06044E
3M™ Marine Imperial™ Compound and Finishing Material

Technical data sheet – Updated July 2004 – New

Product description

3M™ Marine Imperial™ Compound and Finishing Material 6044E has a fast cut and leaves an excellent finish without swirl marks. This liquid compound and finishing material is designed to remove a P600 or P800 dual action sand scratch from gel coat, with a wool pad. Designed to be used with an air or electric buffer equipped with 3M™ Compounding Pads.

Features

- Removes grade P600 disc sand scratches or finer from production gelcoat.
- Leaves a high gloss finish without swirl/wheel marks.
- Contains no wax or silicone.
- Provides high quality results.

Typical physical properties

Consistency	Liquid
Color	White
Appearance & odor	Paste, mild solvent odor

Packaging

1 litre bottle.
4 bottles per case.

Directions for use

Selection

3M Marine Imperial compound is designed for:

- Removing P600, P800 or finer scratches
- Removing gel coat oxidation

It leaves a high gloss finish on gel coat surfaces.
3M™ Imperial Compound is designed for use on production gel coat. 3M™ Marine Mold and Tooling Compound, part number 6027E, is a more aggressive compound and recommended for use on harder tooling gel coat.

Surface preparation

Clean the surface with a boat soap and water.
When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe proper precautionary measures for handling such materials. Refer to product label and MSDS for further precautions.

Local air quality regulations may regulate or prohibit the use of surface preparation and clean-up materials based on VOC content. Consult your local air quality regulation.

Note:

- **Do not apply in direct sunlight.**
- **For best results use machine application.**
- **This product was designed and tested for use on gel coat surfaces. On other surfaces test in an inconspicuous area for suitability.**

Hand application

1. Apply compound to a small area using a soft, clean cloth.
2. Rub aggressively using short strokes.
3. Keep turning the cloth as more compound is applied.
4. Buff to a high gloss using a soft, clean cloth.

Machine application

1. Apply with an air or electric buffer (1500 – 2500 rpm) equipped with a 3M™ Superbuff™ 2 plus 2 Pad, part number 05704 or 3M™ Hookit™ SBS™ Compounding Pad, P.N. 05711.
2. Apply a sufficient amount of Imperial Compound to boat surface to work a 50 cm x 50 cm area.
3. Before starting the machine, spread the material with the buffing pad. This will reduce slinging of compound and clean up.
4. Buff using light to medium pressure in a consistent uniform pattern.
5. Reduce pressure when material begins to dry, polishing the surface.
6. Repeat if necessary, to remove any remaining sanding scratches.

After Compounding : To further refine the surface or increase gloss, follow with 3M™ Marine Finesse-It™ II Finishing Material with a Superbuff polishing pad, part number 05705, or Hookit polishing pad, part number 05713, on a slow speed polisher (1500-2500 rpm).

Cleanup

To remove any dried or caked-on compound, use 3M™ Marine Liquid Wax, part number 09027, 3M™ Marine Ultra Performance Paste Wax, part number 09030.
Apply with Scotch-Brite™ High Performance Cloths, part number HPW2010.

Storage & handling

Recommended storage temperature range: 15°C (60F) to 25°C (80F).
Expected shelf life at recommended storage temperature: 36 months.

Precautionary information

Refer to product label and Material Safety Data Sheets for Health and Safety Information before using this product.

Important notice to purchaser

All physical properties, statements and recommendations are either based on tests we believe to be reliable or our experience, but they are not guaranteed. 3M recommends each user determine the suitability of the products for intended use.

Warranty and limited remedy

This product will be free from defects in material and workmanship at the time of shipment. 3M makes no other warranties, express or implied, including, but not limited to, any implied warranty of merchantability of fitness for particular purpose. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

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