



CUBITRON™ II 3M Aluminum Sanding Process

PERSONAL SAFETY

• Comfort Particle Mask P3



• Hearing Protection



• Comfort Goggles



• Reusable Overall



• Nitrile Gloves



Basic requirements



- ▶ Always use suitable dust extraction and select the correct tools for aluminum sanding: Festool Cleantec CTM 48 EC/B22 is certified under ATEX directive 94/9/EG for Zone 22 areas.
 - ▶ Separate tools and abrasives to avoid cross contamination.
- Note: If aluminum and steel dust are mixed together, it could create a thermal reaction, which can produce a much more powerful explosion than one with just aluminum dust.



Festool LEX 3 150/5
Festool LEX 3 150/7



Festool Cleantec
CTM 48 E LE EC/B22



Festool IAS 3-3500 AS - correspond
DIN IEC 312, Antistatic, bleeder
resistance (DIN IEC 312) < 1 MΩ/m

1 Sanding down the job area



- ▶ 3M™ Hookit™ Cubitron™ II Abrasive Discs, 120+ - 150+.
 - ▶ Identify and highlight sanding scratches through the application of dry guide coat.
- Note: Aluminum is a very soft metal! Pay special attention as using excessively coarse abrasives can badly damage the surface of the substrate.



3M™ Hookit™ Cubitron™ II
Abrasive Discs

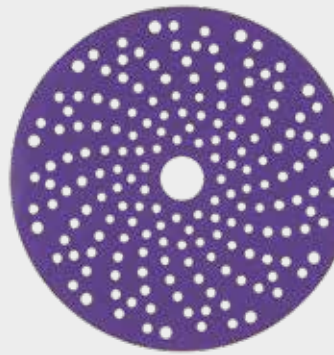


3M™ Dry Guide Coat

2 Fine sanding of the surface & feather edges



- ▶ 3M™ Hookit™ Cubitron™ II Abrasive Discs 220+ - 240+.
- ▶ Refine previous sanding scratches which reduces the possibility of solvents from the body filler penetrating into the OEM paint layers. If this happens it can lead to surface swelling around the repair.



3M™ Hookit™ Cubitron™ II
Abrasive Discs



Festool Interface-Pad

3 Sanding body filler



- ▶ 3M™ Hookit™ Cubitron™ II Abrasive Discs 150+ - 240+.
 - ▶ Flat sanding of the body filler area.
 - ▶ Identify and highlight sanding scratches through the application of dry guide coat.
- Note: Excessive heat build up during the sanding process should be avoided as this can damage the aluminum substrate.



3M™ Hookit™ Cubitron™ II
Abrasive Discs



3M™ Hookit™ Purple
Hand Block



3M™ Hookit™ Purple+
Abrasive Sheets

4 Pre-sanding of edges and borders



- ▶ 3M™ Hookit™ Flexible Abrasive Sheet P800-P1000.
- Note: For maximum process safety.



3M™ Hookit™ Flexible
Abrasive Sheets

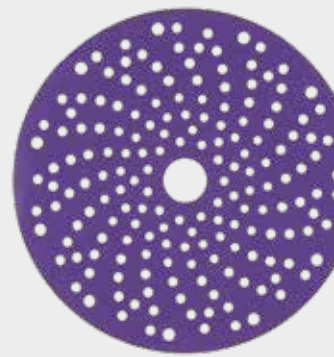


3M™ Hookit™ Flexible
Abrasive Sheets

5 Fine sanding of the surface & feather edges



- ▶ 3M™ Hookit™ Cubitron™ II Abrasive Discs 320+
 - ▶ It is advisable to work with a soft interface pad when sanding curved areas.
- Tip: The choice of the fine grit has to be adjusted to the solvent sensitivity of the original paint. The higher the solvent sensitivity of the original paint, as finer the sanding before primer application.



3M™ Hookit™ Cubitron™ II
Abrasive Discs



Festool Interface-Pad

6 Flat sanding of the primer above the body filler area



- ▶ 3M™ Hookit™ Hand Block and 3M Abrasives 320+ - 400+.
- ▶ Highlight the texture and structure of the primer using dry guide coat.
- ▶ For best results and the most efficient process always use dust extraction.



3M™ Hookit™ Cubitron™ II
Abrasive Sheets



3M™ Hookit™ Purple
Hand Block



3M™ Dry Guide Coat

7 Pre-sanding of edges and borders



- ▶ 3M™ Hookit™ Flexible Abrasive Sheets P800-P1000.
- Note: For maximum process safety.
- ▶ Identify and highlight sanding scratches through the application of dry guide coat.



3M™ Hookit™ Flexible
Abrasive Sheets



3M™ Hookit™ Flexible
Abrasive Sheets

8 Large Area Final Primer Sanding Before Painting



- ▶ Eccentric sanding with 3M Abrasives 400+ - P500.
 - ▶ For critical colors use a 3M™ Hookit™ Flexible Foam Disc P600 as a last sanding step after 400+.
 - ▶ Dedusting of the surface with 3M™ Scotch-Brite™ Abrasive Discs.
- Tip: It is advisable to work with a soft interface pad when sanding curved areas.



3M™ Hookit™ Cubitron™ II
Abrasive Discs



3M™ Hookit™
Flexible Foam Disc

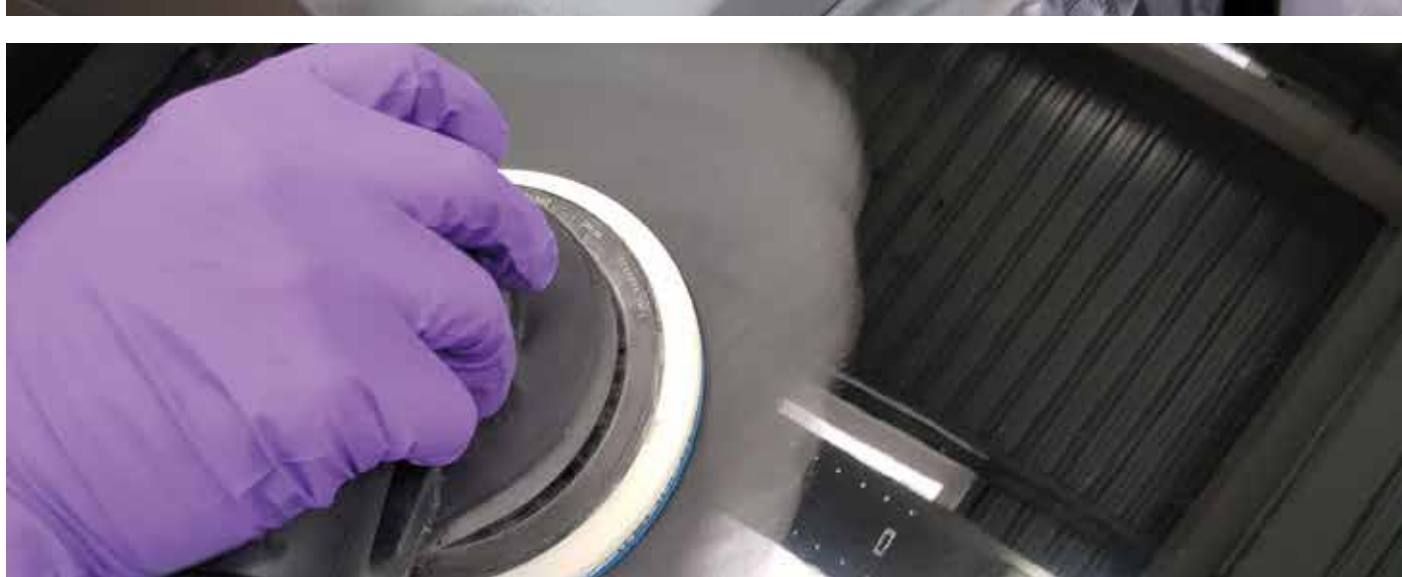


3M™ Scotch-Brite™
Abrasive Discs

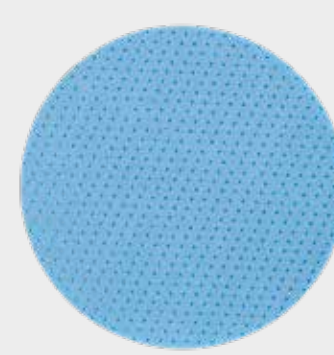


Festool LEX 3 150/3

9 Blending in to adjacent parts



- ▶ 3M™ Hookit™ Flexible Foam Disc P800 - P1000.
 - ▶ Prepare adjacent areas of the OEM clearcoat.
- Note: For maximum process safety.



3M™ Hookit™
Flexible Foam Disc