

3M Science.
Applied to Life.™



Standard Operating Procedures

for Marine OEM

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**Think about
your health**

3M™ E-A-R™ Ultrafit™ Earplugs, 32 dB,
Corded, 50 Pairs/Box, UF-01-000



3M™ Maintenance Free Half Mask,
FFA2P3 R D Filters, 4255+



3M™ SecureFit™ 400 Safety Glasses, Black/Green frame,
Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU



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

Gelcoat Surface Preparation and Application Process		Product List
1 Cleaning		<p>1. Clean the new external composite surface with approved cleaner to remove all mold release materials.</p> <p> </p> <p>3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
2 Sanding		<p>1. Sand the old or new gelcoat to remove surface imperfections using a DA sander with abrasive discs 3M™ Hookit™ 775L Cubitron™ II grade 80+. 2. Apply dry guide coat to surface and re-sand gelcoat to ensure an even texture of surface is being repaired. 3. Clean the repair area with approved cleaner or blow off the repair area using pressured air.</p> <p>  </p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p> <p>3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm</p>
3 Filler application		<p>1. If needed, mix 3M™ Marine Blister Repair Filler per manufacturer's recommendation. 2. First apply a tight coat then apply filling coats. Fill 85% of the cavity leaving space for 3M™ Marine Premium Filler to be applied later in the process. 3. After 30 minutes feather the repair with 3M™ Hookit™ 775L Cubitron™ II abrasive disc grade 80+. 4. Apply dry guide coat to surface and re-sand gelcoat to ensure an even texture of surface is being repaired. 5. Clean the repair area with approved cleaner or blow off the repair area using pressured air.</p> <p>  </p> <p>3M™ Marine Blister Repair Filler PN46013</p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p>3M™ Dry Guide Coat PN09650 Black PN50416 Orange</p>
4 Final filler application		<p>1. Mix 3M™ Marine Premium Filler according to manufacturer's specification. 2. Apply 3M™ Marine Premium Filler to the repair area making sure to apply a tight coat first. 3. After the filler has cured, sand the repair with 3M™ Hookit™ 775L Cubitron™ II 120+ grade abrasive discs, removing high spots in the repair. 4. Finish by sanding the repair area with 3M™ Hookit™ 775L Cubitron™ II grade 220+.</p> <p>  </p> <p>3M™ Marine Premium Filler PN46005</p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
5 Masking		<p>1. Ensure that the surface is completely dry prior to applying 3M™ masking products. 2. Taking care to keep the repair area as small as possible, first mask the areas that require 3M™ Precision Masking Tape. 3. Mask the rest of the repair, backing up the 3M™ Precision Masking Tape with masking tape*. 4. Mask entire surface with 3M™ Purple Premium Plus Masking Film.</p> <p>*3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244</p> <p>   </p> <p>3M™ Purple Premium Plus Masking Film PN50988</p> <p>3M™ Precision Masking Tape</p> <p>3M™ Performance Industrial Masking Tape 301E</p> <p>3M™ Scotch® Performance Masking Tape 244</p>
6 Gelcoat application		<p>1. Mix gelcoat in appropriate 3M™ PPS™ Series 2.0 disposable spray cup, according to manufacturer recommendation. Remember to remove filter in the lid of disposable paint system 2. Adjust 3M™ Performance Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply gelcoat to the repair area according to manufacturer's recommendation for micron thickness.</p> <p>  </p> <p>3M™ PPS™ Series 2.0 Spray Cup System PN26832</p> <p>3M™ Performance Spray Gun PN26832</p> <p>3M™ Performance Gravity HVLP Atomising Head Red PN26720</p>
7 Gelcoat finishing		<p>For gelcoat finishing process please refer to the following page.</p>

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Gelcoat Finishing Process*		Product List					
1	Cleaning		1. Clean the new external composite surface with approved cleaner to remove all mold release materials.	  3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml			
2	Sanding		1. If needed, sand gelcoat surface with 3M™ Hookit™ 775L Cubitron™ II 320+ grade abrasive discs and then 400+ finer grit abrasives. Remember to use 3M™ Hookit™ Soft Interface Pad when sanding with the 320+/400+ grade abrasive discs. 2. If surface is in good condition start with P800 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	 3M™ Hookit™ 775L Cubitron™ II Abrasive Discs	 3M™ Hookit™ Flexible Abrasive Foam Discs	 3M™ Hookit™ Soft Interface Pad	 3M™ Sander PN28508 152mm 5mm orbit
3	Sand scratch refinement		1. Refine the P800 grade sand scratch using the P1200 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	 3M™ Hookit™ Flexible Abrasive Foam Discs	 3M™ Hookit™ Soft Interface Pad	 3M™ Sander PN28508 152mm 5mm orbit	
4	Compounding		1. Compound the abraded surface with 3M™ Perfect-It™ Gelcoat Heavy Cutting Compound and 3M™ Perfect-It™ Low Linting Wool Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's.	 3M™ Perfect-It™ Gelcoat Heavy Cutting Compound PN36101 473ml PN36102E 946ml PN36103 3.6L	 3M™ Perfect-It™ Quick Connect Double Sided Wool Com- pounding Pad 230mm PN33279	 3M™ Perfect-It™ High Performance Cloth, Yellow PN50400	
5	Polishing		1. 3M™ Perfect-It™ Gelcoat Compound + Polish and 3M™ Perfect-It™ Low Linting Wool Compounding Pad. Use the rotary polishing machine at a speed of 1400 - 1800 rpm's.	 3M™ Perfect-It™ Gelcoat Compound + Polish PN30344E 946ml PN30345E 3.6L	 3M™ Perfect-It™ Quick Connect Double Sided Wool Com- pounding Pad 230mm PN33279	 3M™ Perfect-It™ High Performance Cloth, Blue PN50486	
6	Protection		1. Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying Boat Wax, apply in a 10cm x 10cm area and wipe area clean before the wax dries.	 3M™ Perfect-It™ Boat Wax PN09034E 473ml PN09035E 946ml	 3M™ Perfect-It™ High Gloss Polishing Pad PN09378	 3M™ Perfect-It™ High Performance Cloth, Blue PN50486	

* Two options (5 or 6 steps)

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Gelcoat Finishing Process*		Product List
1 Cleaning		<p>1. Clean the new external composite surface with approved cleaner to remove all mold release materials.</p> <p> </p> <p>3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
2 Sanding		<p>1. If needed, sand gelcoat surface with 3M™ Hookit™ 775L Cubitron™ II 320+ grade abrasive discs and then 400+ finer grit abrasives. Remember to use 3M™ Hookit™ Soft Interface Pad when sanding with the 320+/400+ grade abrasive discs. 2. If surface is in good condition start with P800 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.</p> <p>   </p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN28508 152mm 5mm orbit</p> <p>3M™ Hookit™ Flexible Abrasive Foam Discs PN51126 5mm PN51127 10mm</p> <p>3M™ Hookit™ Soft Interface Pad PN28509 152mm 5mm orbit</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
3 Sand scratch refinement		<p>1. Refine the P800 grade sand scratch using the P1200 grade 3M™ Hookit™ Flexible Abrasive Foam Discs on a dual action sander. When sanding use a 50% overlap with each pass of the sander.</p> <p>  </p> <p>3M™ Hookit™ Flexible Abrasive Foam Discs PN51126 5mm PN51127 10mm</p> <p>3M™ Hookit™ Soft Interface Pad PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
4 Compounding & Polishing		<p>1. Compound the abraded surface with 3M™ Perfect-It™ Gelcoat Compound + Polish and 3M™ Perfect-It™ Low Linting Wool Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's.</p> <p>  </p> <p>3M™ Perfect-It™ Gelcoat Compound + Polish PN30344E 946ml PN30345E 3.6L</p> <p>3M™ Perfect-It™ Quick Connect Double Sided Wool Compounding Pad 230mm PN33279</p> <p>3M™ Quick Connect Adaptor PN05752</p>
5 Protection		<p>1. Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying Boat Wax, apply in a 10cm x 10cm area and wipe area clean before the wax dries.</p> <p>  </p> <p>3M™ Perfect-It™ Boat Wax PN09034E 473ml PN09035E 946ml</p> <p>3M™ Perfect-It™ High Gloss Polishing Pad PN09378</p> <p>3M™ Perfect-It™ High Performance Cloth, Blue PN50486</p>

* Two options (5 or 6 steps)

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Marine Paint Surface Preparation and Application Process			Product List		
1 Cleaning		1. Clean the surface with approved cleaner to remove and surface pollution.			3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml 3M™ Perfect-It™ High Performance Cloth, Yellow PN50400
2 Sanding		1. Using a DA sander with 3M™ Hookit™ 775L Cubitron™ II 80+ grade abrasive discs, sand the surface to prepare for filler application. 2. Clean the surface with approved cleaner or blow off the repair area using pressured air.			3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN28508 PN28509 3M™ Sander 152mm 5mm orbit 152mm 2.5mm orbit
3 Filler application		1. As an alternative to Epoxy Fillers use mixed 3M™ Marine Premium Filler per manufacturer's recommendation. 2. Apply 3M™ Marine Premium Filler to the surface. 3. After 30 mins (12-24hrs for Epoxy Filler) apply dry guide coat to the surface and sand the filler with 3M™ Hookit™ 775L Cubitron™ II 120+ grade abrasive discs. 4. Apply dry guide coat to surface and re-sand filler to ensure even texture of surface being repaired. 5. Finish by sanding filler with 3M™ Hookit™ 775L Cubitron™ II 220+ grade abrasive discs. 6. Clean the surface with approved cleaner or blow off the surface with pressured air.			3M™ Marine Premium Filler PN46005 3M™ Hookit™ 775L Cubitron™ II Abrasive Discs 3M™ Dry Guide Coat PN09650 PN50416 Black Orange
4 Masking		1. Ensure that the surface is completely dry prior to applying 3M™ masking products. 2. Taking care to keep the repair area as small as possible, mask the areas that require 3M™ Precision Masking Tape first. 3. Mask the rest of the repair, backing up the 3M™ Precision Masking Tape with masking tape*. 4. Mask entire surface with 3M™ Purple Premium Plus Masking Film. *3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244			3M™ Purple Premium Plus Masking Film PN50988 3M™ Precision Masking Tape *3M™ Performance Industrial Masking Tape 301E 3M™ Scotch® Performance Masking Tape 244
5 Primer Application		1. Mix primer in appropriate 3M™ PPS™ Series 2.0 disposable spray cup. 2. Adjust 3M™ Performance Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply primer to the repair area according to manufacturer's recommendation for micron thickness.			3M™ PPS™ Series 2.0 Spray Cup System 3M™ Performance Spray Gun PN26832 3M™ Performance Gravity HVLP Atomising Heads
6 Primer Sanding		1. Apply dry guide coat to surface and sand primer with 3M™ Hookit™ 775L Cubitron™ II 320+ grade abrasive discs to prepare for paint application. 2. Apply dry guide coat to surface. 3. Repeat sanding with 3M™ Hookit™ 775L Cubitron™ II abrasive discs grade 400+. 4. Clean the surface with approved cleaner or blow off the repair area using pressured air.			3M™ Dry Guide Coat PN09650 Black Orange 3M™ Hookit™ 775L Cubitron™ II Abrasive Discs 3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit
7 Marine Paint Application		1. Mix paint in appropriate 3M™ PPS™ Series 2.0 disposable spray cup. 2. Adjust 3M™ Performance Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply paint to the repair area according to manufacturer's recommendation for micron thickness.			3M™ PPS™ Series 2.0 Spray Cup System 3M™ Performance Spray Gun PN26832 3M™ Performance Gravity HVLP Atomising Heads
8 Marine paint finishing		For Marine Paint Finishing process please refer to the following page.			

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Marine Paint and Clearcoat Finishing Process

Product List

1 Cleaning 	OEM* 1. Clean the surface with approved cleaner to remove and surface pollution. <small>*Dry or Wet Sanding option</small>	 3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml  3M™ Perfect-It™ High Performance Cloth, Yellow PN50400
2 Sanding 	Dry Sanding* 1. Sand with 3M™ Hookit™ Purple Finishing Film Disc 260L+ P1200/1500 grade with DA sander. Use 3M™ Hookit™ Soft Interface Pad. Wet Sanding* 1. Sand with 3M™ Trizact™ Hookit™ Clear Coat Sanding Disc grade 1500 with DA sander, use 3M™ Hookit™ Soft Interface Pad. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc. <small>*Dry or Wet Sanding option</small>	 3M™ Hookit™ Finishing Film Disc 260L+ PN51158 PN51154  3M™ Trizact™ Hookit Clear Coat Sanding Disc PN05600  3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm  3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit
3 Scratch refinement 	Dry Sanding* 1. Refine the 1200 grade abrasive sand scratches with 3M™ Hookit™ Flexible Abrasive Foam Disc P2000 grade on DA sander. 2. Clean the surface prior to compounding application. Wet Sanding* 1. Refine the 1500 grade abrasive sand scratches with 3M™ Trizact™ Hookit™ Foam Abrasive Disc 443S grade 3000 on DA sander, use 3M™ Hookit™ Soft Interface Pad. When using 3M™ Trizact™ Abrasives, use a light mist of water while sanding to avoid clogging of the disc. 2. Clean the surface prior to the compounding application. *Dry or Wet Sanding option	 3M™ Hookit™ Flexible Abrasive Foam Discs PN33544  3M™ Trizact™ Hookit™ Foam Abrasive Disc 443SA PN50414  3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm  3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit
4 Compounding 	1. Compound the abraded surface with 3M™ Perfect-It™ Fast Cut Plus Extreme and 3M™ Perfect-It™ Low Linting Wool Compounding Pad or 3M™ Perfect-It™ Green Foam Compounding Pad. Use a Rotary Polishing machine at a speed of 1400 - 1800 rpm's.	 3M™ Perfect-It™ Fast Cut Plus Extreme 1kg 865ml PN51815  3M™ Perfect-It™ Quick Connect Double Sided Wool Compounding Pad 230mm PN33279  3M™ Perfect-It™ Quick Connect Adaptor 216mm PN50874
5 Polishing 	1. Polish compounded surface with 3M™ Perfect-It™ Ultrafina SE Polish and 3M™ Perfect-It™ Wool Polishing Pad or 3M™ Perfect-It™ Ultrafine Polishing Pad. Use the rotary polishing machine at a speed of 1400 - 1800 rpm's.	 3M™ Perfect-It™ Ultrafina SE Polish 1L PN50383  3M™ Perfect-It™ Quick Connect Double Sided Foam Convolute Blue Polishing Pad 216mm PN50708  3M™ Quick Connect Adaptor PN05752
6 Protection 	1. Apply 3M™ Perfect-It™ Boat Wax to protect the surface. When applying Boat Wax, apply in a 10cm x 10cm area and wipe area clean before the wax dries.	 3M™ Perfect-It™ Boat Wax PN09034E 473ml PN09035E 946ml  3M™ Perfect-It™ High Gloss Polishing Pad PN09378  3M™ Perfect-It™ High Performance Cloth, Blue PN50486

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Marine Bottom Paint (Antifouling) Preparation and Application Process		Product List
1 Cleaning		<p>1. Clean the surface with approved cleaner to remove and surafcae pollution.</p> <p> 3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml</p> <p> 3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
2 Sanding		<p>1. Sand the bottom surface using a dual action sander with 3M™ Hookit™ 775L Cubitron™ II 220+ grade to prepare surface for bottom paint. 2. Clean the repair area with approved cleaner or blow off the repair area using pressured air.</p> <p> 3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN51126 5mm PN51127 10mm</p> <p> 3M™ Hookit™ Soft Interface Pad</p> <p> 3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
3 Filler application		<p>1. Mix 3M™ Marine Premium Filler according to manufacturer's specification. 2. Apply 3M™ Marine Premium Filler to the repair area making sure to apply a tight coat first. 3. After the filler has cured, sand the repair with 3M™ Hookit™ 775L Cubitron™ II 120+ grade abrasive discs, removing high spots in the repair. 4. Finish by sanding the repair area with 3M™ Hookit™ 775L Cubitron™ II 220+ grade abrasive disc.</p> <p> 3M™ Marine Premium Filler PN46005</p> <p> 3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p> 3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
4 Masking		<p>1. Ensure that the surface is completely dry prior to applying 3M™ masking products. 2. Taking care to keep the repair area as small as possible, mask the areas that require 3M™ Precision Masking Tape first. 3. Mask the rest of the repair, backing up the 3M™ Precision Masking Tape with masking tape*. 4. Mask entire surface with 3M™ Purple Premium Plus Masking Film.</p> <p>*3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244</p> <p> 3M™ Purple Premium Plus Masking Film PN50988</p> <p> 3M™ Precision Masking Tape</p> <p> 3M™ Scotch® Performance Masking Tape 244</p>
5 Bottom paint application		<p>1. Mix bottom paint in appropriate 3M™ PPS™ Series 2.0 disposable spray cup, according to manufacturer recommendation. Remember to remove filter in the lid of disposable paint system 2. Adjust 3M™ Performance Spray Gun air pressure, fan and fluid setting to achieve desired fan pattern and atomisation. 3. Hold spray gun 15cm - 20cm away from surface and apply bottom paint to the repair area according to manufacturer's recommendation for micron thickness.</p> <p> 3M™ PPS™ Series 2.0 Spray Cup System</p> <p> 3M™ Performance Spray Gun PN26832</p> <p> 3M™ Performance Gravity HVLP Atomising Head Red PN26720</p>



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