

3M PRODUCT DATA SHEET

Product Title

3M 80349 Extra Fine Compound

Product Description/Markets

3M 80349 Extra Fine Compound has been developed specifically for modern scratch resistant paints to give a relative high cut and very high gloss. The product is equally useful on standard paints.

For use on refinish on original paints to remove sanding scratches after rectifying paint defects such as dust nibs or orange peel.

Can also be used as an alternative to 3M Machine Polish after using a coarser compound to restore finish.

Construction/Physical Properties

Container:	1 litre bottle
Qty per box:	12 bottles
Flash point:	97.22°C closed cup
Colour:	White
Consistency:	Thick liquid
VOCs:	15% by weight SCAQ443
Viscosity:	12,000-22,000 cps
pH:	7-8.5
% volatile:	70-80% by weight

Applications

3M 80349 is a fine automotive compound for use on refinish paints to remove sanding scratches after denibbing or flatting with 3M 260L P1500 abrasive discs on 3M Microfine 2000 grade Wetordry hand sanding paper or 3M 9 micron abrasive disc. Use the appropriate size of Trizact Fine Finishing Discs 50076 (150 mm), 50075 (75 mm) or 3M A5 Trizact discs 50079 (32 mm) after sanding to refine the scratches before compounding.

3M 80349 is recommended for use with an electric or air driven polisher (1500-2000 rpm) equipped with a 3M 01927 Perfect-it Wool Compounding Pad on a 3M 09552/3 Back-up Pad. The wool pad should be used to give more aggression for the initial compounding stage until the scratches are removed. The pad should then be swapped for a 09550 Foam Compounding Pad to go over the compounded areas to restore glass.

On typical hard scratch resistant paints the harder orange foam will achieve a perfect finish. On softer paints the use of the 3M 09738 (soft black) polishing pad is recommended.

Performance Properties

Handling and Application Information

Directions for use

1. Shaking the bottle before use is not necessary but may help in dispensing the product
2. Sand any defects with 3M 260L Hooking Finishing Film Discs P1500 or 3M Microfine Wetordry grade 2000. For denibbing 3M 9 micron discs can be used
3. Refine scratches with the corresponding size of Trizact Fine Finishing Discs. On hard scratch resistant paints it will be necessary to sand longer with the Trizact discs than on standard paints
4. Apply compound using a rotary polisher and a 01927 Wool Compounding Pad. Use sufficient compound and do not run dry on fresh paint
5. Check afterwards to see if all scratches have been removed by using 3M Glass Cleaner/3M Control Spray
6. If any scratches are remaining carry out step 4 again
7. If all scratches have been removed replace the 01927 pad with the 09550 Compounding Pad and apply compound. Buff to a high gloss using pressure at first then easing the pressure as the compound is drying out
8. Remove any residue with a 3M 60668 High Performance Cloth
9. Clean any spatter from adjacent panels and plastics/rubbers with a soft damp cloth

The above system for using 3M 80349 is ideal for removing individual dust nibs, especially as the scratch resistant paints are harder to refinish than standard paints. If however a large area rectification is needed then after the sanding and Trizact scratch refining stage use 80349 on a 200 mm 3M 05704 Superbuff III wool compounding pad before changing to the 150 mm 09550 foam compounding pad for the final stage.

Alternatively use 3M 09374 Fast Cut Compound or 3M 50077 Trizact Compound on a 09550 Perfect-it Foam Compounding Pad then finish with 3M 80349 Extra Fine Compound on a clean 09550 foam pad.

Safety

Skin contact:	Avoid contact with skin. In case of contact with skin, wash immediately with plenty of soap and water
Ingestion:	If swallowed, do not induce vomiting. Seek medical advice immediately and show this container or label

Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

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