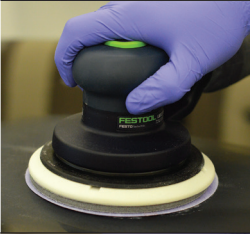


## Paint Finish Large Surface Area Process

1		<b>Initial Defect Removal Texture Match</b> 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		<b>Scratch Refinement 3000</b> 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		<b>Scratch Refinement 5000 (Optional)</b> 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		<b>Compound</b> 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		<b>Machine Polish</b> 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		<b>Ultrafine Machine Polish</b> 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		<b>Final Detail</b> 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.

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

## 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

## 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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