

**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.

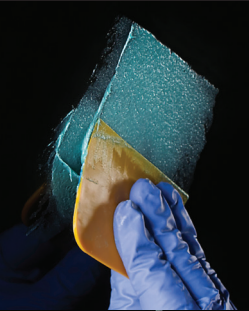
**2**



**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.

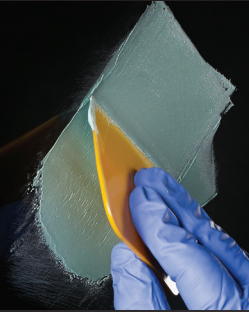
**3**



**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.

Visit [3MMarine.com](http://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™ 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



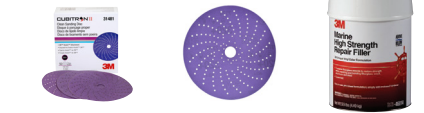
3M™ Marine High Strength Repair Filler, PN 46014, 1 gal, 4 per case

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.

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**3M Automotive Aftermarket Division**  
**3M Center, Building 223-6S-07**  
**St. Paul, MN 55144-1000**  
**U.S.A.**

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