
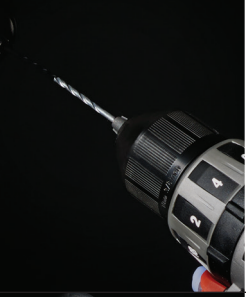


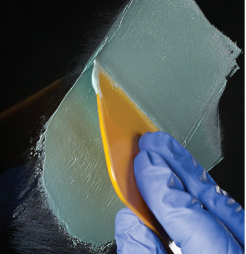


Repair - Severe Blister




1		<p>Cleaning</p> <p>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</p>
2		<p>Dry Blister Repair Area</p> <p>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.</p>
3		<p>Grind Blister</p> <p>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.</p>
4		<p>Laminate Replacement</p> <p>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.</p>
5		<p>Final Filler Application</p> <p>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.</p>

Visit 3MMarine.com for more SOPs and videos

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.

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. 60-4405-0034-0 9/2020