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Standard Operating Procedures

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From metal and plastic repair, to primer sanding, paint finishing and car clean-up, 3M has the repair processes and products for you to achieve the perfect finish. Feel confident your repair is done professionally and efficiently using the most up-to-date processes in the collision repair industry.

Skills for Success

3M Gold tier abrasives have been the workhorse abrasive in the industry since they were introduced over 25 years ago.

Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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3M™ Hookit™ and Stikit™ Accessories

3M™ Hookit™ Accessories									
	3" Disc	5" Disc D/F	5" Disc	6" Disc D/F	6" Disc	8" Disc D/F	8" Disc	2 3/4" File Sheet D/F	2 3/4" File Sheet
Items/Case	5	10	10	10	10	1	1	10	10
Description	Part Numbers								
Bodyman Pad	20427	05858	05775	05865	05776				
Painter Pad		20206		05551	05778				
Disc Pad, Low Profile		20353		20356	05756				
Soft Interface Pad	05771	20278	05573	05777	05777				
Disc Pad, 5/8" Center Mount						05780	05779		
Disc Pad, 5/8" Center Mount (Soft)							05768		
Disc Pad, 5 Mnt Holes (Natl Detroit)						05781	05781		
Disc Pad, 6 Mnt Holes (CP)						05782	05782		
Disc Pad, 5 Mnt Holes (Snap-On)						05783	05783		
Soft Hand Pad					05791				
Half Round Soft Hand Pad					05792				
5" Soft Hand Block									05742
5" Hand Block								05207	05740
7 3/4" Hand Block								05208	05741
16" Hand File Board								05209*	05744*
16" Air File Board								05848**	05748**
16" Orbital Air File Shoe								05899**	05746**
16" Orbital File Shoe Base Plate								05898**	05898**
11" Straight Line Air File Shoe									05750**
6 Meter Whip Hose Kit								05215	05215

3M™ Stikit™ Accessories							
	5" Disc D/F	5" Disc	6" Disc D/F	6" Disc	8" Disc D/F	8" Disc	2 3/4" File Sheet
Items/Case	10	10	10	10	1	1	10
Description	Part Numbers						
Bodyman Pad		05575		05576			
Painter Pad			05646	05546			
Disc Pad, 5/8" Center Mount						05579	
Disc Pad, 5/8" Center Mount (Soft)						05568	
Disc Pad, Low Profile	05655	05555	05656	05556			
Disc Pad, 5 Mnt Holes (Natl Detroit)					05681	05581	
Disc Pad, 6 Mnt Holes (CP)						05582	
Soft Hand Pad				05591			
Hard Hand Pad				05586			
5" Soft Hand Block							05442
5" Hand Block							05440
7 3/4" Hand Block							05441
16" Hand File Board							05444*
16" Air File Board							05448**
16" Orbital Air File Shoe							05446**
16" Orbital File Shoe Base Plate							05898**

* 1 per case
 ** 5 per case

3M™ Gold Abrasives
 with Hookit™ and Stikit™ Attachments



- The Abrasives by which all others are measured
- Delivering uniform, consistent finishes
- Available in both Stikit™ and Hookit™ for convenience and reuse



In our industry, these products are pure Gold.

3M™ Gold Abrasives are the standard that shops have turned to for quality, performance and durability for over 25 years. Our Gold Abrasives are precision coated with high quality minerals and resins to deliver longer-lasting discs that cut through a variety of surfaces - including paint, primer, fiberglass, metal and SMC. 3M™ Gold Abrasives produce uniform, consistent finishes and are available in both Stikit™ and Hookit™ options for convenience and reuse. When job quality and productivity matter most, turn to the abrasives that shops have relied on year after year.

Dent Repair and Paint Removal

D and E weight backing makes these abrasive products extremely durable for sanding paint, metal, or fiberglass. Open coat construction reduces loading on fresh filler. Products are available in no-hole and dust-free configurations, with either Stikit™ or Hookit™ attachment.

3M™ Green Corp Hookit™ Discs									
	5"	6" D/F	6"	8" D/F	8"	2 3/4" x 16 1/2" D/F	2 3/4" x 16 1/2"		
Discs/Box	25	25	25	25	25	50	50		
Boxes/Case	5	5	5	5	5	5	5		
Product ID	Weight	Grade	Part Numbers						
751U	E weight	24E					01652		
751U	E weight	36E	00616	00516	00625	00525		00543	
751U	E weight	40E	00615	00515	00624	00524	00642	00542	
750U	E weight	60E	00508	00513		00522		00540	
750U	E weight	80E	00612	00512	00621	00521	00639	00539	
750U	E weight	100E				00520		00538	

3M™ Green Corp Stikit™ Discs										
	5" D/F	5"	6" D/F	6"	8" D/F	8"	2 3/4" x 16 1/2" D/F	2 3/4" x 16 1/2"		
Discs/Box	100	100	100	100	50	50	100	100		
Boxes/Case	5	5	5	5	5	5	5	5		
Product ID	Weight	Grade	Part Numbers							
255U	E weight	24E					01552			
251U	E weight	36E		01546	01668	01548	01661	01551	02262 02232	
251U	E weight	40E	01665	01545	01667	01547	01660	01550	02261 02231	
255U	E weight	60E					01556			
246U	D weight	80D	01561*	01501*	01566*	01506*	01569	01549	02260 02230	

*10 per case

Featheredging and Primer Sanding

These products are designed to provide productivity in a variety of applications from express repair to larger body repair. Use the coarser products for sanding and featheredging filler and putties, and the finer grades for further refinement and primer sanding.

3M™ Gold Hookit™ Discs							3M™ Gold Film Stikit™ Discs					
	3"	5" D/F	5"	6" D/F	6"	2 3/4" x 16 1/2"		6" D/F	6"			
Discs/Box	50	100	100	100	100	50		125	75	125		
Boxes/Case	4	4	4	4	4	5		4	6	4		
Product ID	Weight	Grade	Part Numbers					Product ID	Weight	Grade	Part Numbers	
236U	C weight	P80	00921	01067*	00967*	01083*	00983*	255L	Film	P80	01383*	01333 01363*
236U	C weight	P100	00920		00966	01082	00982	255L	Film	P100	01382	01332 01362
236U	C weight	P120	00919		00965	01081	00981 02473	255L	Film	P120	01381	01331 01361
236U	C weight	P150	00918	01064	00964	01080	00980 02472	255L	Film	P150	01380	01330 01360
236U	C weight	P180	00917	01063	00963	01079	00979 02470	255L	Film	P180	01379	01329 01359
216U	A weight	P220	00916	01062	00962	01078	00978 02469	255L	Film	P220	01378	01328 01358
216U	A weight	P240	00915		00961	01077	00977	255L	Film	P240	01377	01327 01357
216U	A weight	P280				01076	00976	255L	Film	P280		01326 01356
216U	A weight	P320	00914	01059	00959	01075	00975	255L	Film	P320	01375	01325 01355
216U	A weight	P360					00974	255L	Film	P360		01354
216U	A weight	P400	00913	01057	00957	01073	00973	255L	Film	P400	01373	01323 01353
216U	A weight	P500	00912		00956	01072	00972	255L	Film	P500	01372	01322 01352
216U	A weight	P600	01011		01015	01091	00923					
216U	A weight	P800	01010		01014	01090	00922					

*75 discs/roll

3M™ Gold Stikit™ Discs												
	5" D/F	5"	6" D/F	6"	8"	2 3/4" x 25 YDS	2 3/4" x 30 YDS	2 3/4" x 45 YDS	4 1/2" x 20 YDS			
Discs/Roll	175	75	175	175	75	175	125					
Rolls/Case	10/6	6/12	10/6	10/6	6/12	10/6	4	10	10	10	6	
Product ID	Weight	Grade	Part Numbers									
236U	C weight	P80	01628*	01198	01428*	01643*	01213	01443*	01493	02599		02698
236U	C weight	P100		01197	01427*	01642*	01212	01442*	01492		02598	02697
236U	C weight	P120	01626	01196	01426*	01641*	01211	01441*	01491		02597	02696
236U	C weight	P150	01625	01195	01425	01640	01210	01440	01490		02596	02695**
236U	C weight	P180	01624	01194	01424	01639	01209	01439	01489		02595	02694**
216U	A weight	P220	01623	01193	01423	01638	01208	01438	01488		02594	
216U	A weight	P240	01622		01422	01637		01437	01487		02593	
216U	A weight	P280			01421	01636	01206	01436				
216U	A weight	P320	01620	01190	01420	01635	01205	01435	01485		02591	
216U	A weight	P360					01204	01434				
216U	A weight	P400	01619	01188	01419	01634	01203	01433	01484			
216U	A weight	P500			01417	01633	01202	01432			02589	
216U	A weight	P600					01201					
216U	A weight	P800					01200					

* 125 discs/roll
** 25 yards

Paint Preparation and Paint Finishing

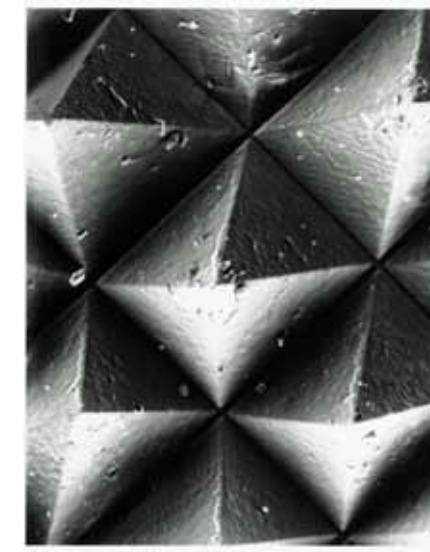
Performance Aluminum Oxide cuts fast, lasts a long time, resists loading and leaves a consistent finish. Use these products with a soft interface pad to scuff sand before painting. Use them to remove runs, dust nibs and excess orange peel from topcoat finishes before buffing.

3M™ Gold Hookit™ Discs						
	3"	5" D/F	5"	6" D/F	6"	
Discs/Box	50	100	100	100	100	
Boxes/Case	4	4	4	4	4	
Product ID	Weight	Grade	Part Numbers			
260L	Film	P600	00911	01055	00955	01071 00971
260L	Film	P800	00910	01054	00954	01070 00970
260L	Film	P1000	00909	01053	00953	01069 00969
260L	Film	P1200	00908	01052	00952	01068 00968
260L	Film	P1500	00907	01051	00951	01050 00950

3M™ Gold Stikit™ Discs				
	5"	6"		
Discs/Box	100	100		
Boxes/Case	4	4		
Product ID	Weight	Grade	Part Numbers	
260L	Film	P600	83678	01321
260L	Film	P800	83679	01320
260L	Film	P1000	83680	01319
260L	Film	P1200	83681	01318

3M™ Trizact™ Discs

Patterned, precise mineral structures give the combination of fast cut and consistent finish every time. Use P1000 foam blending discs for scuff sanding blend panels prior to painting. Use P1500 clearcoat sanding discs for leveling dust nibs and sanding of mismatched orange peel. Finally, use P3000 foam disc for removing P1200-P1500 grade sand scratches prior to use of 3M™ Perfect-It™ polishing system.



3M™ Trizact™ Discs						
	3"	5"	6"			
Product ID	Weight	Grade	Part Numbers			
443SA	Foam	P1000	02091		02090	15 Discs/Box 4 Boxes/Case
471LA	Film	P1500	02094	02095	02088	25 Discs/Box 4 Boxes/Case
443SA	Foam	P3000	02087	02096	02085	15 Discs/Box 4 Boxes/Case