

Gelcoat Finishing for OEM Mold and Tooling

1



Cleaning

Clean the gelcoat surface to remove any contaminants or debris. To remove the mold release agents, use the cleaner recommended by the mold-release manufacturer.

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 a soft interface pad when sanding with the 1000 & 1500 grit abrasive. Clean the surface between each sanding sequence.

3



Sand Scratch Refinement (Optional)

Refine the 1500 grit sand scratch with a 3000 grit abrasive. When sanding, use a 50% overlap with each pass of the sander. Use a soft interface pad with the 3000 grit abrasive when sanding. If final sanding step is 1500 or above, use 3M™ Perfect-It™ Compound + Polish to reduce compound and polish time.

4



Buffing

Buff the gelcoat surface with 3M™ Perfect-It™ Heavy Cutting Compound and a Perfect-It™ Wool Compounding pad. Set the buffer speed between 1200–2000 Max. RPM.

5



Polishing

Polish the gelcoat surface area with 3M™ Perfect-It™ Compound + Polish and a 9 in. 3M™ Perfect-It™ Wool Blend Polishing Pad. Set the buffer speed between 1200 – 2000 Max. RPM.

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Product List

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, P1500, PN 02095



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



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

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



3M™ Perfect-It™ Gelcoat Heavy Cutting Compound, PN 36102

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



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.

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