference the OEM repair procedure to make sure the correct adhesive is being selected for that repair.

## Did You Know?

- Many OEMs recommend 3M™ Panel Bonding Adhesive and 3M™ Impact Resistant Structural Adhesive for weld bonding and rivet bonding repairs.
- 3M™ Composite and Metal Bonding Adhesive 08219 has a 35 minute working time and can be unclamped and handled in as little as 2 hours at 70°F, making it perfect for door skin replacements.
- 3M™ Impact Resistant Structural Adhesive 07333 is optimized to duplicate collision energy management pathways and energy absorption.
- 3M™ Panel Bonding Adhesive 08115 works very well to repair many plastic substrates without the application of adhesion promoter.
- 3M™ Panel Bonding Adhesive 08115 can be “heat set” in as little as 15 minutes to handling strength.



3M™ Shop Rack  
02530



3M™ Static Mixing  
Nozzles 08193



3M™ Performance  
Pneumatic Applicator  
09930



3M™ Cubitron™ II  
Cut-Off Wheel  
33456

## Related Products

# Two-Part Seam Sealers

## 3M™ EZ Sand Multi Purpose Repair Material

Two-part epoxy used to repair most flexible parts. May also be used as a seam sealer where a rounded edge seam is required. This semi-flowable material creates the perfect bead matching many OEM applications.

Approved as Seam Sealer



Part No.	Color	Size	Units per Case
05887	Grey	200mL	6

## 3M™ Bare-Metal Seam Sealer

Two-part epoxy with superior corrosion protection for use on vertical or horizontal bare metal seams. Heavy-bodied, non-sagging, non-flowing and easy tooling. Formulated for matching OEM seam sealer appearances.

Part No.	Color	Size	Units per Case
08310	Beige	200mL	6



3M™ Bare-Metal Seam Sealer may be tooled using a brush or skiving tool to permanently seal seams prior to primer application, saving time and duplication of work in your paint shop.

## 3M™ Heavy-Bodied Seam Sealer

Two-part seam sealer for all general purpose automotive sealing needs. Cures quickly to a tough, strong bead for lasting seam sealing protection. This includes door skins, floor pans, trunk floors, roof seams and many other applications.

Part No.	Color	Size	Units per Case
08308	Black	200mL	6



# Two-Part Seam Sealers Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Paint Time	Features
3M™ EZ Sand Multi Purpose Repair Material	05887	200mL	Grey	Two-Part Epoxy	5 min	15 min	<ul style="list-style-type: none"> <li>• Must be applied over primer</li> <li>• Provides great rounded edges</li> <li>• Match OEM seams, sandable, semi flowable, flexible</li> </ul>
	35887	50mL					
3M™ Bare-Metal Seam Sealer	08310	200mL	Beige	Two-Part Epoxy	8 min	15 min	<ul style="list-style-type: none"> <li>• Apply directly over bare or primed metal</li> <li>• Heavy-bodied seam sealer</li> <li>• Use on vertical or horizontal seams to match OEM seams</li> </ul>
3M™ Heavy-Bodied Seam Sealer	08308	200mL	Black	Two-Part Epoxy	6 min	15 min	<ul style="list-style-type: none"> <li>• Heavy-bodied, non-sagging, non-flowing seam sealer</li> <li>• Match OEM seams on floor pans, door skins, truck beds</li> <li>• Use for cosmetic seams</li> </ul>
3M™ Self-Leveling Seam Sealer	08307	200mL	Clear	Two-Part Epoxy	6 min	15 min	<ul style="list-style-type: none"> <li>• Match OEM seams on roof ditches and rear body panels</li> </ul>
3M™ Factory Match Seam Sealer	08323	200mL	Black	Two-Part Urethane	10 min	45 min	<ul style="list-style-type: none"> <li>• Flows slightly, softens on edges without tooling (rounded appearance)</li> <li>• Use to duplicate factory door skin seams</li> </ul>
3M™ Controlled Flow Seam Sealer	08329	200mL	Black	Two-Part Urethane	3 min	40 min	<ul style="list-style-type: none"> <li>• Flexible for sealing channels and seams</li> <li>• Excellent for sloped areas</li> <li>• Will run approximately 1-1/2 to 2" when applied at a 45 degree angle</li> </ul>

## Did You Know?

- When “equalizing” low viscosity two-part sealers and adhesives you should always position them upright for a few minutes and “equalize” in an upright orientation dispensing material through the mixing nozzle to avoid air bubbles and maintain proper equalization. CAUTION: During equalization point the nozzle away from any person or body parts to avoid accidental exposure.
- The use of aerosol type single component primer is not recommended under 3M seam sealer. **Always use a two component urethane or epoxy primer in direct contact with the seam sealer.**
- 3M™ EZ Sand Multi Purpose Repair Material 05887 works very well as a roof ditch sealer.
- 3M two-part seam sealers may be “tooled” or removed using a VOC Compliant Adhesive Remover without affecting the cure property of the sealers.
- 3M two-part seam sealers can be used to make sealer bead replicas off the vehicle and then attached to the vehicle after curing by using the same material they have been formed with.



3M™ OEM Seam Sealer Tips  
08201-05



3M™ Static Mixing Nozzles 08193



3M™ Performance Pneumatic Applicator 09930



3M™ Cubitron™ II File Belt 33437

## Related Products



# One-Part Seam Sealers

Approved  
for Direct to  
Bare Metal

## 3M™ Urethane and MSP Seam Sealers

A high performance seam sealer ideal for sealing interior and exterior automotive and RV seams and joints. Adheres well to properly prepared bare metal, primer and e-coat surfaces. May be welded through using STRSW equipment. Can be smoothed to a featheredge and/or brushed. Reduces the risk of re-dos associated with the use of solvent-based seam sealers.

- High solids, single-component, moisture-curing
- Non-shrinking and non-cracking
- Low odor
- Able to fill large voids
- Tack-free and paintable
- May be used in direct to bare metal and aluminum applications

Part No.	Color	Size	Units per Case
Urethane Cartridges			
08362	Grey	310mL	12
08365	Beige		
08367	Black		
08368	White		

Part No.	Color	Size	Units per Case
Urethane Foil Packs			
08360	White	310mL	6
08361	Grey		
08364	Beige		

Part No.	Color	Size	Units per Case
MSP Flex Packs			
08369	White	310mL	6
08370	Grey		



## Related Products



3M™ Threaded  
Cartridge Nozzle  
08187



3M™ Flex Pack  
Nozzle 08188



3M™ Single Component  
Cartridge Pneumatic  
Applicator 08990



3M™ Flexible  
Package Applicator  
08398

# One-Part Seam Sealers Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Paint Time	Features
3M™ Urethane Seam Sealer Direct to Metal Applications	08362	310mL	Grey	One-Part Urethane	5–10 min*	30 min for solvent-based; 45 min for water base	<ul style="list-style-type: none"> <li>• Apply directly over bare or primed metal</li> <li>• Non-shrinking, non-cracking</li> <li>• Fills large voids</li> </ul>
	08365		Beige				
	08367		Black				
	08368		White				
3M™ One-Part Seam Sealer (Foil Pack) Direct to Metal Applications	08360	310mL	White	One-Part Urethane	5–10 min*	30 min for solvent-based; 45 min for water base	<ul style="list-style-type: none"> <li>• Apply directly over bare or primed metal</li> <li>• Non-shrinking, non-cracking</li> <li>• Fills large voids</li> </ul>
	08361		Grey				
	08364		Beige				
3M™ MSP Seam Sealer (Flex Pack) Direct to Metal Applications	08369	310mL	White	MSP	5–10 min*	Immediate for solvent-based; 30 min for water base	<ul style="list-style-type: none"> <li>• Apply directly over bare or primed metal</li> <li>• High-quality, heavy bodied, general purpose, moisture-curing seam sealer</li> <li>• Use for interior and exterior body joints</li> <li>• May be primed or painted immediately or up to 72 hours</li> <li>• Not for use on lacquer paints</li> </ul>
	08370		Grey				
3M™ MSP Sprayable Seam Sealer (Cartridge)	08374	310mL	Grey	MSP	5–10 min*	Immediate for solvent-based; 30 min for water base	<ul style="list-style-type: none"> <li>• High-performance, non-shrinking, non-cracking, general purpose seam sealer that can be caulked</li> <li>• Use on door skins, hemming flanges, quarter panels and floor and truck pans</li> </ul>

\*Varies based on temperature and humidity.

## Did You Know?

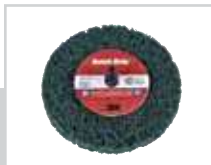
- Caulk grade 3M™ Urethane and MSP Seam Sealers can be used to replicate OEM liquid applied sound deadener applications.
- You can weld through uncured caulk grade 3M Urethane and MSP Seam Sealers using squeeze type resistance spot welding to form a weld sealed joint.
- When using 3M™ Flexible Package Pneumatic Applicator 08990 the best operating pressure is 20 to 25 PSI. Be sure to regulate the inlet pressure for best results.
- Due to the flexibility of caulk grade 3M Urethane and MSP Seam Sealers it is best to apply minimal amounts of primer over seam sealer. If heavy primer surfacer is required be sure to add flex agent to the primer to prevent paint film cracking due to body deflection.
- Many different appearances of seam sealer can be obtained using a pneumatic applicator and some simple techniques to match OEM appearance.



3M™ Flexible Package Pneumatic Applicator 08399



3M™ Cubitron™ II File Belt 33437



Scotch-Brite™ Roloc™+ Clean and Strip XT Pro Extra Cut Disc 21544



3M™ Cubitron™ II Fibre Roloc™ Disc 33389

## Related Products

# Sound Deadening

## 3M™ Sound Deadening Pad

Conformable, self-adhesive sheets that can be easily custom cut and applied to vehicle floor pans, engine compartments, hoods, deck lids, inside doors and on body panels. These sound deadening pads work to suppress noise and vibration in panels.

- Feature an OEM-matching diamond emboss
- Self adhesive and paintable
- Center perforation for easy door panel installation
- May be used in direct metal to aluminum applications



Part No.	Color	Size	Units per Case
08840	Black	19" x 19" 500mm x 500mm	10



3M™ Sound Deadening Pads may be applied to vehicle floor pans, engine compartments, spare tire compartments, hoods, deck lids, inside doors and on body panels.



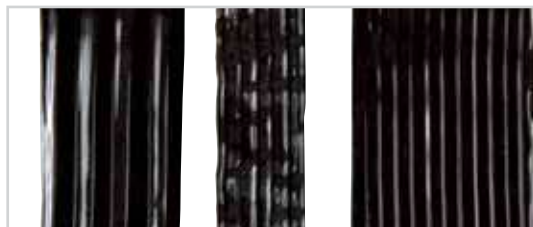
Diamond Pattern

## 3M™ NVH Dampening Material (Noise, Vibration, Harshness)

A flexible adhesive-type material used to reduce noise and vibration between panels where a long work time is required. Can be applied between roof skins and roof bows, door skins and door intrusion beams or other areas using non-structural type foam materials, providing up to 1" thick layer of flexible material on vertical and overhead applications. It can also be applied over existing dampening material as long as the original material is still integrally bonded.

- Can be used for large installations
- Remains very soft, yet sturdy and will not degrade
- 60 minute work time
- Can be applied to a thickness of 1" on vertical and overhead surfaces

Part No.	Color	Size	Units per Case
04274	Black	200mL	6



**Troweled LASD**  
Trunk Floors,  
Floors, Inner 1/4  
Panels



# Sound Deadening Guide

Product Name	Part No.	Size	Color	Chemistry	Work Time	Cure Time	Features
3M™ Sound Deadening Pad	08840	19" x 19" (500mm x 500mm)	Black	Pad	N/A	N/A	<ul style="list-style-type: none"> <li>• Conformable, self adhesive backing to be applied in floor pans, hood deck lids, etc.</li> <li>• OEM matching diamond pattern</li> <li>• Paintable</li> </ul>
3M™ NVH Dampening Material (Noise, Vibration, Harshness)	04274	200mL	Black	Two-Part Urethane	60 min	24 hrs	<ul style="list-style-type: none"> <li>• Ideal two-part urethane for replacing factory NVH sealants and foams</li> <li>• Remains pliable, yet sturdy and will not degrade</li> <li>• Does not expand</li> </ul>
3M™ Flexible Foam	08463	200mL	Grey	Urethane	40 sec	1 hr	<ul style="list-style-type: none"> <li>• Stays flexible, fills and bonds</li> <li>• Use to replace flexible foams in OEM applications such as trunks, door cavities, door skins and roof beams</li> <li>• Works well for quarter panel applications or wherever flexible factory foam is found</li> </ul>
3M™ Rigid Pillar Foam	08458	200mL	Tan	Urethane	1 min	1 hr	<ul style="list-style-type: none"> <li>• Rigid foam, fills and bonds</li> <li>• Foams in place to fill posts, pillars and automotive body cavities</li> <li>• Use for OEM replacement of rigid foams</li> </ul>

## Did You Know?

- You can weld through uncured 3M™ NVH Dampening Material 04274 using squeeze type resistance spot welding equipment.
- You should never compress the replacement 3M NVH Dampening Material between a door skin and door intrusion beam by allowing the weight of the door to rest on the replacement panel during the curing process as this may form “low spots” in the door skin. Allow the 3M NVH Dampening Material to cure in an unrestrained condition.
- 3M NVH Dampening Material 04274 is a two-part urethane offering 60 minutes of open time and is perfect for applications between roof bows, van side reinforcements and intrusion beams.
- It is best to keep as much of the OEM foam in place as possible when replacing body panels and to “butter” the OEM foam with 3M NVH Dampening Material or 3M™ Urethane Seam Sealer to prevent open cells in the foam from absorbing water.
- 3M™ Heavy-Bodied Seam Sealer 08308 or 58308 can be applied to the 3M™ Sound Deadening Pad 08840 and tooled to customize the appearance of the patch.



3M™ Shop Rack  
02530



3M™ Standard Manual  
Cartridge Applicator  
08571



3M™ Static Mixing  
Nozzles 08193



3M™ Performance  
Pneumatic Applicator  
09930

## Related Products

# Coatings

## 3M™ Cavity Wax Plus

All OEMs recommend the application of internal anti-corrosion material during body repair, which includes cavity wax. 3M™ Cavity Wax Plus is a non-hardening, self-healing corrosion protection coating for internal auto body panels and structural enclosures, as well as new replacement parts.

- Corrosion protection for internal body panels, frame rails and structural enclosures.
- Non-hardening material remains soft and pliable — will not crack, chip or peel.
- Use with 3M™ Cavity Wax Plus Applicator Wand Kit (sold separately) to ensure 360° coverage in closed cavities.

Part No.	Description	Size	Units per Case
08852	Anti-Corrosion Spray	18 oz aerosol	4
08851	Applicator Wand Kit	8", 24" and 34" wands	-



Without corrosion protection treatment



3M™ Cavity Wax Plus 08852 (3 coats)

### Tested for long-term corrosion protection.

Actual test panel results after 1,500 hour salt fog exposure (ASTM B117-97\*).



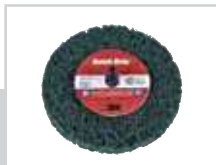


### 3M™ Weld-Thru Coating II

A sprayable, weldable, corrosion-resistant coating designed to prevent corrosion from forming between two welded metal surfaces. When applied to metal surfaces prior to welding 3M™ Weld-Thru Coating II provides corrosion protection after welding. Additionally, this product can be used to prevent corrosion on metal surfaces that will not be receiving any further treatment like body filler, primer and paint. Dries fast with minimum spatter and meets CARB aerosol coating requirements.



Part No.	Application	Color	Size	Units per Case
05917	Surface Coating	Gray	12.75 oz aerosol	6



Scotch-Brite™ Roloc™+  
Clean and Strip XT Pro  
Extra Cut Disc 21544



3M™ Cubitron™ II  
File Belt 33437



3M™ NVH  
Dampening Material  
04274



3M™ Panel Bonding  
Adhesive 08115

## Related Products

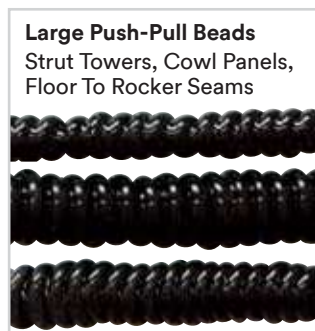


# Mixing and Delivery

## 3M™ Dynamic Mixing System (DMS)

Automatically mix and dispense the perfect amount of adhesives, sealers and body filler products. Designed to maximize productivity, reduce waste and increase profit potential.

Part No.	Description	Size	Units per Case
<b>Fillers and Glazes</b>			
05877	<b>3M™ Reinforced Body Filler for DMS</b> Milled fiberglass reinforced polyester filler that can create water resistant repairs to holes and rust in a two-component cartridge. More than twice the strength of ordinary body fillers. Can be used in conjunction with fiberglass tape, cloth or mat to repair and rebuild fiberglass materials.		
05863	<b>3M™ Platinum™ Plus Body Filler for DMS</b> Cartridge-based, two-component body repair material. Super creamy formula that achieves extreme adhesion to galvanized steel, aluminum, e-coat, fiberglass, SMC, cured epoxy, urethane and primers.		
05221	<b>3M™ All Purpose Fast Cure Filler for DMS</b> Helps increase productivity, increase profits and reduce waste, while ensuring the body repair quality you've come to expect from DMS. By mixing two-component product directly in the nozzle, the applicator quickly and easily delivers filler mixed to the perfect ratio every time.		
05859	<b>3M™ Dent Filling Compound Body Filler for DMS, 95 degrees</b> Warm weather filler in cartridge-based two-component body repair material. Ideal for large panel repairs.	276mL	6
05862	<b>3M™ Platinum™ Glaze for DMS</b> A premium cartridge-based, two-component, self-leveling glaze designed for use as a "skin" coat over sheet metal and dent repair compound.		
05857	<b>3M™ Dent Finishing Glaze for DMS</b> Cartridge-based, two-component, self-leveling glaze designed for use as a "skin" coat over sheet metal and dent repair compound.		
35863	<b>3M™ Platinum™ Select Filler for DMS</b> Designed to increase productivity in the body man process by reducing pinholes by up to 99%. Decreases primer usage by up to 30%, based on its creamy formulation that will spread, cure and sand as one of the best body fillers that 3M offers.		
<b>Bonding Adhesives, Sealers and Coatings</b>			
58115	<b>3M™ Panel Bonding Adhesive for DMS</b> Two-part epoxy used to bond steel, aluminum, SMC and FRP (traditional fiberglass). Use to replace quarter panels, roofs, box sides, van sides, utility vehicle sides and door skins.		4
57333	<b>3M™ Impact Resistant Structural Adhesive for DMS</b> Two-part epoxy adhesive which provides an extended work time, but can be rapidly cured with heat. Excellent adhesion to a wide variety of properly prepared automotive substrates including steel and aluminum. Intended for true structural bonding applications when specified by automotive OEMs, and is recommended for all weld-bonded and rivet-bonded joints.	450mL	2
58308	<b>3M™ Heavy-Bodied Seam Sealer for DMS</b> Two-part epoxy for use in vertical or horizontal seams to match OEM sealers. Non-sagging, non-flowing and easy to tool. Paintable in 30 minutes, 10 minute worktime. No shrinkage or cracking.		
58310	<b>3M™ Bare-Metal Seam Sealer for DMS</b> Two-part epoxy with corrosion inhibitors for use on vertical or horizontal bare metal seams. Heavy-bodied, non-sagging, non-flowing and easy tooling formulation for matching OEM seam sealer appearances. Paintable in 15 minutes, 8 minute worktime. No shrinkage or cracking.	600mL	4
55887	<b>3M™ EZ Sand Multi Purpose Flexible Repair Material for DMS</b> Two-part epoxy used to repair most flexible plastic parts, bumper covers and plastic body panels. This product should NOT be used with SMC/fiberglass. Easy sanding, formulated for excellent featheredge.		
55885	<b>3M™ Rigid Parts Repair Adhesive for DMS</b> Two-part epoxy used to repair SMC, FRP (traditional fiberglass) and other rigid plastic parts. Designed for use as filler and adhesive. Epoxy-based for easy sanding and is formulated for excellent featheredge.		



# Standard Operating Procedures (SOPs)

## Process for Success

From metal and plastic repair, to sanding, paint finishing and car clean-up, 3M has the products and repair processes for you. Feel confident your repair is done professionally and efficiently by using our Standard Operating Procedures. These procedures will help you consistently produce quality, time-proven solutions for any of your collision repair needs, including:

- Aluminum Repair
- Body Repair
- Bumper Repair
- Sealers and Coatings
- Paint Finishing and Detailing
- Masking
- Paint Preparation
- Painting
- Windshield Repairs
- Respirator Fit Testing
- Heavy Duty Trucks



## Standard Operating Procedures

for Collision Repair

3M Automotive Aftermarket Division  
May 2016

2		3M™ Super Glue Part No. 1000 Part No. 1001
3		3M™ Super Glue Part No. 1000 Part No. 1001
4		3M™ Glass Cleaner Part No. 1000
5		3M™ Glass Primer Part No. 1000
6		3M™ Super Glue Part No. 1000 Part No. 1001
7		3M™ Super Glue Part No. 1000 Part No. 1001
8		3M™ Super Glue Part No. 1000 Part No. 1001

Think About Your Health

2		3M™ Flap Wheel Part No. 1000 Part No. 1001
3		3M™ Flap Wheel Part No. 1000 Part No. 1001
4		3M™ Flap Wheel Part No. 1000 Part No. 1001
5		3M™ Polyflex Adhesive Primer Part No. 1000 3M™ Polyflex Adhesive Filler Part No. 1001
6		3M™ Flap Wheel Part No. 1000 Part No. 1001
7		3M™ Flap Wheel Part No. 1000 Part No. 1001

Think About Your Health

### Standard Operating Procedures Bumper Repair











<b>Prepared Area</b>	<b>Product List</b>
3M™ Primer Coat Part No. 1000 Part No. 1001	3M™ Primer Coat Part No. 1000 Part No. 1001
3M™ Primer Coat Part No. 1000 Part No. 1001	3M™ Primer Coat Part No. 1000 Part No. 1001
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### Standard Operating Procedures Paint Finishing and Detailing

<b>Paint Finish Denibbing Process</b>	<b>Product List</b>
1	3M™ Fine Defect Removal Part No. 1000 Part No. 1001
2	3M™ Flap Wheel Part No. 1000 Part No. 1001
3	3M™ Compound Part No. 1000 Part No. 1001
4	3M™ Flap Wheel Part No. 1000 Part No. 1001
5	3M™ Flap Wheel Part No. 1000 Part No. 1001
6	3M™ Clear Coat Part No. 1000 Part No. 1001





Think About Your Health

# Accessories

Accessories	Part No.	Size	Features/Applications
 3M™ Flex Pack Nozzle	08188	310mL	For use with one-part flex pack seam sealers
 3M™ Dynamic Mixing Nozzles	05847	50:1	DMS nozzle for filler and related products
	55847	2:1, 1:1	DMS nozzle for adhesives, sealers and plastic repair products
 3M™ Dynamic Mixing Nozzle Extension	58207	50:1, 2:1, 1:1	Use with DMS nozzles to provide a thinner bead and to get into hard to reach areas
 3M™ Static Mixing Nozzle	08193	200mL, 400mL	3/8 in nozzle for all 200mL and 400mL products; 08194 — bulk pack (50)
	08194		
 3M™ OEM Seam Sealer Tips	08201	200mL, 400mL	Versatile assortment of five different tips that reproduce many OEM seam sealer beads used today; saves time, labor and costly re-dos while trying to reproduce the factory OEM seams
	08202		
	08203		
	08204		
	08205		
 3M™ OEM Seam Sealer Tip Adapter	08206	310mL	Use with Urethane Seam Sealers and MSP Seam Sealers
 3M™ Bulk Nozzle Rack	02576	200mL	Use to hold and store boxes of 08194, 08187, 05847 and 55847
 3M™ Threaded Cartridge Nozzle	08187	310mL	50 Threaded cartridge nozzles to use with single component cartridges
 3M™ Polyolefin Adhesion Promoter	05907	12 oz Aerosol	Provides excellent adhesion of filler materials to TPO type substrates (Type II); compatible with all 3M Flexible, Semi-Rigid and TPO repair products
 3M™ Shop Rack	02530	200mL, 400mL	Shop rack for all 200 and 400mL syringes — Holds 8 open or closed syringes and 2 applicator guns



# Accessories

Accessories	Part No.	Size	Features/Applications
 3M™ Plastic Contour Sheet	04903	5" x 12'	Contour sheet to be used while creating new plastic tabs
 3M™ Reinforcement Patch	04904	5" x 12'	Use for reinforcing the backside of plastic repairs
 Dynatron™ Fiberglass Mat	688	8 sq ft	Use with 3M™ Fiberglass Resin 05833 or 3M™ Short Strand Fiberglass Reinforced Filler 05815 or 05816 to patch larger holes in metal, cracks, tears, punctures and splits in fiberglass panels
 Dynatron™ Fiberglass Cloth	699	8 sq ft	For reinforcing fiberglass and metal repairs; excellent for large repairs where extra reinforcement is needed

# Applicators

Applicators	Part No.	Size	Features/Applications
 3M™ Dynamic Mixing Applicator	05846	All DMS Products	Professional pneumatic applicator to dispense DMS products
 3M™ Performance Pneumatic Applicator	09930	200mL	Pneumatic — For 200mL product
 3M™ Performance Manual Applicator	08117	200mL	Manual — For 200mL product
 3M™ Standard Manual Cartridge Applicator	08571	200mL	Economy Line Applicator with heavy duty construction
 3M™ Performance Manual Applicator	08190	50mL	Manual applicator designed to use 1:1 and 2:1 50mL products
 3M™ Flexible Package Pneumatic Applicator	08399	310mL	Fully enclosed and pneumatic designed for smooth application of 310mL foil pack seam sealers
 3M™ Flexible Package Applicator	08398	310mL	A fully enclosed, all metal, rod driven, friction feed applicator gun for use with all 310mL or smaller foil flexible packages
 3M™ Single Component Cartridge Pneumatic Applicator	08990	310mL	Designed for smooth application of 310mL seam sealers

# 3M™ Safety Products for the Body Tech

Protecting technicians' health helps protect the whole business — when they aren't working, productivity and profitability goes down. 3M's expanded safety solution portfolio can help you protect workers: A collision repair shop's most valuable resource!

## 3M™ Pistonz™ Coded Earplug

Coded, push-to-fit earplugs are stylish hearing protection that feature soft foam tips with a silver metallic look and a convenient thumb-grip stem. No-roll foam makes insertion easy; simply push the earplug into the ear canal and twist to adjust the fit.



Part No.	Size	NRR*	Pairs per Box	Boxes per Case
093045- <b>93402</b>	Standard Size	29 dB	100	4

## 3M™ PELTOR™ Optime™ 95 Behind-the-Head Earmuffs

Features low-profile earcups that fit well with most helmets, eyewear and other safety equipment. Ultra light with soft, comfortable cushions.



Part No.	Size	NRR*	Case Inner Pack	Each per Case
093045- <b>08062</b>	Standard Size	21 dB	1	10

## 3M™ Particulate Welding Respirator, N95

Designed to help provide comfortable, reliable protection for applications such as welding, soldering, cutting, grinding and sanding. Features the 3M™ Cool Flow™ Exhalation Valve, adjustable M-noseclip and braided headband to help provide a custom and secure seal.



Part No.	Size	Each per Box	Boxes per Case
051131- <b>07189</b>	Standard Size	10	8

\*3M strongly recommends fit testing of hearing protectors. Research suggests that many users will receive less noise reduction than indicated by the NRR due to variation in earmuff fit, earmuff fitting skill and motivation of the user. If the NRR is used to estimate typical workplace protection, 3M recommends that the NRR be reduced by 50% or in accordance with applicable regulations.

### 3M™ Half Facepiece Respirator Packout with 3M™ Particulate Filters, P100

Designed for the technician who is working in applications where a respirator is required to help protect against potential exposure to grinding dust and welding fumes. The replaceable P100 filter (07184) contains a layer of activated charcoal affording a nuisance level\* of relief from organic vapors in applications such as undercoating and welding fume when the potential of ozone exposure exists. Low maintenance respirator design allows the filters to be replaced and the facepiece to be maintained and reused.



Part No.	Size	Filter	Case Inner Pack	Each per Case
051131-07181	Small	07184/2097, P100	1	20
051131-07182	Medium			
051131-07183	Large			



\*Concentrations not exceeding OSHA PEL, or applicable government exposure limits, whichever is lower.

### 3M™ H8A Headgear/WP96 Faceshield

A combination headgear and faceshield safety system. Includes H8A ratchet headgear and WP96 polycarbonate faceshield. Adjustable ratchet suspension. Molded faceshield provides impact protection from small particles. Meets the requirements of ANSI Z87.1-2010 for limited impact. Requires protective eyewear, sold separately.



Part No.	Size	Case Inner Pack	Each per Case
82783-00000	Standard Size	1	5

### 3M™ Virtua™ Protective Eyewear

Lightweight, unisex protective eyewear combines versatility and value with high wraparound coverage, polycarbonate construction and a hard coat, scratch-resistant lens for a comfortable, contoured fit. Meets the requirements of ANSI Z87.1-2010 for limited impact.



Part No.	Size	Color	Case Inner Pack	Each per Case
11326-00000	Standard Size	Clear frame, clear lens	1	20

#### ⚠ WARNING: HEARING PROTECTION

These hearing protectors help reduce exposure to hazardous noise and other loud sounds. **Misuse or failure to wear hearing protectors at all times that you are exposed to noise may result in hearing loss or injury.** For correct use, consult supervisor and the products *User Instructions*, or call 3M Technical Service in the U.S.A. If there is any drainage from your ear or you have an ear infection, consult with your physician before wearing ear plugs. Failure to do so may result in hearing loss or injury.

#### ⚠ WARNING: RESPIRATORS

These respirators help protect against certain airborne contaminants. Before use, the wearer must read and understand the *User Instructions* provided as a part of the product packaging. A written respiratory protection program must be implemented meeting all the requirements of OSHA 29 CFR 1910.134 including training, fit testing and medical evaluation. In Canada, CSA standards Z94.4 requirements must be met and/or requirements of the applicable jurisdiction, as appropriate. **Misuse may result in sickness or death.**



#### ⚠ WARNING: PROTECTIVE EYEWEAR

These eye and face protection products help provide limited eye and face protection. **Misuse or failure to follow warnings and instructions may result in serious potential injury, including blindness or death.** For correct use, selection, and applications against flying particles, optical radiation and/or splash consult supervisor, and the products *User Instructions* and WARNINGS on the package, or call 3M Technical Service.



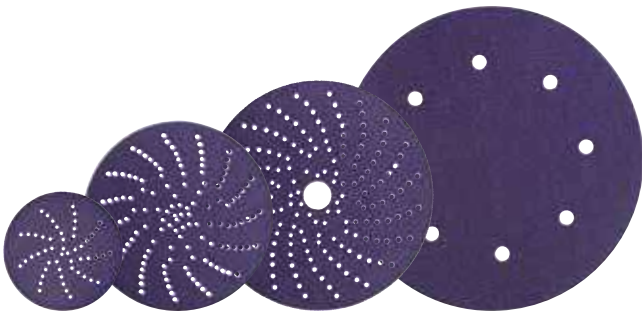


**CUBITRON™ II**

Abrasives

# Part Number Reference

## 3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive Discs



Part No.	Size	Grade	Case Qty.
31361	3"	80+	50 Discs/Box 4 Boxes/Case
31362		120+	
31363		150+	
31364		180+	
31461		220+	
31462		240+	
31463	320+		
31366	5"	80+	50 Discs/Box 4 Boxes/Case
31367		120+	
31368		150+	
31369		180+	
31471		220+	
31472		240+	
31473	320+		
31370	6"	40+	25 Discs/Box 4 Boxes/Case
31371		80+	50 Discs/Box 4 Boxes/Case
31372		120+	
31373		150+	
31374		180+	
31481		220+	
31482	240+		
31483	320+		
31375	8"	40+	25 Discs/Box 4 Boxes/Case
31376		80+	

## 3M™ Cubitron™ II Hookit™ File Sheets



Part No.	Size	Grade	Case Qty.
34490	2-3/4" x 16-1/2"	40+	25 Sheets/Box 4 Boxes/Case
34492		80+	
34494		120+	
34495		150+	50 Sheets/Box 4 Boxes/Case
34496		180+	
34497		220+	

## 3M™ Cubitron™ II Clean Sanding Hookit™ Sheet Rolls



Part No.	Size	Grade	Case Qty.
34440	2-3/4" x 8.75 yd	40+	1 Roll/Box 5 Boxes/Case
34442	2-3/4" x 13 yd	80+	
34444		120+	
34445		150+	
34446		180+	
34447		220+	
34448		240+	
34449	320+		

## 3M™ Cubitron™ II Fibre Roloc™ Discs



Part No.	Size	Grade	Case Qty.
33377	2"	36+	15 Discs/Box 6 Boxes/Case
33379		60+	
33380		80+	
33389	3"	36+	15 Discs/Box 6 Boxes/Case
33391		60+	
33392		80+	

## 3M™ Cubitron™ II File Belts



Part No.	Size	Grade	Case Qty.
33437	3/8" x 13"	36+	10 Belts/Box 5 Boxes/Case
33439		60+	
33440		80+	
33443	1/2" x 18"	36+	10 Belts/Box 5 Boxes/Case
33445		60+	
33446		80+	
33449	3/4" x 20-1/2"	36+	10 Belts/Box 5 Boxes/Case
33451		60+	
33452		80+	

## 3M™ Cubitron™ II Flap Disc — T29



Part No.	Size	Grade	Case Qty.
33470	4-1/2" x 7/8"	40+	5 Discs/Box 6 Boxes/Case
33471		60+	
33472		80+	

## 3M™ Cubitron™ II Cut-Off Wheels



Part No.	Size	Case Qty.
33455	3" x 1/16" x 3/8"	5 Wheels/Box 6 Boxes/Case
33456	3" x 1/25" x 3/8"	
34460	4" x 1/25" x 3/8"	

## 3M™ Cubitron™ II Abrasive Fibre Discs



Part No.	Size	Grade	Case Qty.
33413	5" x 7/8"	36+	5 Discs/Box 5 Boxes/Case
33415		60+	
33416		80+	
33425	7" x 7/8"	36+	5 Discs/Box 5 Boxes/Case
33427		60+	
33428		80+	

# Part Number Reference

## Featured Products

### 3M™ Platinum™ Select Filler



Part No.	Size	Case Qty.
31131	1 Gallon	4
31130	3 Gallon	1
31128	5 Gallon	1
35863	276mL DMS	6

### 3M™ Platinum™ Plus Finishing Glaze



Part No.	Size	Description	Case Qty.
31180	30 oz	Finishing Glaze	6
03180	24 oz		
03080	16 oz		
12011	24 oz	Glaze	
05862	276mL DMS		

### 3M™ Dry Guide Coat



Part No.	Size	Case Qty.
05860	Cartridge	10
05861	Kit	6

### 3M™ Panel Bonding Adhesive



Part No.	Size	Color	Case Qty.
38315	50mL	Black	6
08115	200mL		
08116			
58115	450mL DMS		4

### 3M™ Impact Resistant Structural Adhesive



Part No.	Size	Color	Case Qty.
07333	200mL	Dispenses Silver, Cures Purple	3
57333	450mL DMS		2



## 3M™ Cavity Wax Plus



Part No.	Size	Description	Case Qty.
08852	18 oz aerosol	Anti-Corrosion Spray	4
08851	8", 24" and 34" wands	Applicator Wand Kit	12

## 3M™ EZ Sand Multi Purpose Repair Material



Part No.	Size	Color	Case Qty.
05887	200mL	Grey	6
55887	600mL DMS		4

## 3M™ Bare-Metal Seam Sealer



Part No.	Size	Color	Case Qty.
08310	200mL	Beige	6
58310	600mL DMS		4

## 3M™ Heavy-Bodied Seam Sealer



Part No.	Size	Color	Case Qty.
08308	200mL	Black	6
58308	600mL DMS		4

## 3M™ Semi-Rigid Plastic Repair



Part No.	Size	Color	Case Qty.
34240	50mL	Black	6
04240	200mL		

## 3M™ Super Fast Plastic Repair Adhesive



Part No.	Size	Color	Case Qty.
04747	50mL	Clear	6
04248	200mL	Black	
04247		Clear	



I've been using 3M products since I first started working with my Dad in his shop. At Foose Design, we are proud to use these outstanding products every day to help us achieve the best in quality and design. With 3M, I can trust that I'm using industry's best. Whether it's the exceptional cut and life of 3M™ Cubitron™ II Abrasives or

smooth finish of 3M™ Platinum™ Select Body Filler, I can stand by my work and know I've used products infused with today's leading technology and innovation. I'm proud to have 3M products in my shop and use them every day. If you want to build the best, use the best products: 3M products are the best in the business.

**FOOSE**  
D E S I G N

 **WHEN USING 3M PRODUCTS  
IT IS MANDATORY TO ADHERE  
TO ALL SAFETY STANDARDS.**

Check out the collection of abrasives, grinding and sanding we offer.