

Think about your health

3M[™] E-A-R[™] Ultrafit[™] Earplugs, 32 dB, Corded, 50 Pairs/Box, UF-01-000



3M[™] Maintenance Free Half Mask, FFA2P3 R D Filters, 4255+



3M™ SecureFit™ 400 Safety Glasses, Black/Green frame, Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU



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

Gelcoat Surface Preparation and Application Process **Product List** 1. Clean the new external composite surface with approved cleaner to remove all mold release 3M™ Perfect-It" 3M™ Perfect-It™ **Boat Wash High Performance** PN09034E Cloth, Yellow PN09035E PN50400 1. Sand the old or new gelcoat to remove surface imperfections using a DA sander with abrasive discs 3M™ Hookit™ 775L Cubitron™ II grade 80+. 2. Apply Sanding dry guide coat to surface and re-sand gelcoat to 3M™ Sander ensure an even texture of surface is being repaired. 3M™ Hookit™ 3M™ Hookit" 3. Clean the repair area with approved cleaner or 775L Cubitron™ II PN28508 Soft Interface Pad blow off the repair area using pressured air. Abrasive Discs 152mm 5mm orbit PN28509 152mm 2.5mm orbit PN51126 1. If needed, mix 3M™ Marine Blister Repair Filler per manufacturer's recommendation. 2. First apply Filler applicatior a tight coat then apply filling coats. Fill 85% of the cavity leaving space for 3M™ Marine Premium Filler 3M™ Hookit™ to be applied later in the process. 3. After 30 minutes 3M™ Marine Blister 3M™ Drv feather the repair with 3M[™] Hookit[™] 775L Cubitron[™] II 775L Cubitron™ II **Guide Coat** Repair Filler abrasive disc grade 80+. 4. Apply dry guide coat to Abrasive Discs PN09650 Black PN50416 surface and re-sand gelcoat to ensure an even texture of surface is being repaired. 5. Clean the repair area with approved cleaner or blow off the repair area using pressured air. 1. Mix 3M™ Marine Premium Filler according to manufacturer's specification, 2. Apply 3M™ Marine application Premium Filler to the repair area making sure to apply a tight coat first. 3. After the filler has cured, sand the repair with 3M™ Hookit™ 775L Cubitron™ II 120+ 3M[™] Sander 3M™ Hookit™ 3M™ Marine PN28508 grade abrasive discs, removing high spots in the Premium Filler 775L Cubitron™ II 152mm 5mm orbit repair. 4. Finish by sanding the repair area with 3M™ PN46005 Abrasive Discs PN28509 Hookit™ 775L Cubitron™ II grade 220+. 152mm 2.5mm orbit 1. Ensure that the surface is completely dry prior to applying $3M^{\mathsf{m}}$ masking products. **2.** Taking care to keep the repair area as small as possible, first mask the areas that require 3M™ Precision Masking Tape. 3. Mask the rest of the repair, backing up the 3M™ *3M 3M™ Scotch® 3M™ Purple 5 Performance Precision Masking Tape with masking tape*. Premium Plus Precision Performance 4. Mask entire surface with 3M™ Purple Premium Plus Industrial Masking Tape Masking Film Masking Tape Masking Tape 244 Masking Film. 301E *3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244 1. Mix gelcoat in appropriate 3M[™] PPS[™] Series 2.0 disposable spray cup, according to manufacturer recommendation. Remember to remove filter in pplication the lid of disposable paint system 2. Adjust 3M" 3M™ PPS™ Series $3M^{^{\mathsf{m}}}\,Performance$ Performance Spray Gun air pressure, fan and 3M™ Performance fluid setting to achieve desired fan pattern and 2.0 Spray Cup Spray Gun **Gravity HVLP** atomisation. 3. Hold spray gun 15cm - 20cm away System PN26832 Atomising Head from surface and apply gelcoat to the repair area Red according to manufacturer's recommendation for PN26720 micron thickness. For gelcoat finishing process please refer to the following page. finishing

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Gelcoat Finishing Process* Product List 1. Clean the new external composite surface with approved cleaner to remove all mold release 3M™ Perfect-It" 3M™ Perfect-It™ **Boat Wash High Performance** PN09034E Cloth, Yellow PN09035E PN50400 1. If needed, sand gelcoat surface with 3M™ Hookit™ 775L Cubitron™ II 320+ grade abrasive discs and then 400+ finer grit abrasives. Remember to use 3M™ Sanding Hookit™ Soft Interface Pad when sanding with the 320+/400+ grade abrasive discs. 2. If surface is in 3M™ Hookit™ 3M™ Hookit™ 3M™ Hookit™ good condition start with P800 grade 3M™ Hookit™ Flexible Soft Interface 7751 PN28508 Abrasive Pad 152mm 5mm orbit Flexible Abrasive Foam Discs on a dual action sander. Cubitron™ II PN28509 Foam Discs When sanding use a 50% overlap with each pass of Abrasive 152mm 2.5mm orbit PN51127 10mm the sander. Discs 1. Refine the P800 grade sand scratch using the P1200 grade 3M™ Hookit™ Flexible Abrasive Foam Sand scratch refinement Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander. 3M™ Hookit" 3M™ Hookit™ 3M™ Sander Flexible Soft Interface PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit Abrasive Pad Foam Discs PN51126 5mm PN51127 1. Compound the abraded surface with 3M™ Perfect-It™ Gelcoat Heavy Cutting Compound and 3M™ Perfect-It™ Low Linting Wool Compounding Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's. 3M™ Perfect-It™ 3M™ Perfect-It" 3M™ Perfect-It™ Gelcoat **Quick Connect High Performance Heavy Cutting** Double Sided Cloth, Yellow Compound Wool Com-PN50400 PN36101 PN36102E PN36103 pounding Pad 230mm PN33279 3.6L 3M™ Quick Connect Adaptor 1. 3M™ Perfect-It™ Gelcoat Compound + Polish and $3M^{\mathsf{TM}}$ Perfect-ItTM Low Linting Wool Compounding Pad. Use the rotary polishing machine at a speed of 1400 - 1800 rpm's. 3M™ Perfect-It™ 3M™ Perfect-It™ 3M[™] Perfect-It[™] Gelcoat **Quick Connect High Performance** Double Sided Cloth, Blue Compound + Polish Wool Com-PN30344E PN30345E pounding Pad 3.6L 230mm PN33279 3M™ Quick Connect Adaptor 1. Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying Boat Wax, apply in a Protection 10cm x 10cm area and wipe area clean before the wax dries. 3M™ Perfect-It 3M™ Perfect-It™ 3M™ Perfect-It™ **Boat Wax** High Gloss High Performance Polishing Pad PN09034E Cloth, Blue

PN09035E

PN09378

PN50486

^{*} Two options (5 or 6 steps)

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Gelcoat Finishing Process*			Product List
1	Cleaning	Clean the new external composite surface with approved cleaner to remove all mold release materials.	3M™ Perfect-It™ 3M™ Perfect-It™ Boat Wash High Performance PN09035E 946ml Cloth, Yellow PN50400
2	Sanding	1. If needed, sand gelcoat surface with 3M™ Hookit™ 775L Cubitron™ II 320+ grade abrasive discs and then 400+ finer grit abrasives. Remember to use 3M™ Hookit™ Soft Interface Pad when sanding with the 320+/400+ grade abrasive discs. 2. If surface is in good condition start with P800 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	3M™ Hookit™ 3M™ Hookit™ 3M™ Hookit™ 3M™ Sander 775L Flexible Soft Interface Cubitron™ II Abrasive Pad 152mm 5mm orbit PNS1126 5mm PNS1126 5mm PNS1126 10mm PNS1127 10mm
3	Sand scratch refinement	1. Refine the P800 grade sand scratch using the P1200 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	3M™ Hookit™ 3M™ Hookit™ 3M™ Sander Flexible Soft Interface PN28508 Abrasive Pad PN51126 5mm PN51126 5mm PN51127 10mm Foam Discs PN51126 5mm PN51127 10mm
4	Compounding & Polishing	1. Compound the abraded surface with 3M [™] Perfect-It [™] Gelcoat Compound + Polish and 3M [™] Perfect-It [™] Low Linting Wool Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's.	3M™ Perfect-It™ Gelcoat Quick Connect High Performance Cloth, Yellow PN30344E 946ml PN30345E 3.6L 3M™ Perfect-It™ Guick Connect Adaptor PN05752
5	Protection	1. Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying Boat Wax, apply in a 10cm x 10cm area and wipe area clean before the wax dries.	3M™ Perfect-It™ Boat Wax PN09034E 473ml PN09035E 946ml PN09378 3M™ Perfect-It™ High Gloss High Performance Cloth, Blue PN50486

^{*} Two options (5 or 6 steps)

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Marine Paint Surface Preparation and Application Process **Product List** 1. Clean the surface with approved cleaner to remove Cleaning and surface pollution. 3M™ Perfect-It" 3M™ Perfect-It™ **Boat Wash** High Performance PN09034E Cloth, Yellow PN09035E 946ml PN50400 1. Using a DA sander with 3M™ Hookit™ 775L Cubitron™ II 80+ grade abrasive discs, sand the Sanding surface to prepare for filler application. 2. Clean the surface with approved cleaner or blow off the repair area using pressured air. 3M™ Hookit™ 3M™ Sander 775L Cubitron™ II PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit Abrasive Discs 1. As an alternative to Epoxy Fillers use mixed 3M[™] Marine Premium Filler per manufacturer's recommendation. **2.** Apply $3M^{\text{™}}$ Marine Premium application Filler to the surface. 3. After 30 mins (12-24hrs for Epoxy Filler) apply dry guide coat to the surface and 3M[™] Marine 3M™ Hookit™ 3M[™] Dry sand the filler with 3M™ Hookit™ 775L Cubitron™ II **Guide Coat** Premium Filler 775L Cubitron™ II 120+ grade abrasive discs. 4. Apply dry guide coat to PN46005 Abrasive Discs PN09650 Black PN50416 surface and re-sand filler to ensure even texture of surface being repaired. 5. Finish by sanding filler with 3M™ Hookit™ 775L Cubitron™ II 220+ grade abrasive discs. 6. Clean the surface with approved cleaner or blow off the surface with pressured air. 1. Ensure that the surface is completely dry prior to applying 3M™ masking products. 2. Taking care to keep the repair area as small as possible, mask the areas that require 3M™ Precision Masking Tape first. 3. Mask the rest of the repair, backing up the 3M™ Precision 3M™ Purple 3M™ Scotch® Masking Tape with masking tape*. 4. Mask entire Premium Plus Precision Performance Performance surface with 3M™ Purple Premium Plus Masking Film. Masking Film Masking Tape Industrial Masking Tape *3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244 PN50988 Masking Tape 244 1. Mix primer in appropriate 3M[™] PPS[™] Series 2.0 disposable spray cup. 2. Adjust 3M™ Performance **Applicatior** Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply 3M™ PPS™ Series 3M™ Performance 3M™ Performance primer to the repair area according to manufacturer's 2.0 Spray Cup Spray Gun Gravity HVLP recommendation for micron thickness. System PN26832 Atomising Heads 1. Apply dry guide coat to surface and sand primer with 3M™ Hookit™ 775L Cubitron™ II 320+ grade Sanding abrasive discs to prepare for paint application. 2. Apply dry guide coat to surface. 3. Repeat sanding with 3M™ Hookit™ 775L Cubitron™ II abrasive discs 3M[™] Drv 3M™ Hookit™ 3M[™] Sander 775L Cubitron™ II Guide Coat PN28508 grade 400+. 4. Clean the surface with approved 152mm 5mm orbit PN09650 Black **Abrasive Discs** cleaner or blow off the repair area using pressured air. PN50416 **1.** Mix paint in appropriate $3M^{TM}$ PPS TM Series 2.0 Application disposable spray cup. 2. Adjust $3M^{\mathsf{TM}}$ Performance Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply 3M™ PPS™ Series 3M™ Performance paint to the repair area according to manufacturer's 2.0 Spray Cup Spray Gun Gravity HVLP recommendation for micron thickness. Atomising Heads System PN26832 paint For Marine Paint Finishing process please refer to the finishing following page.

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Marine Paint and Clearcoat Finishing Process



1. Clean the surface with approved cleaner to remove and surface pollution.

*Dry or Wet Sanding option

Product List



3M™ Perfect-It™ **Boat Wash** PN09034E PN09035E



3M™ Perfect-It™ **High Performance** Cloth, Yellow PN50400



Dry Sanding

1. Sand with 3M[™] Hookit[™] Purple Finishing Film Disc 260L+ P1200/1500 grade with DA sander. Use 3M™ Hookit™ Soft Interface Pad.

Wet Sanding

1. Sand with 3M™ Trizact™ Hookit™ Clear Coat Sanding Disc grade 1500 with DA sander, use $3M^{\mbox{\tiny M}}$ Hookit[™] Soft Interface Pad. When using 3M[™] Trizact[™] Abrasives, use a light mist of water while sanding to avoid clogging of the disc.

*Dry or Wet Sanding option



Hookit[™] Film Disc 260L+ PN51158 PN51154



3M™ Trizact™ Hookit Clear **Coat Sanding** Disc PN05600



3M™ Hookit™ Soft Interface PN28508 Pad PN51127 10mm



3M™ Sander 152mm 5mm orbit PN28509 152mm 2.5mm orbit

Scratch refinement



Dry Sanding

1. Refine the 1200 grade abrasive sand scratches with 3M™ Hookit™ Flexible Abrasive Foam Disc P2000 grade on DA sander. 2. Clean the surface prior to compounding application.

1. Refine the 1500 grade abrasive sand scratches with 3M™ Trizact™ Hookit™ Foam Abrasive Disc 443S grade 3000 on DA sander, use 3M™ Hookit™ Soft Interface Pad. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc. 2. Clean the surface prior to the compounding application. *Dry or Wet Sanding option



3M™ Hookit™ Flexible Abrasive Foam Discs PN33544



3M™ Trizact™ Abrasive Disc. Pad. 443SA PN50414



3M™ Hookit™ Hookit[™] Foam Soft Interface PN28508 PN51126 PN51127 10mm



152mm 5mm orbit PN28509 152mm 2.5mm orbit

Compounding



1. Compound the abraded surface with 3M™ Perfect-It™ Fast Cut Plus Extreme and $3M^{\mathsf{TM}}$ Perfect- $\mathsf{It}^{\mathsf{TM}}$ Low Linting Wool Compounding Pad or 3M™ Perfect-It™ Green Foam Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's.



Perfect-It[™] Fast Cut Plus Extreme 1kg 865ml PN51815

Perfect-It™ Quick Connect Double Sided Wool Compounding Pad 230mm PN33279

3M™ Quick Connect Adaptor PN05752



3M1 Perfect-It™ **Quick Connect** Double Sided Foam Convoluted Green Compounding Pad

216mm PN50874

Perfect-It™ High Performance Cloth, Yellow PN50400

Polishing



1. Polish compounded surface with 3M™ Perfect-It™ Ultrafina SE Polish and 3M™ Perfect-It™ Wool Polishing Pad or 3M[™] Perfect-It[™] Ultrafine Polishing Pad. Use the rotary polishing machine at a speed of 1400 - 1800 rpm's.



зм™ Perfect-It" Ultrafina SE Polish 11 PN50383



Quick Connect Double Sided Foam Convoluted Blue Polishing Pad PN50708

3M™ Quick Connect Adaptor PN05752



Perfect-It™ Hiah Performance Cloth, Blue PN50486

Protection



1. Apply 3M[™] Perfect-It[™] Boat Wax to protect the surface. When applying Boat Wax, apply in a 10cm x 10cm area and wipe area clean before the wax dries.



3M" Perfect-It™ Boat Wax PN09034E 473ml PN09035E 946ml



3M™ Perfect-It™ High Gloss Polishing Pad PN09378



ЗМ™ Perfect-It™ High Performance Cloth, Blue

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for micron thickness.

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Marine Bottom Paint (Antifouling) **Preparation and Application Process Product List** 1. Clean the surface with approved cleaner to remove and surafcae pollution. 3M™ Perfect-It 3M™ Perfect-It™ Boat Wash **High Performance** PN09034E Cloth, Yellow PN09035E 946ml PN50400 1. Sand the bottom surface using a dual action sander with 3M™ Hookit™ 775L Cubitron™ II 220+ grade to Sanding prepare surface for bottom paint. 2. Clean the repair area with approved cleaner or blow off the repair 3M™ Hookit™ area using pressured air. 3M™ Hookit™ 3M™ Sander Soft Interface Pad 775L Cubitron™ II PN28508 PN51126 PN51127 152mm 5mm orbit PN28509 5mm 10mm Abrasive Discs 1. Mix 3M™ Marine Premium Filler according to manufacturer's specification. 2. Apply 3M™ Marine plication Premium Filler to the repair area making sure to apply a tight coat first. 3. After the filler has cured, sand the repair with 3M™ Hookit™ 775L Cubitron™ II 120+ 3M™ Hookit™ 3M[™] Marine 3M™ Sander Premium Filler 775L Cubitron™ II grade abrasive discs, removing high spots in the PN28508 152mm 5mm orbit repair. 4. Finish by sanding the repair area with 3M™ PN46005 **Abrasive Discs** PN28509 Hookit™ 775L Cubitron™ II 220+ grade abrasive disc. 152mm 2.5mm orbit 1. Ensure that the surface is completely dry prior to applying 3M™ masking products. 2. Taking care to keep the repair area as small as possible, mask the areas that require 3M™ Precision Masking Tape first. 3M™ Purple 3. Mask the rest of the repair, backing up the 3M™ Scotch® 3M™ Precision Masking Tape with masking tape*. Precision Performance Premium Plus 4. Mask entire surface with 3M™ Purple Premium Plus Masking Tape Masking Film Masking Tape Masking Film. PN50988 244 "3M" Performance Industrial Masking Tape 301E or 3M" Scotch® Performance Masking Tape 244 1. Mix bottom paint in appropriate 3M[™] PPS[™] Series 2.0 disposable spray cup, according to manufacturer recommendation. Remember to remove filter in application the lid of disposable paint system 2. Adjust 3M7 3M[™] Performance 3M™ PPS™ Series Performance Spray Gun air pressure, fan and 3M™ Performance Spray Gun fluid setting to achieve desired fan pattern and 2.0 Spray Cup Gravity HVLP atomisation. 3. Hold spray gun 15cm - 20cm away System Atomising Head from surface and apply bottom paint to the repair Red area according to manufacturer's recommendation PN26720

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 in accordance with all applicable instructions and with appropriate safety equipment, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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