Aluminum Repair Procedures

Paint Prep

Blend Panel Sanding Process

1

Clean the Repair Area

Clean the repair area with soap and water, followed by a recommended VOC compliant surface cleaner.

2

Hand Sand Edges

Scuff hard to reach areas and panel edges by hand with P800–P1000 abrasive disc or flexible abrasive sheet.

3

DA Sand Color Blend Area

DA sand the color blend area using a grade P800 abrasive disc and a soft interface pad. For best results, sand back into primer surfacer.

4

DA Sand Adjacent Panels

DA sand the remainder of the blend panel(s) using a P1000 abrasive disc.

5

Clean and Inspect

Clean the repair area with a VOC compliant or paint manufacturer recommended surface cleaner. Blow dry the repair area with clean, dry air. Inspect the repair area and re-sand any shiny spots as necessary.

Product List

3M™ Trizact™ Hookit™ Blending Disc, 6 in., P1000, PN 02090

3M™ Flexible Abrasive Hookit™ Sheet, 5.5 in. x 6.8 in., P800, PN 34340

3M™ Purple Finishing Film Hookit™ Disc, 6 in., P800, PN 30670

3M™ Hookit™ Soft Interface Pad, 6 in. x 1/2 in. x 3/4 in., PN 05777

Think About Your Health

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300

3M™ Half Facepiece Respirator, PN 07182

3M™ Lexa™ Protective Eyewear, PN 15200

3M

Post this insert in the work area.
Read and understand all information before using this product.

SAFETY INFORMATION

⚠ WARNING

Always wear recommended and appropriate eye, face, ear, hand and body protection. INJURY to face and eyes can result if product fails, disc flies off or pad ruptures. SEE ANSI Z87.1 for proper safety equipment.

⚠ WARNING

Sparks and particles generated from normal product operation can cause fire or explosion.
Remove flammable or explosive materials from work area.
Do not grind in flammable or explosive environments.
Do not grind flammable or explosive materials.

Read the
Material Safety Data Sheets (MSDS)
before using any materials.

Contact the suppliers of the workpiece materials and abrasive materials for copies of the MSDS if one is not readily available.

⚠ WARNING

Exposure to DUST generated from workpiece and/or abrasive materials can result in lung damage and/or other physical injury.

Use dust capture or local exhaust as stated in the MSDS. Wear government-approved respiratory protection and eye and skin protection.

Failure to follow this warning can result in serious lung damage and/or physical injury.

- PROVIDE appropriate local exhaust. If exhaust ventilation is not adequate, wear approved dust protection to prevent inhalation of dust particles.

⚠ WARNING

- CHECK the maximum operating speed (MOS) of the product and the tool. NEVER EXCEED the slower MOS. PRODUCT CAN BREAK APART AND CAUSE SERIOUS INJURY IF OPERATED ABOVE MOS.
- Inspect backup pads prior to use and replace if damaged or worn (cracks, nicks, or wear). Damaged product can break apart during use and cause serious injury.
- Ensure the shaft of the backup pad is fully seated in the tool. Failure to properly engage the shaft could result in disengagement of the pad during operation, causing bodily injury or property damage.

⚠ CAUTION

- Inspect backup pads prior to use to ensure it is properly mounted. Stop usage immediately if vibration or wobbling occurs.
- Do not jam backup pad into workpiece.
- DO NOT free spin tool. Start tool just before engaging work piece. Stop tool as it is being removed from work piece.
- STORE abrasive products in cool, dry place for best performance and safety. Avoid extended exposure to direct sunlight.
- Use only with 3M-recommended systems, under approved applications and conditions.
- ALWAYS clean mating surfaces prior to using pressure sensitive adhesive (PSA) attachment systems (i.e., Stikit™).
- REFER to tool manufacturer's recommendations for proper use of tools.
  Use manufacturer’s mounting hardware if supplied with tool.
- Use manufacturer's recommendations for use of tool guards.
- Follow tool manufacturer's recommendations for correct flanges and/or adaptors.
- SPEED ratings for accessories in a free spin mode are stated in revolutions per minute (rpm) and use the symbol:
- SPEED ratings for accessories in a random orbital mode are stated in orbits per minute (opm) and use the symbol:

Max rpm
tr/min

Max
opm