

**Gelcoat Finishing for Darker OEM Colors**

**1**



**Cleaning**

Clean the gelcoat surface to remove any contaminants or debris. Followed by a cleaner to remove stubborn marks, spots, and stains. Wipe dry using 3M™ Perfect-It™ Detailing Cloth.

**2**



**Sanding**

Sand gelcoat surface, beginning with the least aggressive grit possible, on a dual-action sander. For larger repair areas, abrade the surface with a 50% overlap on each pass with the sander. Use the following abrasive grit sequence (begin where applicable): 320, 500, 800, 1000. Use a soft interface pad when sanding with the 800 & 1000 grit abrasive. Clean the surface between each sanding step.

**3**



**Sand Scratch Refinement**

For darker gelcoats, refine the 1000 grit sand scratch with 1500 grit, followed by 3000 grit. When sanding, use a 50% overlap with each pass of the sander. Use a soft interface pad with the 1500 & 3000 grit abrasive when sanding.

**4**



**Buffing/Polishing**

Buff the 3000 grit sand scratch with 3M™ Perfect-It™ Gelcoat Compound + Polish, and a 3M™ Perfect-It™ Wool pad. Set the buffer speed between 1200–2000 Max. RPM.

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

**Product List**

3M™ Sharpshooter™ Extra Strength No-Rinse Mark Remover, PN 16861, 1 qt.



3M Perfect-It™ Detailing Cloth, PN 06016

3M™ Hookit™ Film Disc 360L Sanding Disc, 5 in, No Hole, 320 grit, PN 01707



3M™ Hookit™ Film Disc 360L Sanding Disc, 5 in, No Hole, 500 grit, PN 01709

3M™ Hookit™ Film Disc 360L Sanding Disc, 5 in, No Hole, 800 grit, PN 01711

3M™ Hookit™ Film Disc 360L Sanding Disc, 5 in, No Hole, 1000 grit, PN 01712

3M™ Trizact™ Clear Coat Sanding Disc, 5 in, P1500, PN 02095



3M™ Trizact™ Hookit™ Foam Disc, 5 in, 3000 grit, PN 02096



3M™ Perfect-It™ Gelcoat Compound + Polish, 1 quart, PN 30344



3M™ Perfect-It™ Wool Compounding Pad, 9 in, PN 05753

3M™ Quick Connect Adaptor, 05752, 5/8 in. thread



3M™ Perfect-It™ Wool Blend Polishing Pad, Yellow, 9 in, PN 05754



**Think About Your Health**

3M™ E-A-R™ Skull Screws™ Ear Plug, PN P1300



3M™ Half Facepiece Respirator, PN 07182



3M™ Virtua™ CCS Protective Eyewear with Foam Gasket, PN 11872



**Not a complete list.** Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment.

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**Product Selection and 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. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

**Limitation of Liability:** Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



3M Automotive Aftermarket Division  
3M Center, Building 223-6S-07  
St. Paul, MN 55144-1000  
U.S.A.

3M, Dynatron, Dyna-Glass, E-A-R, Hand Masker, Hookit, Imperial, Lexa, Perfect-It, Platinum, PPS, Roloc, Scotchgard, Sharpshooter, Skull Screws, Trizact and Ultra Glass are trademarks of 3M Company.

3MMarine.com

Please recycle. Printed in U.S.A. © 3M 2020. All rights reserved. 60-4405-0023-3 9/2020