Product List

Tooling Gelcoat Finishing

3M™ IMPERIAL™ HOOKIT™ DISCS–360L

Part Number	Grade	Size	Discs/Box	Boxes/Case
051115-19621	P1000	3"	50	4
051115-19622	P800	3"	50	4
051115-19623	P600	3"	50	4
051115-19624	P500	3"	50	4
051115-19625	P400	3"	50	4
051115-19626	P320	3"	50	4
051115-19627	P240	3"	50	4
051115-19628	P220	3"	50	4
051131-55723	P1000	5"	100	5
051131-55722	P800	5"	100	5
051131-55721	P600	5"	100	5
051131-55720	P500	5"	100	5
051131-55719	P400	5"	100	5
051131-55718	P360	5"	100	5
051131-55717	P320	5"	100	5
051131-55716	P280	5"	100	5
051131-55714	P240	5"	100	5
051131-55713	P220	5"	100	5
051131-13935	P1000	6"	100	5
051131-13936	P800	6"	100	5
051131-13937	P600	6"	100	5
051131-13938	P500	6"	100	5
051131-13939	P400	6"	100	5
051131-13940	P360	6"	100	5
051131-13941	P320	6"	100	5
051131-13942	P280	6"	100	5
051131-13943	P240	6"	100	5
051131-13944	P220	6"	100	5

3M™ HOOKIT™ DISC SANDING ACCESSORIES

Part Number	Description	Size	Qty/Case
051131-05861	Dry Guide Coat Cartridge with Applicator	50 gm	6
051131-07439	Scotch-Brite™ Clean and Prep Sponge - White	10/bag	3 bags
051111-57764	Disc Pad 02700 - Low Profile	3"	5
051131-05769	Disc Pad 5769	3"	5
051144-05540	Roloc™ Disc Pad Assembly	3"	10
051144-14736	Finesse-It™ Roloc™ Finishing Pad 12/bag	3"	144
051131-05775	Disc Pad - 3/4"	5"	10
051131-05755	Low Profile Finishing Disc Pad - 3/8"	5"	10
051144-77855	Low Profile Soft Finishing Disc Pad - 11/16"	5"	10
051131-05773	Soft Interface Pad	5"	10
000000-88132	Half Round Hand Pad	5"	20
051144-85095	Disc Hand Pad - Molded	5"	10
051144-77750	Hand Pad - 1"	5"	10
051131-77752	Hand Pad - 1/4"	5"	20
051131-05776	Disc Pad - 3/4"	6"	10
051131-05756	Low Profile Finishing Disc Pad - 3/8"	6"	10
051131-05747	Low Profile Soft Finishing Disc Pad - 11/16"	6"	10
051131-05774	Soft Interface Pad	6"	10
051131-05791	Hand Pad - 1/4"	6"	20
051131-05792	Half Round Pad	6"	20

MOLD CLEANING

Part Number	Description	Size	Qty/Case
048011-19344	3M™ Sharpshooter Extra Strength No Rinse Cleaner Bottle w/Nozzles	Quart	12
048011-13702	3M™ Sharpshooter Extra Strength No Rinse Cleaner and Mark Remover	5 Gal	1
048011-19349	3M™ Sharpshooter Extra Strength No Rinse Cleaner and Mark Remover	55 Gal	1
-08440	3M™ Doodlebug White Cleansing Pad	5/Box	4 Boxes
048011-23651	Scotch-Brite™ High Performance Cloth - Yellow	Each	50

Product List

Tooling Gelcoat Finishing

3M™ IMPERIAL™ WETORDRY™ PAPER SHEETS

Part Number	Grade	Size	Sheets/Sleeve	Sleeves/Case
051131-02019	Microfine 2500	9" x 11"	50	5
051131-02020	Microfine 2000	9" x 11"	50	5
051131-02032	Microfine 1500	9" x 11"	50	5
051131-02033	Microfine 1200	9" x 11"	50	5
051131-02034	Microfine 1000	9" x 11"	50	5
051131-02035	P800	9" x 11"	50	5
051131-02036	P600	9" x 11"	50	5
051131-02037	P500	9" x 11"	50	5
051131-02038	P400	9" x 11"	50	5
051131-02039	P320	9" x 11"	50	5
051131-02042	P240	9" x 11"	50	5
051131-02043	P220	9" x 11"	50	5

3M™ IMPERIAL™ WETORDRY™ PAPER SANDING TOOLS

Part Number	Description	Qty/Case
051144-05517	Rubber Squeegees - 2-3/4" x 4-1/4"	50
051144-05518	Rubber Squeegees - 3" x 2"	50
051131-05526	No. 20 Sponge Pad	50
051131-02513	Bucket	10
051144-05519	Rubber Sanding Block 2-3/4" x 5"	10
051144-05520	Rubber Sanding Block 3" x 8"	10

3M™ SOFTBACK WETORDRY™ SANDING SPONGES

Part Number	Description	Sponges/Box	Boxes/Case
051131-02600	Microfine 1200-1500	20	6
051131-02601	Ultrafine 800-1000	20	6
051131-02602	Superfine 500-600	20	6
051131-02603	Fine 320-400	20	6
051131-02604	Medium 120-180	20	6

3M™ BUFFING COMPOUNDS AND PADS

Part Number	Description	Size	Qty/Case
051111-57764	Hookit™ Disc Pad 02700 - Low Profile	3"	5
051111-51151	Finesse-It™ Hookit™ Orange Foam Buffing Pad	3.25"	
051131-05726	Perfect-It™ Hookit™ Black Foam Polishing Pad	3"	
051131-05540	Roloc™ Disc Pad Assembly	3"	10
051144-81470	Finesse-It™ Natural Buffing Pad 10/bag	3"	5 bags
051144-14736	Roloc™ Finishing Backup Pad 12/bag	3"	12 bags
051131-05755	Low Profile Finishing Disc Pad	5"	10
051144-81471	Finesse-It™ Natural Buffing Pad 10/bag	5"	5 bags
051131-05719	Perfect-It™ III Compounding Pad - Single-Sided (100% Wool)	9"	24
051131-05703	Superbuff™ Compounding Pad - Double-Sided (100% Wool)	9"	6
051131-05705	Superbuff™ Polishing Pad - Double-Sided (Yellow)	9"	24
051144-05710	Superbuff™ Adapter for Double-Sided Pads	9"	10
051131-05711	Hookit™ SBS™ Compound Pad - Single-Sided (100% Wool)	9"	24
051131-05713	Hookit™ SBS™ Polishing Pad - Single-Sided	9"	24
051131-05717	Hookit™ SBS™ Backup Pad	9"	24
051131-05725	Perfect-It™ Black Foam Polishing Pad - 2 pads/bag	8"	12 bags
051131-06027	Mold and Tooling Compound	Gallon	4
051131-06044	Imperial™ Compound and Finishing Material	Quart	12
051131-06045	Imperial™ Compound and Finishing Material	Gallon	4
051131-06046	Imperial™ Compound and Finishing Material	5 Gal	1
051131-06064	Perfect-It™ 3000 Swirl Mark Remover	Quart	6
051131-06065	Perfect-It™ 3000 Swirl Mark Remover	Gallon	4

Warranty and Limited Remedy: 3M warrants this product will be free from defects in materials and manufacture at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. If the product is proved to be defective, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

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Marine and Specialty Vehicle Department

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3M Imperial™ Abrasives and Surface Finishing Solutions

Tooling Gelcoat Finishing

TOOLING GELCOAT FINISHING

Achieve Superior Mold Finishes in Less Time with 3M Products—The Industry Standard

- Advanced abrasive technology
- Pure abrasive finishing compounds
- Swirl-free, high-gloss mold finishes
- 3M Marine "Finish First" Employee Training

Clean Before Sanding or Buffing

STEP 1: Remove debris and or mold release agents with 3M™ Sharpshooter Extra Strength No Rinse Cleaner and Mark Remover (PN 19344) and Scotch-Brite™ High Performance Cloth – Yellow (PN 23651).

STEP 2: For heavy mold release wax buildup, use 3M™ Sharpshooter Extra Strength No Rinse Cleaner and Mark Remover (PN 19344) and Scotch-Brite™ Clean and Prep Sponge – White (PN 07439).

Sanding with 3M™ Hookit™ Sanding Discs

Use 3M™ Imperial™ Abrasive Discs - available in full grade sequence—3", 5" and 6".

(Example Grade Sequence)

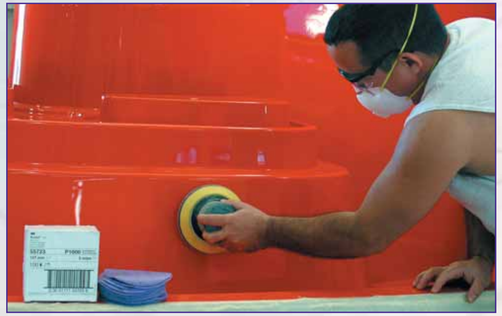
STEP	1	2	3	4	5*
GRADE	P220	P500	P800	P1000	P1200

NOTE: Use 3" abrasive discs for small or hard-to-reach areas.

Use soft interface pads for contours and radius finishing.

Random Orbital Sanding Tips

- Clean the surface.
- Start random orbital tool on the surface, and stop random tool off the surface.
- Choose correct abrasive grade for the degree of repair.
- Use proper tool speeds.
- Ensure proper air pressure to the tool.
- Use 3M™ Dry Guide Coat to see when abrasive areas are completely finished.



Wet or Dry Abrasive Sheet Sanding

Use 3M™ Imperial™ Wetordry™ Abrasive 9" x 11" sheets for block sanding - available in full grade sequence.

Use Softback Foam Sanding Sponges in full grade range for small contours and radius areas.

(Example Grade Sequence)

STEP	1	2	3	4	5*
GRADE	P220	P500	P800	P1000	P1200

**** Optional Step: P1200 3M™ Wetordry™ Abrasive Block Sanding = P1000 Random Orbit Disc Sanding.***

Buffing

STEP 1: For P1000 D/A disc scratch or P1200 wet or dry scratch, use 3M™ Imperial™ Compound and Finishing Material with 3M™ single- or double-sided 100% wool Compounding Pads (PN 5703 double-sided, PN 5719 single-sided).

Tip: Run buffer at 1700 – 2000 RPMs for best results.

STEP 2: 3M™ Perfect-It™ 3000 Swirl Mark Remover (PN 6064) with yellow 3M™ Polishing Pads (PN 5705 double-sided, PN 5713 single-sided) or 3M™ Perfect-It™ Hookit™ Black Foam Polishing Pad (PN 5725).

Optional step to further improve finish and/or remove swirl marks:

Step 3: 3M™ Perfect-It™ 3000 Final Glaze (PN 06066) with 3M™ Perfect-It™ Hookit™ Black Foam Polishing Pad (PN 5725).

Note: To Remove P800 D/A disc scratch, use 3M™ Marine Premium Mold and Tooling Compound with 3M™ single- or double-sided 100% wool Compounding Pads (PN 5703 double-sided, PN 5719 single-sided).

Buffing Tips

- Use 3M™ Sharpshooter Extra Strength No Rinse Cleaner and Mark Remover and Scotch-Brite™ High Performance Cloth (PN 23589) between compounding and polishing steps.
- Use same products for mold cleanup after polishing steps.

Mold Protection During Finishing Work Periods

STEP 1: Cover mold and non-skid surfaces with 3M™ (UV Resistant) Slip Resistant Protective Film (PN 99602 or PN 99603) to protect diamond pattern and adjacent work areas. Tape down leading edges with 3M™ Masking Tape 233+ (PN 26340 is 2" wide).

Mold Protection for Non-Use Periods

STEP 1: Cover clean mold with 3M™ Overspray Sheeting (PN 6788) and secure with 3M™ Masking Tape 233+ (PN 26340 is 2" wide).

Mold Protection During Non-use Periods