






E-Coat Panel Prep		
<b>1</b>		<p><b>Cleaning</b> Clean part with soap and water, followed by a VOC compliant surface cleaner.</p>
<b>2<sub>A</sub></b>		<p><b>Surface Prep Hand</b> Sand edges and other hard to reach areas using P400 flexible abrasive sheet or Scotch-Brite™ hand pad until the surface is matte and all sheen has been removed.</p>
<b>2<sub>B</sub></b>		<p><b>Surface Prep Machine</b> Sand remaining surfaces using P400 abrasive on a DA sander until the surface is matte and all sheen has been removed. <b>Note: Use 3M™ Flexible Abrasive Disc to reduce burning through the e-coat surface.</b></p>
<b>3</b>		<p><b>Re-clean</b> Blow off with clean, dry air. Clean bumper surface with soap and water, followed by a VOC compliant surface cleaner.</p>
<b>4</b>		<p><b>Apply Top Coats</b> Seal and paint following paint company recommendations.</p>
<p>Visit <a href="http://www.3MCollision.com">www.3MCollision.com</a> for more SOPs and videos</p>		

Product List	
<p>3M™ Car Wash Soap Concentrate, 1 gallon, PN 38377</p>	
<p>3M™ All Purpose Cleaner and Degreaser Concentrate, 1 gallon, PN 38350</p>	
<p>3M™ Flexible Abrasive Hookit™ Sheet, 5.5 in. x 6.8 in., P400, PN 34337</p>	
<p>Scotch-Brite™ Durable Flex Hand Pad, MX-HP, 4-1/2 in. x 9 in., Very Fine, PN 64659</p>	
<p>Scotch-Brite™ 7447 PRO Hand Pads, Very Fine grade, 6 in. x 9 in., PN 64926</p>	
<p>3M™ Flexible Abrasive Hookit™ Foam Pad, PN 34349</p>	
<p>3M™ Purple Clean Sanding Hookit™ Disc 334U, 6 in., P400 grit, PN 01811</p>	
<p>3M™ Flexible Abrasive Hookit™ Disc, 17 hole, 6 in., P400, PN 34800</p>	
<p>3M™ Accuspray™ Spray Gun Model HG14 Kit, 1.4mm, PN 16577</p>	

Think About Your Health	
<p>3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300</p>	
<p>3M™ Half Facepiece Respirator, PN 07182</p>	
<p>3M™ Lexa™ Protective Eyewear, PN 15200</p>	