



Together, creating the future of care and repair

Marine OEM and Aftermarket Repair

3M Automotive Aftermarket Division



Process for Success

Standard Operating Procedures

From gelcoat, metal and plastic repair to sanding, paint finishing and boat clean-up – 3M has the go-to portfolio and repair processes for you. Feel confident your repair is done professionally and efficiently using our **Standard Operating Procedures**. These time-proven procedures will help you consistently produce quality marine repairs.

For more Standard Operating Procedures, visit our website at **3MMarine.com**

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Additional Information:

For all cleaning steps consult local regulations and use an appropriate VOC compliant product.

General Masking

1



Clean Area

Clean the surface that you will be working on with boat wash.

2



Critical Edge Masking

Mask the areas that require fineline tape first. Mask the rest of the repair and backup the fineline with masking tape.

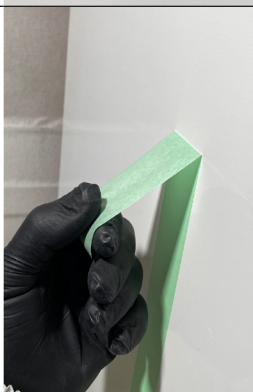
3



Overspray Protection

Ensure that the surface is completely dry before applying plastic sheeting. Mask entire surface with plastic sheeting or masking paper. Tape the plastic sheeting or masking paper directly to critical masking edge.

4



Masking Removal

After applying marine coating, remove the masking tape, pulling it at a 45° angle to the masked surface.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Precision Masking Tape, PN 06620, 1 in. x 60 yds., Sleeve

3M™ Vinyl Tape 471 Blue, PN 36405, 1/4 in.



Scotch® Fine Line Tape 218 Green, PN 06301, 1/4 in. x 60 yds., each

Scotch® Performance Green Masking Tape 233+, PN 26336, 24 mm width (.94 in.)



3M™ Automotive Refinish Masking Tape 388N

PN 06652, 18mm (.71")

PN 06653, 24mm (.94")

PN 06654, 36mm (1.41")

PN 06656, 48mm (1.9")



3M™ Overspray Protective Sheeting,

PN 06727, 12 in. x 400 in., roll

PN 06728, 16 in. x 350 in., roll

PN 06742, 20 in. x 250 in., roll



3M™ Hand Masker™ Pre-Folded Masking Film, PN 6846 72 inch x 90 feet, AMF72

3M™ Hand Masker™ Kit M3000KML, PN 06788

3M™ Precision Masking Tape, PN 06620, 1 in. x 60 yds., Sleeve



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.

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



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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



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Gelcoat Finishing for Lighter OEM Colors

1



Cleaning

Clean the gelcoat surface to remove any contaminants or debris. Follow 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 abrasives. Clean the surface between each sanding step.

3



Buffing

Buff the 800+ grit sand scratch with 3M™ Perfect-It™ Gelcoat Heavy Cutting Compound and a Perfect-It™ Wool Compounding Pad. Set the buffer speed between 1200–2000 Max. RPM. Clean any extra compound off surface with 3M™ Perfect-It™ Detailing Cloth. If final sanding step is 1500 or above, use 3M™ Perfect-It™ Compound + Polish to reduce compound and polish time.

4



Polishing (Optional)

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

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



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

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



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.

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.

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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



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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.

Gelcoat Finishing – Light Oxidation Removal

For lightly oxidized gelcoat or polishing the surface

1



Cleaning

Clean the surface that you will be working on with 3M™ Perfect-It™ Boat Wash.

2



Oxidation Removal

Apply 3M™ Perfect-It™ Gelcoat Light Cutting Polish + Wax using a microfiber detail cloth to a 2' x 2' area. Wipe the surface clean and inspect to ensure that you have removed all surface oxidation. Re-apply and re-work as necessary to remove all surface oxidation on the gelcoat. If desired, 3M™ Perfect-It™ Gelcoat Light Cutting Polish + Wax can also be used with a buffer and a yellow wool buffing pad. Set the buffer speed between 1200 – 2000 Max. RPM.

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Product List

3M™ Perfect-It™ Detail Cloth,
PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



3M™ Perfect-It™ Gelcoat
Light Cutting Polish + Wax,
36110, Quart



3M™ Perfect-It™ Wool Polishing
Pad, 05754, 9 in.

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



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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.

Gelcoat Finishing – Medium Oxidation Removal

For faded or medium oxidized gelcoat

1



Cleaning

Clean the surface that you will be working on with 3M™ Perfect-It™ Boat Wash.

2



Oxidation Removal

Apply 3M™ Perfect-It™ Gelcoat Medium Cutting Compound + Wax using a microfiber detail cloth to a 2' x 2' area. Wipe the surface clean and inspect to ensure that you have removed all surface oxidation. Re-apply and re-work as necessary to remove all surface oxidation on the gelcoat.

If desired, 3M™ Perfect-It™ Gelcoat Medium Cutting Compound + Wax can also be used with a buffer and a white or yellow wool buffing pad. Set the buffer speed between 1200 – 2000 Max. RPM.

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Product List

3M™ Perfect-It™ Detail Cloth,
PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



3M™ Perfect-It™ Gelcoat
Medium Cutting Compound +
Wax, 36106, Quart



3M™ Perfect-It™ Wool Polishing
Pad, 05754, 9 in.

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



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



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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



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Gelcoat Finishing – Heavy Oxidation Removal

For chalky and heavily oxidized gelcoat

1



Cleaning

Clean the surface that you will be working on with 3M™ Perfect-It™ Boat Wash.

2



Sanding (Optional)

Depending on the condition of the gelcoat, sanding prior to buffing may be necessary. For small areas, wet sand the gelcoat surface with an Ultrafine Softback Sanding Sponge to remove surface oxidation. Apply medium pressure when sanding the oxidized gelcoat surface.

For large areas or the majority of the boat, use a dual-action sander with 800 grit abrasive initially, with the DA set to medium speed. When sanding, abrade the surface with a 50% overlap on each pass with a dual-action sander. Remember to use a soft interface pad when sanding with the 800 grit or finer abrasive. Follow-up the 800 grit with 1500 grit.

3



Buffing

To remove sand scratches, buff the sanded gelcoat area with 3M™ Perfect-It™ Gelcoat Heavy Cutting Compound and a white wool buffing pad. Set the buffer speed between 1200 – 2000 Max. RPM.

4



Polishing (Optional)

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.

5



Protection

Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying wax, apply in a 2' x 2' area and wipe area clean before the wax dries. Do not allow the wax to dry or haze on the gelcoat.

Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Purple Finishing Film Hookit™ Disc, 30670, 6 in., P800 grit



3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 02088, 6 in., P1500 grit



3M™ Softback Sanding Sponge, 02600, 4 1/2 in. x 5 1/2 in., Microfine



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



3M™ Perfect-It™ 100%Wool Compounding Pad, 05753, Double Sided, Quick Connect



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



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

3M™ Perfect-It™ Boat Wax, PN 36113, Quart



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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



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Gelcoat Application

1



Cleaning

Pressure wash the repair area. Clean the repair area with 3M™ Perfect-It Boat Wash or an approved cleaner to remove any inorganic materials.

2



Preparation

Using a DA sander with 80 grit abrasive sand the old oxidized gelcoat. Apply dry guide coat to surface and re-sand gelcoat to ensure even texture of surface being repaired. Clean the repair area with a recommended VOC compliant cleaner.

3



Masking

Mask the repair area to contain the repair to as small of a repair as possible.

4



Spray Gun Set Up

Mix gelcoat in appropriate size disposable lid and liner. Remember to remove the filter in the lid of the disposable paint system. Mix gel coat according to manufacturer recommendation. Adjust the air pressure setting, fan setting, and fluid setting on the spray gun to achieve the desired fan pattern and atomization.

5



Application

Hold the spray gun 6" - 8" away from the repair area and pull the trigger. Apply gel coat according to manufacturer's recommendation for mil thickness.

6



Gelcoat Finishing

For gelcoat finishing process please refer to page 12.

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Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Hookit™ Clean Sanding disc, PN 31371, 6 in, 80+ grit, 50 discs/box

3M™ Dry Guide Coat, PN 05861, 6 per case

3M™ Random Orbital Sander - Elite Series, PN 28516, 6", Self-Generated Vacuum (SGV)

3M™ Clean Sanding Filter Bag, PN 20452, Large, 10 per inner, 50 per case

3M™ Precision Masking Tape, PN 06620

3M™ Hand Masker™ Pre-Folded Masking Film, PN 06848

3M™ Scotchblok™ Masking Paper, PN 06732

Coming soon - 3M™ Performance Industrial Spray Gun System, PN 26878, 2 Kits/Case

Coming soon - 3M™ Performance Spray Gun, PN 26832

3M™ Accuspray™ Spray Gun Kit HGP, PN 16587

3M™ PPS™ Series 2.0 Spray Cup System,
PN 26024 Large, 28oz, 850mL
PN 26112 Midi, 13.5oz, 400 mL

3M™ PPS™ Series 2.0 Type H/O Pressure Cup
PN 26124 Large - 28 oz
PN 26121 Midi - 13.5 oz

3M™ Accuspray Atomizing Head Refill Pack Kit
PN 26618, Clear Transparent, 1.8 mm, 4 Pack
PN 26620, Red, 2.0 mm, 4 Pack



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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.

Gelcoat Finishing – Professional Refinishing

1



Cleaning

Clean the gelcoat surface to be repaired with 3M™ Perfect-It™ Boat Wash.

2



Sanding

Sand gelcoat surface, beginning with the least aggressive grit possible, on a dual-action sander. Set the dual-action sander at a medium speed. When sanding, abrade the surface with a 50% overlap on each pass. Remember to use a soft interface pad when sanding with the 800 grit abrasive.

3



Sand Scratch Refinement

Refine the sand scratch with a 1500+ grit abrasive. Use 1500+ grit abrasive with a dual-action sander running at a medium speed. Use a 50% overlap with each pass of the sander. Remember to use a soft interface pad with 1500+ grit abrasive.

4



Buffing

Buff the 1500+ grit sand scratch with 3M™ Perfect-It™ Gelcoat Compound + Polish and a wool buffing pad. Set the buffer speed between 1200 – 2000 Max. RPM.

5



Protection

Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying wax, apply in a 2' x 2' area and wipe area clean before the wax dries. Do not allow the wax to dry or haze on the gelcoat.

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Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Purple Finishing Film Hookit™ Disc, 30670, 6 in., P800 grit



3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 02088, 6 in., P1500 grit



3M™ Hookit™ Soft Interface Pad, 05777, 6 in. x 1/2 in. x 3/4 in.



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

3M™ Perfect-It™ 100% Wool Compounding Pad, PN 05753, Double Sided, Quick Connect



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

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

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



3M™ Perfect-It™ Boat Wax, PN 36113, Quart



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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.

Paint Finish Large Surface Area Process

1		Initial Defect Removal Texture Match DA sand the repair area with a P1500/P2000 3M™ Purple Finishing Film Hookit™ Disc or P1500 3M™ Trizact™ Clearcoat Sanding Disc used damp. Remove all paint defects and match texture to adjacent OEM panels. Wipe clean with a yellow microfiber cloth.
2		Scratch Refinement 3000 Refine the P1500/P2000 scratches with a DA and a 3000 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe clean with a yellow microfiber cloth.
3		Scratch Refinement 5000 (Optional) To reduce your buffing time refine the 3000 scratches with a DA and a 5000 grit 3M™ Trizact™ Hookit™ Foam Disc used damp with a 3M™ Hookit™ Soft Interface Pad. Wipe clean with a yellow microfiber cloth. The use of 3000 is required prior to 5000 for best results.
4		Compound Compound the repair area with a high speed polisher set between 1200–2000 RPM. For faster results, use a foam compounding pad and the appropriate rubbing compound. To insure all sand scratches have been removed, inspect the surface by spraying with an inspection spray and wipe clean with a yellow microfiber cloth.
5		Machine Polish Polish the repair area with a high speed polisher set between 1200–2000 RPM. Use a black foam polishing pad and the appropriate machine polish. Wipe the panel clean with a yellow microfiber cloth.
6		Ultrafine Machine Polish Polish the repair area with a high speed polisher with the speed set between 1200–2000 RPM. Use a blue foam polishing pad and the appropriate ultrafine machine polish. Leave a light film of the polish on the panel and wipe clean with a blue microfiber cloth.
7		Final Detail Remove any masking material from the repair area and clean any residual sling from adjacent panels and door jamb areas. Cleaning the panel immediately after compounding and polishing will greatly improve the ease of cleaning. Inspect the surface using the 3M™ PPS™ SUN GUN™ II Light Kit.

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Product List

3M™ Purple Finishing Film Hookit™ Disc, 6 in., P1500, PN 30667; P2000, PN 30666

3M™ Trizact™ Hookit™ Clearcoat Sanding Disc, 6 in., P1500, PN 02088

Festool D150 Thin Interface Pad, PN 29939

3M™ Trizact™ Hookit™ Foam Disc, 6 in., 3000, PN 02085; 6 in., 5000 grit, PN 30662

3M™ Perfect-It™ EX AC Rubbing Compound, 1 qt., PN 36060

3M™ Perfect-It™ Foam Compounding Pad, Double Sided, Quick Connect, 9 in., PN 05706

3M™ Perfect-It™ Low Linting 100% Wool Compound Pad, Double Sided, Quick Connect, PN 33279

3M™ Quick Connect Adaptor, 14mm. Thread, PN 33271

3M™ Perfect-It™ EX Machine Polish, 1 qt., PN 06094

3M™ Perfect-It™ Foam Polishing Pad, Double Sided, Quick Connect, 9 in., PN 05707

3M™ Inspection Spray, 1 gallon, PN 06082

3M™ Perfect-It™ EX Ultrafine Machine Polish, 1 qt., PN 06068

3M™ Perfect-It™ Ultrafine Foam Polishing Pad, Double Sided, Quick Connect, 9 in., PN 05708

3M™ Perfect-It™ Detail Cloth, PN 06016; PN 06020

3M™ PPS™ SUN GUN™ II Light Kit, PN 16550

3M™ Perfect-It™ Clean and Shine, 16 fl. oz. bottle, PN 06084

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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.

Paint Finish Small Surface Area Process

1		Initial Defect Removal DA sand the repair area with a 3 in. P1500 finishing film disc, removing all paint defects. Wipe clean with a yellow microfiber cloth. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc.
2		Scratch Refinement P3000 Refine the P1500 scratches with a DA and a 3 in. P3000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. Wipe clean with a yellow microfiber cloth.
3		Scratch Refinement 5000 (Optional) Refine the P3000 scratches with a DA and a 3 in. 5000 3M™ Trizact™ Foam Disc used damp with a soft interface pad. To thoroughly remove previous scratches go over each area five times. The use of P3000 is required prior to 5000 for best results. Wipe clean with a yellow microfiber cloth.
4		Buff Compound the repair area with a 3 in. polisher. Use a 3 in. foam compound pad and the appropriate rubbing compound. Wipe clean with a yellow microfiber cloth.
5		Polish Polish the repair area with a 3 in. polisher. Use a 3 in. black foam polishing pad and the appropriate machine polish. Wipe panel clean with a yellow microfiber cloth.
6		Swirl Elimination Ultrafine polish the repair area with a 3 in. polisher. Use a 3 in. blue foam polishing pad and ultrafine machine polish. Leave a light film of polish on the surface and wipe the panel clean with a blue microfiber cloth.
7		Final Detail Clean sling from adjacent panels and door jamb areas. Doing this immediately after the repair will greatly improve the ease of this step.

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Product List

3M™ Trizact™ Hookit™ Clear Coat Sanding Disc, 3 in., P1500 grit, PN 02094



3M™ Purple Finishing Film Hookit™ Disc, 3 in., P1500 grit, PN 30367



3M™ Hookit™ Soft Interface Pad, 3 in., PN 05771



3M™ Pistol Grip Disc Sander, PN 33577



3M™ Trizact™ Hookit™ Foam Disc, 3 in., 3000 grit, PN 02087; 5000 grit, PN 30362



3M™ Perfect-It™ EX AC Rubbing Compound, 1 qt., PN 36060



3M™ Perfect-It™ Foam Compounding Pad, Single Sided with Inset, Hookit™ Attachment, 4 in., PN 30041



3M™ Perfect-It™ EX Machine Polish, 1 qt., PN 06094



3M™ Perfect-It™ Foam Polishing Pad, Single Sided with Insert, Hookit™ Attachment, 4 in., PN 30042



3M™ Perfect-It™ Jumbo Detailing Cloth, PN 06018



3M™ Perfect-It™ EX Ultrafine Machine Polish, 1 qt., PN 06068



3M™ Perfect-It™ Ultrafine Foam Polishing Pad, Single Sided with Insert, Hookit™ Attachment, 4 in., PN 30043



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.

Bottom Paint Small Area Repair

1



Cleaning

Pressure wash the repair area. Clean the repair area with boat wash or a recommended VOC compliant cleaner to remove all organic and inorganic materials from the repair area. Cover the boat to protect from dust and debris.

2



Removal

Use a dual-action sander to abrade the old bottom coating, removing any loose paint. Clean the repair area with a recommended VOC compliant cleaner, or blow off the repair area.

3



Protection

Mask all areas needing protection during bottom paint application.

4



Spray Gun Set Up

Pour the bottom paint into the disposable lid and liner to be used with your spray gun. Remember to remove the filter from the lid of the disposable paint system. Adjust the fan, fluid, and air pressure settings to achieve the desired fan pattern size and atomization.

5



Application

Holding the spray gun 6" - 8" from the repair area pull the spray gun trigger and apply bottom paint to the repair area. Apply bottom paint with a 1.8 mm or 2.0 mm atomizing spray nozzle. Apply bottom paint according to bottom paint manufacturers recommendation for mil thickness.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Cubitron II™ Hookit™ Clean Sanding disc, PN 31371, 6 in, 80+ grit, 50 discs/box

3M™ Cubitron II™ Hookit™ Clean Sanding disc, PN 31370, 40+ grit, 25 discs/box



3M™ Random Orbital Sander - Elite Series, PN 28516, 6", Self-Generated Vacuum (SGV)



3M™ Clean Sanding Filter Bag, PN 20452, Large, 10 per inner, 50 per case

Coming Soon - 3M™ Performance Industrial Spray Gun System, PN 26878, 2 Kits/Case

Coming Soon - 3M™ Performance Spray Gun, PN 26832

3M™ Accuspray™ Spray Gun Kit HGP, PN 16587 - coming soon

3M™ PPS™ Series 2.0 Spray Cup System, PN 26024 Large, 28oz, 850mL
PN 26112 Midi, 13.5oz, 400 mL

3M PPS Series 2.0 Type H/O Pressure Cup
PN 26124 Large - 28 oz
PN 26121 Midi - 13.5 oz

3M Accuspray Atomizing Head Refill Pack Kit
PN 26618, Clear Transparent, 1.8 mm, 4 Pack
PN 26620, Red, 2.0 mm, 4 Pack



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.

Varnish Finishing

1		Clean the Repair Area Clean the surface that you will be working on with boat wash. Use denatured alcohol not mineral spirits.
2		Masking Mask all areas needed to protect from unwanted abrasions.
3		Sanding Sand with a 1500 grit abrasive disc with dual-action sander set at medium speed. Use 1500 grit abrasive with a soft interface pad. Use 1500 grit abrasive disc wet. Use a spray bottle filled with water to spray the abrasive disc as well as the surface to be sanded maintaining a wet surface to sand.
4		Scratch Refinement Refine the 1500 grit abrasive sand scratches with a 3000 grit abrasive on a dual-action sander set at a medium speed. Use 3000 grit abrasive with a soft foam interface pad. Use 3000 grit abrasive damp. Use a spray bottle of water to mist the abrasive disc and the surface to be sanded keeping the surface to be sanded damp. After sanding steps rinse the surface with water to remove debris. Refine the P3000 scratches with a DA and a 5000 Trizact™ Foam disc used damp with a soft interface pad. Wipe surface clean with yellow microfiber cloth as necessary.
5		Compound Remove 3000 grit abrasive sand scratches with rubbing compound and a white wool buffing pad. Set the buffer speed at 1400 - 1800 RPM's.
6		Machine Polish Polish the repair area with a high speed polisher set between 1400 - 1800 RPM's. Use a black foam polishing pad and the appropriate machine polish. Wipe surface clean with a yellow microfiber cloth.
7		Ultrafine Machine Polish Remove ultra fine swirl marks with ultra fine machine polish and a blue foam polishing pad. Set the buffer speed at 1400 - 1800 RPM's. Wipe the surface clean with a yellow microfiber cloth.
8		Protection Apply boat wax to protect the surface. When applying boat wax, apply in a 2' x 2' area and wipe area clean before the wax dries.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Detail Cloth, PN 06016, 6 cloths/bag

3M™ Perfect-It™ Boat Wash PN 09035, 1 Quart



3M™ Random Orbital Sander - Elite Series, PN 28516, 6", Self-Generated Vacuum (SGV)



3M™ Trizact™ Hookit™ Foam Disc, PN 02085, 6 in, P3000 grit, 15 discs per box



3M™ Hookit™ Soft Interface Pad, PN 05777, 6 in

3M™ Trizact™ Hookit™ Foam Disc, PN 30362, 3 in, 5000, 15 discs per



3M™ Perfect-It™ 3M™ Perfect-It™ EX AC, PN36060, 1 qt, 946mL

3M™ Perfect-It™ 100% Wool Compound Pad, Quick Connect, PN05753, double sided, 9 in.



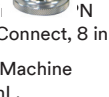
3M™ Perfect-It™ Low Linting 100% Wool Compounding Pad, PN33279, 9 in, 6 per case



3M™ Quick Connect Adaptor, PN05752, 5/8 in. thread



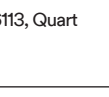
3M™ Perfect-It™ EX Machine Polish, PN06094, 1 qt, 946m



3M™ Perfect-It™ Foam Polish, PN 05707, double sided, Quick Connect, 8 in.



3M™ Perfect-It™ EX Ultrafine Machine Polish, PN 06068, 1 qt, 946mL.



3M™ Perfect-It™ Ultrafine Foam Polishing Pad, PN 05708, double sided, Quick Connect, 8 in.



3M™ Perfect-It™ Boat Wax, 36113, Quart



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.

Repair - Minor Blister

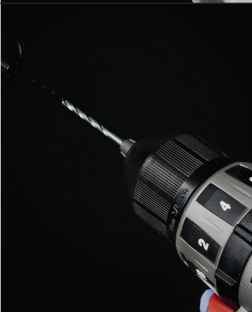
1



Cleaning

Pressure wash the repair area. Clean the repair area with boat wash. Clean the repair area with a cleaner to remove stubborn marks, spots, and stains. Inspect and mark the blisters that will be repaired.

2



Dry Blister Repair area

Puncture the blister with a small drill. Dry the blister completely with a lamp or direct sunlight. Be sure the blister is completely drained and dry before moving to the next step.

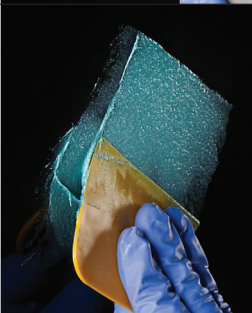
3



Grind Blister

Using a 80 grit Roloc™ abrasive grind the blister. Grind an area of 1" - 2" beyond the blistered area. Bevel the edge of the blister repair. Remove any loose fiberglass from the repair area. Clean the repair area with acetone.

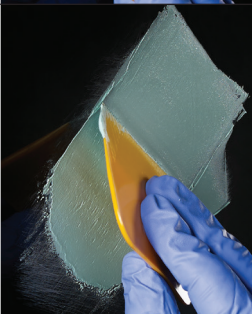
4



Filler Application

Mix vinyl ester reinforced fiberglass repair putty per manufacturer's recommendation. Apply Vinyl Ester fiberglass reinforced repair putty to the repair area. First apply a tight coat then apply filling coats. Fill the cavity 85% to allow for premium vinyl ester filler to be applied. After 30 minutes feather the repair with 80 grit sand paper. Apply dry guide coat to surface and re-sand gelcoat to ensure even texture of surface being repaired. Clean the repair area with acetone, a VOC compliant cleaner, or blow off the repair area.

5



Final Filler Application

Mix premium vinyl ester fairing filler according to manufacturer's specification. Apply the premium vinyl ester filler to the repair area making sure to apply a tight coat first. After filler has cured sand the repair with 80grit abrasives removing high spots in the repair. Finish sand the repair area with 220 grit abrasive.

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Product List

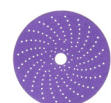
3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart

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



3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in., 80 grade

3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in.



3M™ Marine High Strength Repair
Filler, PN 46014, 1 gal, 4 per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31371, 6 in, 80+ grade, 50
discs per carton, 4 cartons per case 20 discs/
box

3M™ Spreader Assortment, PN 05844,
3 per package, 24 per case

3M™ Dry Guide Coat, PN 05861,
6 per case



3M™ Cubitron™ II Hookit™ Clean
Sanding Discs, 31481, 6 in, 220+
grade, 50 discs per carton,
4 cartons per case

3M™ Marine Premium Filler, PN
46006, 1 gal, 4 per case



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.

Repair - Severe Blister

1



Cleaning

Pressure wash the surface. Clean the repair area with boat wash to remove all organic material. Clean the repair area with a cleaner to remove stubborn marks, spots, and stains. Inspect and mark the blisters that will be repaired

2



Dry Blister Repair Area

Puncture the blister with a small drill. Dry the blister completely with a lamp or direct sunlight. Be sure the blister is completely drained and dry before moving to the next step.

3



Grind Blister

Using a 80 grit Roloc™ abrasive, grind the surface of 1" - 2" beyond the blistered area. Bevel the edge of the blister repair. Remove any damaged fiberglass from the repair. Clean the repair area with acetone.

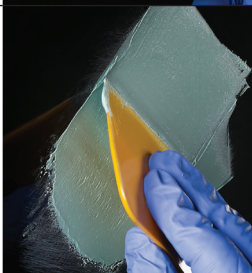
4



Laminate Replacement

Cut small fiberglass patch for deepest part of the repair. Cut larger fiberglass patches to apply over smaller patches as you rebuild the structural re-enforcement that was removed when the blister was ground out. Mix the fiberglass resin per the manufacturer's recommendation. Brush on the mixed resin and lay fiberglass on the first fiberglass patch. Push out all the air bubbles and completely wet the fiberglass patch. Immediately apply additional fiberglass patches necessary to reinstate structural integrity. After the fiberglass resin has cured, sand the repair area with 80 grit abrasive to level the repair. Feather sand the repair with 220 grit abrasive.

5



Final Filler Application

Mix premium vinyl ester fairing filler according to manufacturer's specification. Apply the premium vinyl ester filler to the repair area making sure to apply a tight coat first followed by build coats. After filler has cured, sand the repair with 80 grit abrasives removing high spots in the repair. Finish sand the repair area with 220 grit abrasive.

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Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 qt

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



3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in, 80 grade

3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in



3M™ Fiberglass Resin, PN 05834,
1 gal, 4 per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, PN 31371, 6 in, 80+ grade,
50 discs per carton, 4 cartons per case

3M™ Fiberglass Mat, PN 05837, 8 square ft.

3M™ Spreader Assortment, PN 05844,
3 per package, 24 per case



3M™ Cubitron™ II Hookit™ Clean
Sanding Discs, PN 31481, 6 in,
220+ grade, 50 discs per carton,
4 cartons per case

3M™ Marine Premium Filler,
PN 46006, 1 gal, 4 per case



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.

Repair - Cracked or Shattered Fiberglass (Back side)

If back side of the repair is accessible.

1



Cleaning

Clean the back side of the repair with boat wash. Additionally, clean the back side of the repair with a cleaner to remove stubborn marks, spots, and stains.

2



Sanding/Grinding

Grind the damaged area using 80 grit Roloc™ abrasives and grind 2" - 3" beyond the repair area. Clean the repair area with acetone prior to moving to next step making sure all debris and contaminants are removed.

3



Reinstate Structural Integrity

Cut fiberglass patches 2" - 3" larger than the damaged area to use as a backer. Apply 3 - 4 fiberglass patches, depending on the size of the repair, to reinstate structural integrity. Mix fiberglass resin per manufacturer's recommendation. Apply mixed fiberglass resin to fiberglass patches, completely wetting the fiberglass patches. Continue for additional patches that need to be applied. Allow fiberglass resin to cure according to manufacturer's recommendation.

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Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 qt

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

3M™ Perfect-It™ Detail Cloth,
PN6016, 6 cloths/bag



3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in, 80 grade

3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in.



3M™ Fiberglass Mat, PN 05837, 8 square ft.

3M™ Fiberglass Resin, PN 05834, 1 gal, 4 per case



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.

Repair - Cracked or Shattered Fiberglass (Front side)

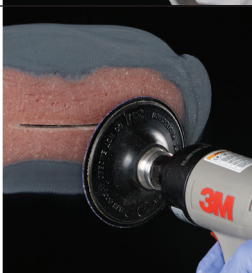
1



Cleaning

Pressure wash the boat to remove any fouling that has collected. Clean the repair area with boat wash. Additionally, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

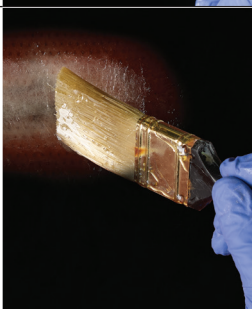
2



Grinding

Using an 80 grit Roloc™ abrasive grind out the damaged fiberglass area. Extend the repair 2" - 3" beyond the repair. Bevel the edge of the repair. Remove all loose and damaged fiberglass.

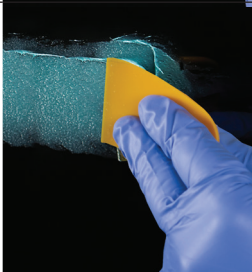
3



Reinstate Structural Integrity

Cut 3-4 pieces of fiberglass mat in varying sizes from small to large patches depending on the size and depth of the repair. Place the smallest patches in the deepest part of the repair and larger patches in the shallowest part of the repair area. Mix and apply fiberglass resin per manufacturer's recommendations. Be sure to roll out all air bubbles. Allow fiberglass resin to cure according to manufacturer's recommendation. Sand the repair area with an 80 grit Roloc™ abrasive to create a bonding surface for the reinforced filler.

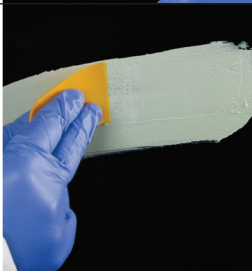
4



Reinforced Filler/ Structural Filler Application

Mix and apply high strength filler per manufacturer's recommendation. First apply a tight coat making sure all micro pinholes and voids are filled. Apply additional coats of filler to build up the repair. Sand the area with 80 grit abrasive to feather the high strength filler. Clean the repair area with clean dry air.

5



Final Filler/ Finishing Filler Application

Mix and apply premium filler per manufacturer's recommendation. First apply a tight coat of filler making sure to fill in all pinholes and voids. Allow premium filler to cure according to manufacturer's recommendation. Apply additional coats to build repair. Sand and feather the filler with 80 grit abrasive. Finish sand the repair with 180/220 grit abrasives if applying gelcoat. Finish sand the repair.

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Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart

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



3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in, 80 grade

3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in.



3M™ Fiberglass Resin, PN 05834, 1 gal., 4 per case

3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive
Disc, 31371, 6 in, 80+ grade, 50 discs per carton, 4
cartons per case

3M™ Fiberglass Mat, PN 05837, 8 square ft.

3M™ Spreader Assortment, PN 05844,
3/package, 24 per case



3M™ Marine Premium Filler,
PN 46006, 1 gal, 4 per case

3M™ Cubitron™ II Marine Sanding Disc,
PN 31379, 6 in., 80+grit, 20 discs/box

3M™ Cubitron™ II Hookit™ Clean Sanding
Discs, 31481, 6 in, 220+ grade, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31483, 6 in, 320+, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31484, 6 in, 400+, 50 discs per
carton, 4 cartons per case



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.

Repair - 2 Sided Small to Medium Hole

Above/Below the Waterline - Back side Accessable

1



Cleaning

Pressure wash the boat. Clean the repair area with boat wash. If needed, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

2



Grinding

Sand the back side of the repair area with 80 grit Roloc™ abrasive. Sand 2" - 3" around the area to be repaired. Clean the repair using a VOC compliant cleaner.

3



Reinstate Structural Integrity

Cut fiberglass patches to expand 2" - 3" beyond the damaged area as a backer. Apply 3 - 4 fiberglass patches depending on the size of the repair to reinstate structural integrity. Mix fiberglass resin per manufacturer's recommendation. Apply mixed fiberglass resin to patches, completely wetting out the patch and making sure there are no air pockets or air bubbles under the patch. Continue for additional patches that need to be applied. Allow fiberglass resin to cure according to manufacturer's recommendation.

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Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



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

3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in, 80 grade



3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in



3M™ Fiberglass Mat, PN 05837, 8 square ft.

3M™ Fiberglass Resin, PN 05834, 1 gal., 4 per case



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.

Repair - 2 Sided Small to Medium Hole

Above/Below the Waterline - Front side

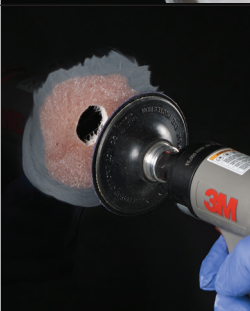
1



Cleaning

Pressure wash the boat to remove any fouling that has collected. Clean the repair area with boat wash. Additionally, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

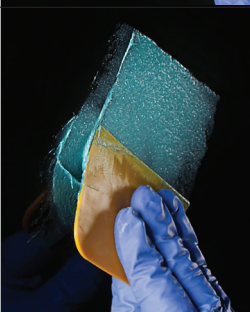
2



Grinding

Grind the repair area with an 80 grit Roloc™ abrasive. Grind 2"- 3" beyond the repair area. Bevel the edge of the hole to be repaired. Clean the repair area with an approved VOC compliant cleaner.

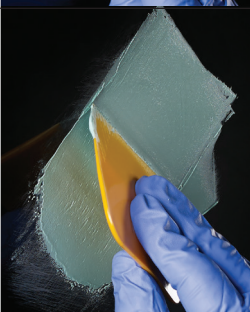
3



Reinstate Structural Integrity

Mix and apply reinforced repair filler according to the manufacturer's recommendation. Allow reinforced repair filler to cure according to manufacturer's recommendation. Sand and feather with 80 grit abrasive. Clean the repair area with an approved cleaner.

4



Finishing Filler Application

Mix and apply premium filler according to manufacturer's recommendation. Allow filler to cure according to manufacturer's recommendation. Sand the filler with 80 grit abrasive and feather the repair with 180/220 grit abrasive for gelcoat. Feather the repair with 320/400 grit abrasive for paint. Clean the repair area with an approved cleaner.

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Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



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

3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in, 80 grade

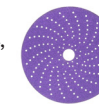


3M™ Disc Sander, Pistol Grip,
PN 33577, 3 in.



3M™ Cubitron™ II Clean Sanding Hookit™ Abrasive
Disc, 31371, 6 in, 80+ grade, 50 discs per carton, 4
cartons per case

3M™ Spreader Assortment, PN 05844,
3/package, 24 per case



3M™ Marine Premium Filler,
PN 46006, 1 gal, 4 per case

3M™ Marine High Strength Repair
Filler, PN 46014, 1 gal, 4 per case

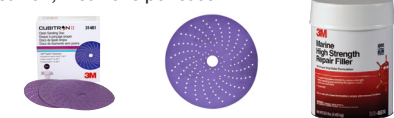


3M™ Cubitron™ II Marine Sanding
Disc, PN 31379, 6 in., 80+grit, 20 discs/box

3M™ Cubitron™ II Hookit™ Clean Sanding
Discs, 31481, 6 in, 220+ grade, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31483, 6 in, 320+, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31484, 6 in, 400+, 50 discs per
carton, 4 cartons per case



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.

Small Hole Above Waterline

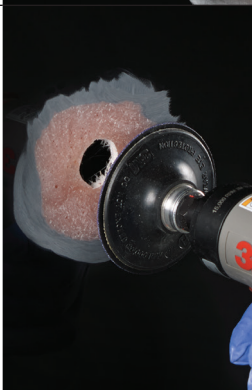
1



Cleaning

Pressure wash the repair area to remove any fouling that has collected. Clean the repair area with boat wash. Additionally, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

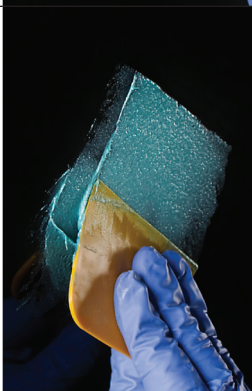
2



Sanding

Tape the back side of the repair using 2" masking tape to create a backing for the filler. Hand sand, block sand, or grind the front side of the repair with 80 grit abrasive beveling the repair area. Clean the repair area with an approved cleaner.

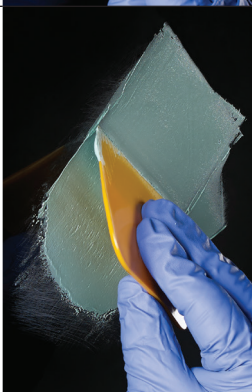
3



Reinstate Structural Integrity

Mix and apply reinforced filler according to manufacturer's recommendation. Allow filler to cure according to manufacturer's recommendation. Sand and feather the repair with 80 grit abrasive. Clean the repair area to remove all sanding dust.

4



Finishing Filler Application

Mix and apply finishing filler according to manufacturer's recommendation. Allow filler to cure according to manufacturer's recommendation. Sand with 80 grit abrasive to knock down any high spots or rough edges. Feather the repair with 180/220 grit abrasive for gelcoat. Feather the repair with 320/400 grit abrasive for paint.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart

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



3M™ Imperial™ Roloc™ Disc,
PN 33392, 3 in., 80 grade



3M™ Disc Sander, Pistol Grip, PN 33577, 3 in.

3M™ Aluminum Foil Tape 425, Silver, 2 in. x
60 yd., 4.6 mil, PN 95072



3M™ Marine High Strength Repair Filler,
PN 46014, 1 gal,

4 per case 3M™ Cubitron™ II Clean Sanding
Hookit™ Abrasive Disc, 31371, 6 in, 80+ grade, 50
discs per carton, 4 cartons per case

3M™ Spreader Assortment, PN 05844,
3/package, 24 per case

3M™ Marine Premium Filler, PN 46006,
1 gal, 4 per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31371, 6 in, 80+ grade, 50
discs per carton, 4 cartons per case

3M™ Cubitron™ II Hookit™ Clean Sanding
Abrasive Disc, 31374, 6 in, 180+, 50 discs per
box, 4 boxes per case

3M™ Cubitron™ II Hookit™ Clean Sanding
Discs, 31481, 6 in, 220+ grade, 50 discs per
carton, 4 cartons per case

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.

Gouge Above Waterline

1



Cleaning

Pressure wash the repair area to remove any fouling that has collected. Clean the repair area with boat wash. Additionally, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

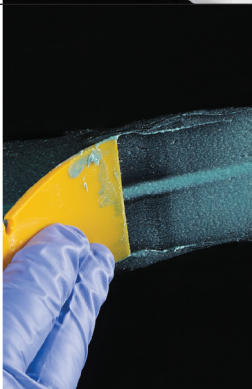
2



Sanding

Block or hand sand with 80 grit abrasive. Dish out/bevel the repair area. Clean the repair area with an approved cleaner.

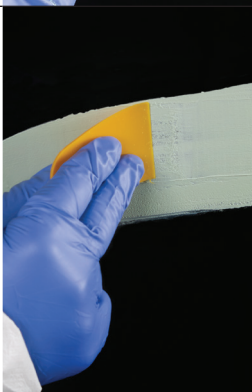
3



Reinstate Structural Integrity

Mix and apply milled glass filler according to manufacturer's recommendation. Apply a tight coat first then apply build coats. Allow milled glass filler to cure according to manufacturer's recommendation. Sand and feather the repair area with 80 grit abrasive.

4



Finishing Filler Application

Mix and apply premium filler according to manufacturer's recommendation. Apply a tight coat first then apply build coats. Allow premium filler to cure according to manufacturer's recommendation. Sand the filler with 80 grit abrasive and feather the repair with 180/220 grit abrasive for gelcoat. Feather the repair with 320/400 grit abrasive for paint.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



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

3M™ Cubitron™ II Hookit™ Clean
Sanding Sheet Roll, PN 34440,
40+, 70 mm x 8 m, 1 roll per box,
5 boxes per case



3M™ Marine High Strength
Repair Filler, PN 46014, 1 gal,
4 per case

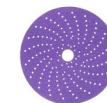


3M™ Spreader Assortment,
PN 05844, 3/package, 24 per case



3M™ Marine Premium Filler,
PN 46006, 1 gal, 4 per case

3M™ Cubitron™ II Clean Sanding
Hookit™ Abrasive Disc, PN 31371,
6 in, 80+ grade, 50 discs per
carton, 4 cartons per case



3M™ Cubitron™ II Hookit™ Clean Sanding
Abrasive Disc, 31374, 6 in, 180+, 50 discs per
box, 4 boxes per case

3M™ Cubitron™ II Hookit™ Clean Sanding Discs,
31481, 6 in, 220+ grade, 50 discs per carton, 4
cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31483, 6 in, 320+, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding
Hookit™ Abrasive Disc, 31484,
6 in, 400+, 50 discs per carton,
4 cartons per case



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.

Cosmetic Scratch

1



Cleaning

Pressure wash the repair area to remove any fouling that has collected. Clean the repair area with boat wash. Additionally, clean the surface with a cleaner to remove stubborn marks, spots, and stains.

2



Sanding

Feather the repair area with 180 grit abrasive by hand sanding or block sanding. Clean the repair area with an approved cleaner.

3



Finishing Filler Application

Mix and apply glaze according to manufacturer's recommendation. Apply a tight coat of glaze first followed by build coats of glaze. Allow glaze to cure according to manufacturer's recommendation. Sand and feather the repair area with 180 grit abrasive followed by 220 grit abrasive for gelcoat. Sand and feather the repair area with 320/400 grit abrasive for paint.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart



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

3M™ Cubitron™ II Hookit™ Clean Sanding
Sheet Roll, 34446, 180+, 70 mm x 12 m,
1 roll per box, 5 boxes per case



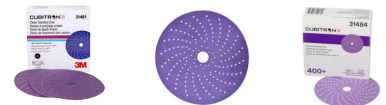
3M™ Cubitron™ II Hookit™
Clean Sanding Abrasive Disc,
31374, 6 in, 180+, 50 discs
per box, 4 boxes per case



3M™ Cubitron™ II Hookit™ Clean Sanding Discs,
31481, 6 in, 220+ grade, 50 discs per carton, 4
cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31483, 6 in, 320+, 50 discs per
carton, 4 cartons per case

3M™ Cubitron™ II Clean Sanding Hookit™
Abrasive Disc, 31484, 6 in, 400+, 50 discs per
carton, 4 cartons per case



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.

Plastic Restoration

1



Clean and Mask

Clean the damage with soap and water. Perimeter mask the lens with two layers of masking tape.

2



Sand to Remove Yellowing & Defects

Dry DA sand the damaged lens with a 3 in. P500 abrasive disc using a soft interface pad. Completely remove any yellowing and/or surface defects.

3



1st Step Scratch Refinement

Refine the P500 sand scratches by dry DA sanding with a 3 in. P800 abrasive disc on a soft interface pad. Wipe the lens clean.

4



2nd Step Scratch Refinement

Refine the P800 sand scratches by DA sanding with a 3 in. P1000 foam abrasive disc on a soft interface pad. Use water to lubricate the P1000 foam abrasive disc. Spend extra time on this step to ensure removal of all P800 sand scratches. Wipe the lens clean.

5



3rd Step Scratch Refinement

Refine the P1000 sand scratches by DA sanding with a 3 in. P3000 foam abrasive disc on a soft interface pad. Use water to lubricate the P3000 foam abrasive disc. Spend extra time on this step to ensure removal of all P1000 sand scratches. Wipe the lens clean.

6



Compound Lens

Completely remove the P3000 sand scratches using a 3 in. polishing tool with a foam compounding pad and rubbing compound. Wipe the lens with a clean microfiber cloth.

7



Polish Lens

Polish the lens using a 4 inch foam polishing pad and machine polish. Wipe the lens with a clean microfiber cloth. Remove the masking tape and inspect for quality.

Visit 3MMarine.com for more SOPs and videos

Product List

3M™ Perfect-It™ Boat Wash
PN 09035, 1 Quart

3M™ Perfect-It™ Detail Cloth,
PN 06016, 6 cloths/bag



3M™ Precision Masking Tape,
PN 06619, 18 in. x 60 yds.
PN 06525, ¼ in. x 60 yds.
PN 06529, ¾ in. x 60 yds.
PN 06526, ¾ in. x 60 yds.
PN 06528, 2 in. x 60 yds.



3M™ Purple Clean Sanding Hookit™ Disc,
PN30272, 3 in, P500, 50 discs per box,
4 boxes per case

3M™ Pistol Grip Disc Sander, 33577,
50mm and 75mm, 18,000 Max. RPM

3M™ Hookit™ Soft Interface Pad,
PN 05771, 3 in., 10 per case

3M™ Orbital Pistol Grip Sander,
PN 28353, 3 in., 1/8 in. Orbit

3M™ Purple Finishing Film Hookit™
Disc, 30370, 3 in, P800, 50 discs
per carton, 4 cartons per case

3M™ Trizact™ Hookit™ Blending
Disc 443A, 02091, 3 in, P1000,
15 discs per box, 4 boxes per case

3M™ Trizact™ Hookit™ Foam Disc 02087, 3 in,
P3000, 15 discs per box, 4 boxes per case



3M™ Perfect-It™ EX AC Rubbing
Compound, PN 36060, 1 qt. (946mL.)

3M™ Perfect-It™ Foam Compounding Pad,
30041, 4 in, single sided with inset, Hookit™,
2 pads per bag, 6 bags per case

3M™ Perfect-It™ EX Machine Polish,
PN 06094, 1 qt. (946mL.)

3M™ Perfect-It™ Hookit™ Foam Polishing Pad,
PN 30042, 4 in, single sided with inset, 2 pads
per bag, 6 bags per case



Think About Your Health

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

3M™ Half Facepiece
Respirator, PN 07182

3M™ Lexa™ Protective
Eyewear, PN 15200



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

3M™ PPS™ Paint Preparation System

Spot Repair



Spot Repair

Micro Cups

Ideal for spot repairs that require 3 fluid ounces of material or less.

Small Repair



Small Repair

Mini Cups

Ideal for small areas that require 6 fluid ounces of material or less.

Medium Size Repair



Medium Size Repair

Midi Cups

Ideal for areas that require 13.5 fluid ounces of material or less.

Large Repair



Large Repair

Standard Cups

Ideal for large areas that require 22 fluid ounces of material or less.

Entire Boat Repair



Entire Boat Repair

Large Cups

Ideal for large jobs that require 28 fluid ounces of material or less.

Visit 3MMarine.com for more SOPs and videos

Product List



3M™ PPS™ Kit Mini, 6 fl oz (180 mL),
Lids and Liners, PN 26114

3M™ PPS™ Kit Midi, 13.5 fl oz (400 mL),
Lids and Liners, PN 26112

3M™ PPS™ Kit Standard, 22 fl oz (650 mL),
Lids and Liners, PN 26000

3M™ PPS™ Kit Micro, 3 fl oz (90 mL),
Lids and Liners, PN 26028

3M™ PPS™ Kit Large, 28 fl oz (850 mL),
Lids and Liners, PN 26024

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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