
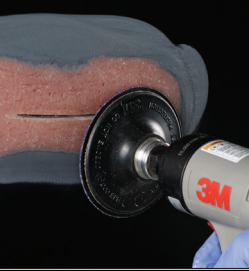

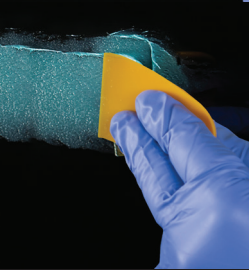



Repair - Cracked or Shattered Fiberglass (Front side)

1		<p>Cleaning</p> <p>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.</p>
2		<p>Grinding</p> <p>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.</p>
3		<p>Reinstate Structural Integrity</p> <p>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.</p>
4		<p>Reinforced Filler/ Structural Filler Application</p> <p>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.</p>
5		<p>Final Filler/ Finishing Filler Application</p> <p>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.</p>

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™ 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



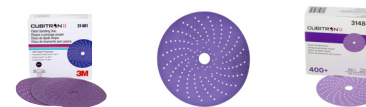
3M™ Marine Premium Filler,
PN 46006, 1 gal, 4 per case

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.

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. 60-4405-0036-5 9/2020