

you	nk abo r healt complete	h Corded, 50 Pairs/Box, UF-0		3M [™] SecureFit [™] 400 Safety Glasses, Black/Green frame, Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU Ig based on your job and exposure assessment.
Ge	lcoat	Surface Preparat	ion and Application Process	Product List
1	Cleaning	Sin and the second seco	1. Pressure wash the repair area. 2. Clean the repair area with 3M [™] Perfect-It [™] Boat Wash to remove any organic materials, with approved cleaner to remove any inorganic materials.	Image: Solution of the systemImage: Solution of the systemSM™ Perfect-It™SM™ Perfect-It™Boat WashHigh PerformancePN09034E473miPN09035E946miPN09035E946mi
2	Sanding		 Sand the old or new gelcoat to remove surface imperfections using a DA sander with abrasive discs 3M[™] Hookit[™] 737U 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. Clean the repair area with approved cleaner or blow off the repair area using pressured air. 	3M [™] Hookit [™] 3M [™] Sander 737U Cubitron [™] II 3M [™] Sander Abrasive Discs 152mm 5mm orbit PN51369 (80+)
3	Filler application		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 [™] 737U 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.	SM [™] Marine Blister Repair Filler PN46013 Blister PN51369 (80+) SM [™] Hookit [™] 737U Cubitron [™] II Abrasive Discs PN51369 (80+) Abrasive Discs PN50416 Orange
4	Final filler application		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 [™] 737U Cubitron [™] II 120+ grade abrasive discs, removing high spots in the repair. 4. Finish by sanding the repair area with 3M [™] Hookit [™] 737U Cubitron [™] II grade 220+.	Image: Signed systemImage: Signed systemImage: Signed systemImage: Signed system3M™ Marine Premium Filler PN460053M™ Hookit™ 737U Cubitron™ II Abrasive Discs PN51370 (120+) PN51423 (220+)3M™ Sander 9N% Sander PN28508 152mm Smm orbit PN28509 152mm 2.5mm orbit
5	Masking		 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. Mask the rest of the repair, backing up the 3M[™] Precision Masking Tape with masking tape*. Mask entire surface with 3M[™] Purple Premium Plus Masking Film. "3M[®] Scotch" 3030 Masking Tape (internal use) or 3M[®] Scotch Blue[®] 2090 Painter's Tape (internal and external use) 	Image: Solution of the soluti
6	Gelcoat application		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.	Image: SystemImage: Series SystemImage: Series Spray Gun PN26832Image: Series Sm™ Performance Gravity HVLP Atomising Head Red PN26720
7	Gelcoat finishing		For gelcoat finishing process please refer to the following page.	

Think about your health 3M [™] E-A-R [™] Ultrafit [™] Earplu Corded, 50 Pairs/Box, UF-O Not a complete list. Select protective eyewear, approximation		3M [™] SecureFit [™] 400 Safety Glasses, Black/Green frame, Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU ng based on your job and exposure assessment.
Gelcoat Finishing Process	*	Product List
Cleaning Cleaning	1. Pressure wash the repair area. 2. Clean the repair area with 3M [™] Perfect-It [™] Boat Wash to remove any organic materials. 3. Clean the repair area with approved cleaner to remove any inorganic materials.	image: bit with the second systemimage: bit with the second systemSM™ Perfect-It™SM™ Perfect-It™Boat WashHigh PerformancePN09035E946mlPN09035E946mlPN50400
2 ganding	1. Sand gelcoat surface with P800 grade 3M [™] Hookit [™] Flexible Abrasive Foam Disc on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	3M" Hookit"3M" Hookit"3M" Hookit"3M" Hookit"737U3M" Hookit"3M" Hookit"3M" Sander737UFlexibleSoft InterfacePN28508Cubitron" IIAbrasivePadPN28508Abrasive DiscsFoam DiscsPN51366Soft InterfacePN51369(80+)PN3540 (P800)PN5112710mm
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 [™] 3M [™] Hookit [™] 3M [™] Sander Soft Interface 9N28508 Abrasive Pad 152mm 5mm orbit PN31542 (P1200) PN51126 5mm
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.	Image: Signed systemImage: Signed systemImage: Signed systemImage: Signed system3M" Perfect-It" Gelcoat Heavy Cutting Compound PN36101 PN361033M" Perfect-It" Quick Connect Double Sided Wool Com- pounding Pad 230mm PN3279 3M" Quick Connect Adaptor PN057523M" Perfect-It" High Performance Cloth, Yellow PN50400
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 Double Sided 3M [™] Perfect-It [™] Polish Double Sided Vool Com- PN30344E 946ml pounding Pad 230mm PN3279 3M [™] Quick Connect Adaptor PN05752
Protection	 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. 	Image: Solution of the systemImage: Solution of the systemImage: Solution of the system3M [™] Perfect-It [™] 3M [™] Perfect-It [™] 3M [™] Perfect-It [™] Boat Wax PN09034E473ml 946mlHigh Gloss Polishing Pad PN093783M [™] Perfect-It [™] High SolutionPolishing Pad PN09378Cloth, Blue PN50486

* Two options (5 or 6 steps)

	nk about 3M [™] E-A-R [™] Ultrafit [™] Earplu Ir health Corded, 50 Pairs/Box, UF-C		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 Finishing Process*			Product List				
1	Cleaning	1. Pressure wash the repair area. 2. Clean the repair area with 3M [™] Perfect-It [™] Boat Wash to remove any organic materials. 3. Clean the repair area with approved cleaner to remove any inorganic materials.	Image: Solution of the systemImage: Solution of the systemSM™ Perfect-It™SM™ Perfect-It™Boat WashHigh PerformancePN09035E946mlPN09035E946mlPN50400				
2	Sanding	1. Sand gelcoat surface with P800 grade 3M [™] Hookit [™] Flexible Abrasive Foam Disc on a dual action sander. When sanding use a 50% overlap with each pass of the sander.	3M [™] Hookit [™] 3M [™] Hookit [™] 3M [™] Hookit [™] 3M [™] Hookit [™] 737U 3M [™] Hookit [™] 3M [™] Hookit [™] 3M [™] Sander 737U Abrasive Abrasive 3M [™] Hookit [™] Abrasive Discs Foam Discs Pad 10mm PN51369 (80+) PN33540 (P800) PN51127 10mm				
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 [™] 3M [™] Hookit [™] 3M [™] Sander SM [™] Hookit [™] 3M [™] Hookit [™] 3M [™] Sander Flexible Soft Interface PN28508 Abrasive Pad 152mm 5mm orbit PN35542 (P1200) PN51126 5mm				
4	Compounding & Polishing	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.	SM [™] Perfect-It [™] SM [™] Perfect-It [™] SM [™] Perfect-It [™] Gelcoat SM [™] Perfect-It [™] SM [™] Perfect-It [™] Compound + Double Sided SM [™] Perfect-It [™] PN30344E 946ml pounding Pad PN30345E 3.6L 230mm PN33279 SM [™] Quick Connect Adaptor PN05752 SM [™] Quick				
5	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 [™] 3M [™] Perfect-It [™] 3M [™] Perfect-It [™] Boat Wax 3M [™] Perfect-It [™] 3M [™] Perfect-It [™] PN09035E 946ml Polishing Pad PN09378 PN50486				

* Two options (5 or 6 steps)

Think about 3M [™] E-A-R [™] Ultrafit [™] Earplu	gs, 32 dB, 🧑 3M [™] Maintenance Free Half Mask, 🦳	3M [™] SecureFit [™] 400 Safety Glasses, Black/Green frame, ∕◯◯∖
your health Corded, 50 Pairs/Box, UF-C	n1-000 FFA2P3 R D Filters, 4255+	Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU
Marine Paint Surface Prep	paration and Application Process	Product List
Cleaning Cleaning	1. Pressure wash the repair area. Clean the repair area with 3M [™] Perfect-It [™] Boat Wash to remove any organic materials. Clean the repair area with approved cleaner to remove any inorganic materials.	Image: Signal problemImage: Signal problemSM™ Perfect-It™SM™ Perfect-It™Boat WashHigh PerformancePN09034E473mi 946miCloth, Yellow PN50400
2 guding	1. Using a DA sander with 3M [™] Hookit [™] 737U Cubitron [™] II 80+ grade abrasive discs, sand the repair area to remove any oxidized paint. 2. Clean the repair area with approved cleaner or blow off the repair area using pressured air.	3M [™] Hookit [™] JM [™] Sander 737U Cubitron [™] II PN28508 Abrasive Discs 152mm 5mm orbit PN51369 (80+)
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 [™] 737U 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 [™] 737U Cubitron [™] II 220+ grade abrasive discs. 6. Clean the surface with approved cleaner or blow off the surface with pressured air.	SM [™] Marine Premium Filler PN46005
4 Wasking	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 [™] Scotch [™] 3030 Masking Tape (internal use) or 3M [™] Scotch Blue [®] 2090 Painter's Tape (internal and external use)	Image: Solution of the solutio
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.	Image: Series 2.0 Spray Cup SystemImage: Spray Gun PN26832Image: Spray Gun Gravity HVLP Atomising Heads
Primer Sanding	 Apply dry guide coat to surface and sand primer with 3M[™] Hookit[™] 737U Cubitron[™] II 320+ grade abrasive discs to prepare for paint application. Apply dry guide coat to surface. Repeat sanding with 3M[™] Hookit[™] 737U Cubitron[™] II abrasive discs grade 400+. Clean the surface with approved cleaner or blow off the repair area using pressured air. 	SM™ Dry Guide Coat PN50416SM™ Hookit™ OrangeSM™ Hookit™ 737U Cubitron™ II Abrasive Discs PN51426 (320+) PN51428 (400+)SM™ Sander PN28508 SSM™ Sander PN28509 152mm 5mm orbit PN28509 152mm 2.5mm orbit
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.	Image: Series 2.0 Spray Cup SystemImage: Series Spray Gun PN26832Image: Series Small content of the ser
B Marine paint finishing	For Marine Paint Finishing process please refer to the following page.	

Think about 3M[™] E-A-R[™] Ultrafit[™] Earplugs, 32 dB, 3M[™] Maintenance Free Half Mask. 3M[™] SecureFit[™] 400 Safety Glasses, Black/Green frame. $\langle \boldsymbol{\cdot} \rangle$ FFA2P3 R D Filters, 4255+ Anti-Scratch / Anti-Fog, Clear Lens, SF401AS/AF-EU Corded, 50 Pairs/Box, UF-01-000 your health Not a complete list. Select protective eyewear, appropriate gloves, hearing protection, respirator and protective clothing based on your job and exposure assessment. Marine Paint and Clearcoat Finishing Process **Product List** Maintenance 1. Pressure wash the repair area. Clean the repair Cleaning area with 3M[™] Perfect-It[™] Boat Wash to remove any organic materials. Clean the repair area with 3M[™] Perfect-It" 3M[™] Perfect-It[™] approved cleaner to remove any inorganic materials. Boat Wash **High Performance** *Dry or Wet Sanding option PN09034E 473m Cloth, Yellow PN09035E 946ml PN50400 Drv Sanding 1. Sand with 3M[™] Hookit[™] Purple Finishing Film Disc 260L+ P1200/1500 grade with DA sander. Use 3M[™] Hookit[™] Soft Interface Pad. 3M[™] Hookit[™] Sanding 3M 3M[™] Trizact[™] 3M[™] Sander Wet Sanding Soft Interface PN28508 Hookit[™] Film Hookit Clear 2 1. Sand with 3M[™] Trizact[™] Hookit[™] Clear Coat Pad 152mm 5mm orbit Disc 260L+ Coat Sanding PN28509 PN51126 Sanding Disc grade 1500 with DA sander, use $3M^{\scriptscriptstyle \rm M}$ PN51158 PN51154 Disc 5mm 152mm 2.5mm orbit Hookit[™] Soft Interface Pad. When using 3M[™] Trizact[™] PN51127 10mm PN05600 Abrasives, use a light mist of water while sanding to avoid clogging of the disc. *Dry or Wet Sanding option Dry Sanding 1. Refine the 1200 grade abrasive sand scratches with Scratch refinement 3M[™] Hookit[™] Flexible Abrasive Foam Disc P2000 grade on DA sander. 2. Clean the surface prior to 3M[™] Hookit[™] 3M[™] Trizact[™] 3M[™] Hookit[™] 3M[™] Sander compounding application. Hookit[™] Foam Soft Interface PN28508 Flexible Wet Sanding* 3 Abrasive Disc. Pad Abrasive 152mm 5mm orbit PN28509 Foam Discs PN51126 1. Refine the 1500 grade abrasive sand scratches 443SA 5mm 152mm 2.5mm orbit PN51127 10mm PN33544 with 3M[™] Trizact[™] Hookit[™] Foam Abrasive Disc 443S PN50414 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 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 Compounding Polishing machine at a speed of 1400 - 1800 rpm's. 3M^{*} 3M 3M" 3M[™] Perfect-It[™] Perfect-It[™] Perfect-It[™] Perfect-It[™] Fast Cut Plus Quick Connect Quick Connect High 4 Extreme 1kg Double Sided Double Sided Performance 865ml Wool Com-Foam Con-Cloth, Yellow PN51815 pounding Pad voluted Green PN50400 Compounding 230mm PN33279 Pad 3M[™] Quick 216mm PN50874 Connect Adaptor PN05752 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 Polishing 3M[™] 3M[™] Perfect-It[™] 3M" , 1400 - 1800 rpm's. 5 Perfect-It[™] Quick Connect Double Sided Perfect-It[™] Ultrafina Foam Convoluted Blue High SE Polish Polishing Pad Performance Cloth, Blue 1L 216mm PN50708 PN50383 PN50486 3M[™] Quick Connect Adaptor PN05752 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 Protection before the wax dries. 3M¹ 3M[™] Perfect-It[™] ЗМ™ 6 Perfect-It[™] High Gloss Polishing Pad Perfect-It[™] Boat Wax High PN09378 PN09034E 473ml PN09035E 946ml Performance Cloth, Blue

PN50486

Think about your health 3M[™] E-A-R[™] Ultrafit[™] Earplugs, 32 dB, 3M[™] SecureFit[™] 400 Safety Glasses, Black/Green frame. 3M[™] Maintenance Free Half Mask. Ì Corded, 50 Pairs/Box, UF-01-000 FFA2P3 R D Filters, 4255+ 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. Marine Bottom Paint (Antifouling) **Preparation and Application Process Product List** 1. Pressure wash the repair area. 2. Clean the repair area with 3M[™] Perfect-It[™] Boat Wash to remove Cleaning any organic materials. Clean the repair area with approved cleaner to remove any inorganic materials. 3M[™] Perfect-It 3M[™] Perfect-It[™] Boat Wash **High Performance** PN09034E Cloth, Yellow 473m PN09035E 946ml PN50400 1. Sand the old bottom paint using a dual action sander with 3M[™] Hookit[™] 737U Cubitron[™] II 80 grade Sanding abrasive discs to remove old loose bottom paint. 2. Clean the repair area with approved cleaner or 2 3M[™] Hookit[™] blow off the repair area using pressured air. 3M[™] Hookit[™] 737U 3M[™] Sander Soft Interface Pad Cubitron[™] II PN28508 PN51126 PN51127 152mm 5mm orbit PN28509 5mm 10mm Abrasive Discs PN51369 (80+) 152mm 2 5mm orbit 1. Mix 3M[™] Marine Premium Filler according to manufacturer's specification. 2. Apply 3M[™] Marine application Premium Filler to the repair area making sure to apply a tight coat first. 3. After the filler has cured, sand Filler 3 3M[™] Hookit[™] 737U 3M[™] Sander the repair with 3M[™] Hookit[™] 737U Cubitron[™] II 120+ 3M[™] Marine grade abrasive discs, removing high spots in the **Premium Filler** Cubitron[™] II PN28508 152mm 5mm orbit repair. 4. Finish by sanding the repair area with $3M^*$ PN46005 Abrasive Discs PN28509 Hookit[™] 737U Cubitron[™] II 220+ grade abrasive disc. (320+) (400+) PN51426 152mm 2.5mm orbit PN51428 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. Masking 3M[™] Scotch 3. Mask the rest of the repair, backing up the 3M[™] Purple 3M™ 4 3M[™] Precision Masking Tape with masking tape*. Premium Plus Precision Blue[™] 2090 4. Mask entire surface with 3M[™] Purple Premium Plus Masking Film Masking Tape Painter's Tape Masking Film. PN50988 *3M[™] Scotch[™] 3030 Masking Tape (internal use) or 3M[™] Scotch Blue[™] 2090 Painter's Tape (internal and external use) 1. Mix bottom paint in appropriate 3M[™] PPS[™] Series 2.0 disposable spray cup, according to manufacturer recommendation. Remember to remove filter in Bottom paint application the lid of disposable paint system 2. Adjust 3M" 3M[™] Performance 3M[™] Performance 3M[™] PPS[™] Series Performance Spray Gun air pressure, fan and 5 Spray Gun fluid setting to achieve desired fan pattern and 2.0 Spray Cup Gravity HVLP PN26832 atomisation. 3. Hold spray gun 15cm - 20cm away System Atomising Head from surface and apply bottom paint to the repair Red area according to manufacturer's recommendation PN26720 for micron thickness.

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 in accordance with all applicable instructions and with appropriate safety equipment, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

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