

3M™ Solid Surface Finishing Guide (Acrylic or Polyester)

Clean Sanding Discs - Dry

Matte Finish			
	Prod.	Grade	damp/dry
STEP 1	236U	P150	dry
STEP 2	360L	P320	dry
STEP 3	Scotch-Brite™ 7447		
	gloss appx 10		

Semi-Gloss Finish			
	Prod.	Grade	damp/dry
STEP 1	236U	P150	dry
STEP 2	360L	P320	dry
STEP 3	360L	P600	dry
STEP 4	Scotch-Brite™ 7448		
	gloss appx 40		

High Gloss Finish (1)			
	Prod.	Grade	damp/dry
STEP 1	236U	P150	dry
STEP 2	360L	P320	dry
STEP 3	360L	P600	dry
STEP 4	360L	P1000	dry
STEP 5	White Wool	Finesse-It™ Finishing Material Easy Clean-up	
	gloss appx 75		

OR

High Gloss Finish (2)			
	Prod.	Grade	damp/dry
STEP 1	236U	P150	dry
STEP 2	360L	P320	dry
STEP 3	360L	P600	dry
STEP 4	360L	P1000	dry
STEP 5	White Wool	Finesse-It™ Finishing Material Easy Clean-up	
STEP 6	Black Wool	Finesse-It™ Final Finish Easy Clean-up	
	gloss appx 85+		

Part Numbers for all products listed on this page are located on the second page.
 Finesse-It™ Finishing Material Easy Clean-up will remove 1000 or 1200 grit scratches.
 Finesse-It™ Final Finish Easy Clean-up will remove 1500 or 2000 grit scratches, as well as reduce haze.

Microfinishing Film Discs - Dry

Matte Finish			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	366L	60µ	dry
STEP 3	Scotch-Brite™ 7447		
	gloss appx 15		

Semi-Gloss Finish			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	366L	60µ	dry
STEP 3	366L	30µ	dry
STEP 4	Scotch-Brite™ 7448		
	gloss appx 45		

High Gloss Finish (1)			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	366L	60µ	dry
STEP 3	366L	30µ	dry
STEP 4	366L	15µ	dry
STEP 5	White Wool	Finesse-It™ Finishing Material Easy Clean-up	
	gloss appx 75		

OR

High Gloss Finish (2)			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	366L	60µ	dry
STEP 3	366L	30µ	dry
STEP 4	366L	15µ	dry
STEP 5	968M	Finesse-It™ Finishing Material Easy Clean-up	
STEP 6	968M	Finesse-It™ Final Finish Easy Clean-up	
	gloss appx 85+		

Trizact™ Film Discs - Damp

Matte Finish			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	268XA	A35	damp
STEP 3	268XA	A10	damp
	OR		
	Scotch-Brite™ 7447		
	gloss appx 15		

Semi-Gloss Finish			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	268XA	A35	damp
STEP 3	268XA	A10	damp
STEP 4	268XA	A5	damp
	OR		
	Scotch-Brite™ 7448		
	gloss appx 45		

High Gloss Finish (1)			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	268XA	A35	damp
STEP 3	268XA	A10	damp
STEP 4	268XA	A5	damp
STEP 5	568XA	CeO	damp
STEP 6	White Wool	Finesse-It™ Finishing Material Easy Clean-up	
	gloss appx 75		

OR

High Gloss Finish (2)			
	Prod.	Grade	damp/dry
STEP 1	366L	100µ	dry
STEP 2	268XA	A35	damp
STEP 3	268XA	A10	damp
STEP 4	268XA	A5	damp
STEP 5	286Q	9µ	damp
STEP 6	White Wool	Finesse-It™ Finishing Material Easy Clean-up	
STEP 7	Black Wool	Finesse-It™ Final Finish Easy Clean-up	
	gloss appx 90+		

- 1) Use a 5" or 6" diameter by 3/16" orbit Random Orbital sander for cut, and a 3/32" orbit tool for finish.
 - 2) Use a Standard Backup pad for the most aggressive sanding, Low-Profile pad for mid-range sanding, and Low-Profile Finishing pad for the best finish.
 - 3) Sand with a north-south, east-west pattern for one minute per one-foot square area. Clean the workpiece surface between steps to prevent contamination from previous steps.
 - 4) For the buffing/polishing steps, recommend using a variable speed buffer with a 3000 RPM maximum rotation speed (orbital or circular is acceptable).
- * Use this method if you encounter swirl marks using the standard sequence, or if you desire a very high gloss (over 85).

Many components in the three different systems are interchangeable. A component from one system may be used with the other systems in the absence of a given component. Review product packaging for further information regarding product use and warranty. For more specific details, call 3M Technical Service at: 1-866.279.1235

