



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














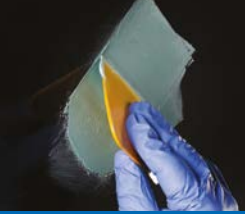












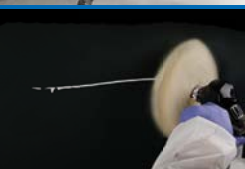
3M™ Maintenance Free Half Mask, FFA2P3 R D Filters, 4255+



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>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>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</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>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>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>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>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>
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 	<p>1. Clean the new external composite surface with approved cleaner to remove all mold release materials.</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>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN51126 5mm PN51127 10mm</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>
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>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 	<p>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.</p>     <p>3M™ Perfect-It™ Gelcoat Heavy Cutting Compound PN36101 473ml PN36102E 946ml PN36103 3.6L</p> <p>3M™ Perfect-It™ Quick Connect Double Sided Wool Compounding Pad PN28508 230mm PN33279</p> <p>3M™ Quick Connect Adaptor PN05752</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
5	Polishing 	<p>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.</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 PN28508 230mm PN33279</p> <p>3M™ Quick Connect Adaptor PN05752</p> <p>3M™ Perfect-It™ High Performance Cloth, Blue PN50486</p>
6	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>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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










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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>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>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs PN51126 5mm PN51127 10mm</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>
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>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>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™ Perfect-It™ High Performance Cloth, Yellow PN50400</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>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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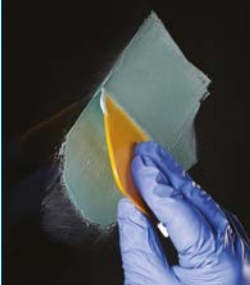





















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Marine Paint Surface Preparation and Application Process		Product List
1 Cleaning		<p>1. Clean the surface with approved cleaner to remove and surface pollution.</p>   <p>3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
2 Sanding		<p>1. 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.</p>   <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
3 Filler application		<p>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.</p>    <p>3M™ Marine Premium Filler PN46005</p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p>3M™ Dry Guide Coat PN09650 Black PN50416 Orange</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™ Performance Industrial Masking Tape 301E</p> <p>3M™ Scotch® Performance Masking Tape 244</p>
5 Primer Application		<p>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.</p>    <p>3M™ PPS™ Series 2.0 Spray Cup System</p> <p>3M™ Performance Spray Gun PN26832</p> <p>3M™ Performance Gravity HVLP Atomising Heads</p>
6 Primer Sanding		<p>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.</p>    <p>3M™ Dry Guide Coat PN09650 Black PN50416 Orange</p> <p>3M™ Hookit™ 775L Cubitron™ II Abrasive Discs</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
7 Marine Paint Application		<p>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.</p>    <p>3M™ PPS™ Series 2.0 Spray Cup System</p> <p>3M™ Performance Spray Gun PN26832</p> <p>3M™ Performance Gravity HVLP Atomising Heads</p>
8 Marine paint finishing		<p>For Marine Paint Finishing process please refer to the following page.</p>

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Marine Paint and Clearcoat Finishing Process

Product List

<p>1 Cleaning</p>		<p>OEM*</p> <p>1. Clean the surface with approved cleaner to remove and surface pollution.</p> <p>*Dry or Wet Sanding option</p>	<p>3M™ Perfect-It™ Boat Wash PN09034E 473ml PN09035E 946ml</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
<p>2 Sanding</p>		<p>Dry Sanding*</p> <p>1. Sand with 3M™ Hookit™ Purple Finishing Film Disc 260L+ P1200/1500 grade with DA sander. Use 3M™ Hookit™ Soft Interface Pad.</p> <p>Wet Sanding*</p> <p>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.</p> <p>*Dry or Wet Sanding option</p>	<p>3M™ Hookit™ Film Disc 260L+ PN51158 PN51154</p> <p>3M™ Trizact™ Hookit™ Clear Coat Sanding Disc PN05600</p> <p>3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
<p>3 Scratch refinement</p>		<p>Dry Sanding*</p> <p>1. Refine the 1200 grade abrasive sand scratches with 3M™ Hookit™ Flexible Abrasive Disc P2000 grade on DA sander. 2. Clean the surface prior to compounding application.</p> <p>Wet Sanding*</p> <p>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</p>	<p>3M™ Hookit™ Flexible Abrasive Foam Discs PN33544</p> <p>3M™ Trizact™ Hookit™ Foam Abrasive Disc 443SA PN50414</p> <p>3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm</p> <p>3M™ Sander PN28508 152mm 5mm orbit PN28509 152mm 2.5mm orbit</p>
<p>4 Compounding</p>		<p>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.</p>	<p>3M™ Perfect-It™ Fast Cut Plus Extreme 1kg 865ml PN51815</p> <p>3M™ Perfect-It™ Quick Connect Double Sided Wool Compounding Pad 230mm PN33279</p> <p>3M™ Quick Connect Adaptor PN05752</p> <p>3M™ Perfect-It™ Quick Connect Double Sided Foam Convuluted Green Compounding Pad 216mm PN50874</p> <p>3M™ Perfect-It™ High Performance Cloth, Yellow PN50400</p>
<p>5 Polishing</p>		<p>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.</p>	<p>3M™ Perfect-It™ Ultrafina SE Polish 1L PN50383</p> <p>3M™ Perfect-It™ Quick Connect Double Sided Foam Convuluted Blue Polishing Pad 216mm PN50708</p> <p>3M™ Quick Connect Adaptor PN05752</p> <p>3M™ Perfect-It™ High Performance Cloth, Blue PN50486</p>
<p>6 Protection</p>		<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>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>

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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 surface 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</p>  <p>3M™ Hookit™ Soft Interface Pad PN51126 5mm PN51127 10mm</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™ 775LCubitron™ 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><small>*3M™ Performance Industrial Masking Tape 301E or 3M™ Scotch® Performance Masking Tape 244</small></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>

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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