

Clearcoat Repair without Repainting

Service Precautions

- Avoid washing vehicles in direct sunlight.
- Avoid using strong soaps or chemical detergents.
- Use brushless type automatic car wash equipment.
- Avoid using products containing acids, unless specified in order to correct a condition such as rail dust.
- Do not use brushes or brooms in order to remove snow or ice from vehicles in storage or on lots.
- Cleaning agents and water should be dried promptly and not allowed to dry on the surface.
Drying with a soft chamois is recommended.
- Standing rinse water should be dried promptly and not allowed to dry on the surface.
Drying with a soft chamois is recommended.
- Do not polish vehicles unless a surface condition exists that can only be corrected by polishing. Refer to [Clearcoat Repair Specifications - 3M Products](#) .
- If a surface condition does exist, the repair approach should be one of less is best, the very least it takes to correct the condition.
- Avoid removing too much clear coat whenever possible, use paint gauges before, during and after polishing. Refer to [Paint Gages](#) .
- Use only the products recommended in this procedure (or their equivalent). Refer to [Clearcoat Repair Specifications - 3M Products](#) .
- Ensure that any power polishing equipment does not exceed the requirements in the polish manufacturers recommendations. The final process step typically uses an orbital type polisher with speeds of 1,500-2,000 RPM. Refer to [Clearcoat Repair Specifications - 3M Products](#) .
- Do not use wax or silicone type products in order to hide swirl marks, this damage will reappear later and cause customer dissatisfaction.
- Specific conditions on the paint (environmental damage, rail dust, etc.) may be corrected by:
 - Refer to [Environmental Fallout \(Acid Rain\)](#) .
 - Refer to [Rail Dust Damage Repair](#) .

Repair Procedure

Notice: Removing more than 0.5 mils of the clearcoat can result in early paint failure. The clearcoat contains ultraviolet screeners. Do not finesse sand more than what is required to remove the defect.

1. Thoroughly wash the repair area with Liquid Wash and Wax GM P/N 1052870 or the equivalent.
2. Readings of the paint film build should be taken prior to the operation. Refer to [Paint Gages](#) .
3. Apply a small amount of the appropriate material to repair area and smear evenly with the pad. Refer to [Clearcoat Repair Specifications - 3M Products](#) .
4. With the polisher running at approximately 1,500-2,000 RPM, polish the repair area. Keep the pad flat against the panel while applying heavier pressure for 4-6 seconds. Then, polish with lighter pressure for 6-8 seconds. Feature lines and panel edges should be hand-rubbed in order to avoid burn-through.
5. Inspect the repair area frequently. Add more of the appropriate material as needed.
6. Always blend or feather the outer edges of the repaired area.
7. After buffing, inspect the repaired area.
8. If swirls are still visible, repeat the buffing procedure.
9. Clean the repaired area using a clean soft, non-scratching cloth with a 50/50 mixture of Isopropyl Alcohol and water.
10. If sanding is required, refer to [Clearcoat Repair Specifications - 3M Products](#) .