3M™ Marine
Recommended Finishing

3M™ Marine Machine Finishing Systems

Material	Tooling Gelcoat	Production Gelcoat	Paint*	Wood / Varnish Laquer
Preliminary Abrasive *Step for very rough surfaces only*	*3M 255 P320*	*3M 255 P320*	*Start at Step 1*	*Start at Step 1*
Abrasive Step 1	*3M 255 P400*	*3M 255 P400*	*3M 255 P600 (if thick coating of lacquer)*	*3M 255 P600 (if thick coating of lacquer)*
Abrasive Step 2	*3M 260 P600*	*3M 260 P800*	*3M 260 P1000*	*3M 260 P1000*
Abrasive Step 3	*3M 260 P800*	*N/A*	*3M 260 P1500*	*3M 260 P1500*
Abrasive Step 4	*3M Trizact P3000*	*3M Trizact P3000***	*3M Trizact P3000*	*3M Trizact P3000*
Compound	*3M Premium Mould & Tooling Compound 06027*	*3M Imperial Compound 06044*	*3M Imperial Compound 06044*	*3M Imperial Compound 06044*
Polish	*3M Finesse-it II Finishing Material 09048 I l*	*3M Finesse-it II Finishing Material 09048*	*3M Finesse-it II Finishing Material 09048*	*3M Finesse-it II Finishing Material 09048*
Wax	*N/A*	*Ultra Performance Paste Wax 09030*	*Ultra Performance Paste Wax 09030 (for cured paint only)*	*N/A*

Material *Due to the wide varieties of paints available please test for suitability.
** Preferred for dark gelcoat. Not necessary on white gelcoat.

Tools

Sanding	*3M™ Hookit™ back up pad 05876 or 59000 with 3M Soft Interface Pad 05774*
Compounding	*3M™ Double-Sided Compounding Pad 05704 or 3M™ SBS™ Back Up Pad 5717M with 3M™ White Compounding Pad 05711*
Polishing	*3M™ Double-Sided Polishing Pad 05705 or 3M™ SBS Back Up Pad 5717M with 3M Yellow Polishing Pad 05713*
Final Finish	*Scotch-Brite™ High Performance Cloth 2010*

tooling & production gelcoat

Follow the finishing steps outlined in the table overleaf. A soft interface pad is recommended for use with the finer grades of abrasive and should be used for step 2 and for all following steps. The initial stages are designed to achieve a uniform finish and do not require a soft interface pad.

When in use, move the sanding machine continuously to prevent loading. Similarly, move the buffing machine continuously and evenly over the substrate to prevent over heating the substrate.

Compounding

Material *Either 3M™ Premium Mold and Tooling Compound (06027) for tooling gel coat or 3M™ Imperial™ Compound (06044) for production gelcoat.*

Tool *Either 3M™ Double-Sided Compounding Pad (05704) or 3M™ SBS™ Back Up Pad (5717M) with 3M™ White Compounding Pad (05711).*

Use an electrical buffer with 1500 rpm and a lot of pressure at the start of buffing. When the material starts to dry, increase the speed to 2000/2500 and decrease the pressure.

Polishing

Material *3M™ Finesse-it™ II Finishing Material (09048).*

Tool *Either 3M™ Double-Sided Compounding Pad (05705) or 3M SBS Back Up Pad (5717M) with 3M Yellow Compounding Pad (05713).*

Use an electrical buffer with 1500 rpm and a lot of pressure at the start of buffing. When the material starts to dry, increase the speed to 2000/2500 and decrease the pressure.

paint & wood varnish

Follow the finishing steps outlined in the table overleaf. A soft interface pad is recommended for use with the finer grades of abrasive and should be used for step 2 and for all following steps. The initial stages are designed to achieve a uniform finish and do not require a soft interface pad.

When in use, move the sanding machine continuously to prevent loading. Similarly, move the buffing machine continuously and evenly over the substrate to prevent over heating the substrate.

Compounding

Material *Either 3M™ Imperial Compound (06044) for paint or 3M™ Perfect-It™ Fast Cut Compound (09374) for wood varnish and lacquer.*

Tool *Either 3M Double-Sided Compounding Pad (05704) or 3M SBS back up pad (5717M) with 3M™ White Compounding Pad (05711).*

Use an electrical buffer with 1500 rpm and a lot of pressure at the start of buffing. When the material starts to dry, increase the speed to 2000/2500 and decrease the pressure.

Polishing

Material *3M Finesse-it II Finishing Material (09048).*

Tool *Either 3M Double-Sided Compounding Pad (05705) or 3M SBS Back Up Pad (5717M) with 3M Yellow Compounding Pad (05713).*

Use an electrical buffer with 1500 rpm and a lot of pressure at the start of buffing. When the material starts to dry, increase the speed to 2000/2500 and decrease the pressure.

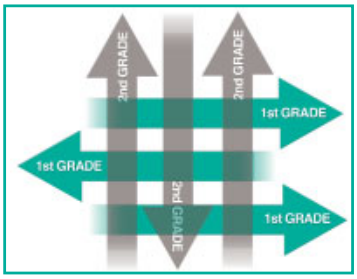
3M™ Marine Hand Finishing System

Tooling & Production Gelcoat

Tool & Material	Comments
3M™ Softback™ Sanding Sponge superfine (03810).	*Always use cross sanding technique.**
Softback Sanding Sponge ultra fine (02601)	*Always use cross sanding technique.**
Scotch-Brite™ White Hand Pad (07617) with 3M™ Imperial™ Compound (06044)	
Scotch-Brite™ High Performance Cloth 2010 with 3M™ Finesse-it™ II Finishing Material (09048)	

Cross sanding technique

Alternate the sanding direction with each grade of abrasive



Paint & Wood Varnish

Tool & Material	Comments
Softback Sanding Sponge ultra fine (02601).	*Always use cross sanding technique.**
Softback Sanding Sponge micro fine (02600).	*Always use cross sanding technique.**
Scotch-Brite™ White Hand Pad (07617) with 3M™ Perfect-It™ Fast Cut Compound (09374)	
Scotch-Brite™ High Performance Cloth 2010 with 3M™ Finesse-It™ II material (09048)	

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