

3M High Gloss Polishing Schedule

Safety First – Make sure that the piece to polish is secured to the work surface before polishing begins. The polishing machine may move or launch smaller pieces, possibly causing injury.

1. Sand out orange peel and imperfections with 3M Trizact P1500-grit Clearcoat Sanding Disc. (If surface is exceptionally rough or orange peeled, back off and start with 3M Finishing Film Disc P1000-grit, then 3M Finishing Film Disc P1200-grit, then 3M Trizact P1500-grit Clearcoat Sanding Disc). Use water as a lubricant. Use a random orbital sander at medium speed.

Note - You are sanding back the last layer of coating film only. The last layer of film may be quite thin. If you sand through the last layer to the prior layer, a halo will appear at the sand-through, and the piece will have to be re-sprayed. It is best to make sure that the final layer of film is thick enough to allow for substantial film removal without sand-through. This is often achieved by applying several wet-on-tack coats in the final application.

2. Use a rubber squeegee tool to wipe liquid and sanding dust from the surface, to determine if any low or glossy spots remain. Continue sanding with P1500-grit until all low or glossy spots are gone, and the surface is perfectly flat and smooth.

3. Now begin the process of sanding out the scratch marks caused by the 3M Trizact P1500-grit Clearcoat Sanding Disc. Clean sanding dust from surface with clean soft cloth, and then start with Trizact Foam Disc P3000, lubricated with water, running medium speed on a random orbital sander. Squeegee and wipe the surface periodically for inspection. Continue this process until you begin to see a clear reflection with no obvious swirl mark or defects on the surface.

4. Switch now to the 3M Perfect-it Series of buffing compounds. The compounds are Labeled 1, 2 and 3, and should be used in that order. They are intended to be applied with the appropriate 3M foam buffing pads, using a handheld electric sander/polisher. To make life easy, each compound is a different color, and the appropriate pad for that compound is the same color. For example;

Compound #1 - 3M Perfect-it Extra Cut Rubbing Compound - Color is white - use white foam pad.

Compound #2 - 3M Perfect-it Machine Polish - Color is grey - use with grey foam pad

Compound #3 - 3M Perfect-it Ultrafina-SE - Color is blue - use with blue pad.

Note - Compound #3 can also be used a cloth polish for touching up pieces at trade shows etc.

Apply each compound to the surface of the piece and operate the polisher at approximately 800 rpm. Thoroughly polish the entire surface of the piece. Wipe away residual paste, and move to the next pad and compound until you have used all three compounds.

5. Perform final inspection.