



**Headlight Lens Restoration Process**

<b>1</b>		<p><b>Clean and Mask</b></p> <p>Clean the damaged lens with soap and water. Perimeter mask the lens with two layers of masking tape.</p>
<b>2</b>		<p><b>Sand to Remove Yellowing and Defects</b></p> <p>Dry DA sand the damaged headlight lens with a 3 in. grade 500 3M™ Hookit™ Purple Clean Sanding Disc using a soft interface pad. Completely remove any yellowing and/or surface defects.</p>
<b>3</b>		<p><b>1st Step Scratch Refinement</b></p> <p>Refine the grade 500 sand scratches by dry DA sanding with a 3 in. grade 800 3M™ Hookit™ Purple Clean Sanding Disc on a soft interface pad. Wipe the headlight lens clean.</p>
<b>4</b>		<p><b>2nd Step Scratch Refinement</b></p> <p>Refine the grade 800 sand scratches by DA sanding with a 3 in. grade 1000 3M™ Trizact™ Hookit™ Blending Disc on a soft interface pad. Use water to lubricate the grade 1000 foam abrasive disc. Spend extra time on this step to ensure removal of all grade 800 sand scratches. Wipe the headlight lens clean.</p>
<b>5</b>		<p><b>3rd Step Scratch Refinement</b></p> <p>Refine the grade 1000 sand scratches by DA sanding with a 3 in. grade 3000 3M™ Trizact™ Hookit™ Foam Disc on a soft interface pad. Use water to lubricate the grade 3000 foam abrasive disc. Spend extra time on this step to ensure removal of all grade 1000 sand scratches. Wipe the headlight lens clean.</p>
<b>6</b>		<p><b>Compound Lens</b></p> <p>Completely remove the grade 3000 sand scratches using a 3 in. polisher with a 4 in. 3M™ Perfect-It™ Foam Compounding Pad and 3M™ Perfect-It™ EX AC Rubbing Compound. Wipe the headlight lens with a clean microfiber cloth.</p>
<b>7</b>		<p><b>Polish Lens</b></p> <p>Polish the headlight lens using a 4 in. 3M™ Perfect-It™ Foam Polishing Pad and 3M™ Perfect-It™ EX Machine Polish. Wipe the headlight lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.</p>

Visit [3MCollision.com](http://3MCollision.com) for more SOPs and videos

**Product List**

Meguiar's® Shampoo Plus,  
1 gallon, PN D11101



Scotch® Performance  
Masking Tape 233+,  
18mm x 55m (.75 in.),  
PN 26334



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



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



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



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



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



3M™ Perfect-It™ Foam  
Buffing Pad, 4 in., PN 30041



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

3M™ Perfect-It™ Foam  
Polishing Pad, 4 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™ Protective  
Eyewear, PN 11326



Note: For best results use a process dedicated microfiber cloth.

## 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](http://3MCollision.com)

For product material safety data sheets see [3MCollision.com](http://3MCollision.com)

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