

3M Colour Coded Polishing Process

PERSONAL SAFETY

• Comfort Particle Mask P3



Hearing Protection



Comfort Goggles



• Reusable Overall





Spot Defects Sanding



► Denib with 3M[™] Finesse-it[™] Trizact[™] film disc, 32mm grade 3000 on denib tool.





466LA Trizact™ A5 Discs 3000

3M™ Mini Orbital Sander, Air Pressure



► Scratch refinement with 3M[™] Trizact[™] Fine Finishing Disc 443SA, grade 5000, 75 mm on orbital sander.







3M™ Precision Random Orbital Sander 75 mm (3 in)

Defects Area Sanding



► Sand the area with 3M[™] Hookit[™] Purple Finishing Film Abrasive Disc 260L, grade P1500 - P2000.



3M™ Hookit™ 260L+



3M™ Hookit™ Interface-Pad Multihole



3M™ Precision Random Orbital Sander 150 mm (6 in)



► Sand the area with 3M[™] Trizact[™] Fine Finishing Disc 443SA, grade 3000, 150 mm on orbital sander.

► Scratch refinement with 3M[™] Trizact[™] Fine Finishing Disc



3M™ Trizact™ Fine Finishing Disc 3000,



3M™ Trizact™ Fine Finishing Disc 5000, 150 mm

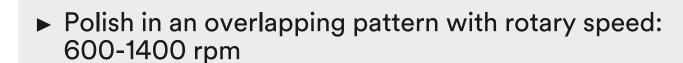


3M™ Precision Random Orbital Sander 150 mm (6 in)

Step Polishing



► Add a small amount of 3M[™] Perfect-It[™] Fast Cut Plus Extreme onto the green foam pad on the rotary polisher.



443SA, grade 5000, 150 mm on orbital sander.

▶ When polishing always try to keep the pad flat on the surface to avoid jumping. Reduce pressure towards the end of the compounding stage to enable easy cleanup.

Note: The softer the coating, the lower the temperature and thus the RPM needs to be.



150 mm

Perfect-It™ Fast Cut Extreme



3M™ Perfect-It™ **Quick Connect** Double Sided Flat Green Polishing Pad



3M™ Perfect-It™ **Quick Connect Double Sided** Convoluted Green Polishing



3M™ High Performance Cloth

Control



► Should sanding scratches from the first polishing step still be visible after controlling the surface, please repeat polishing step!

Note: It is important to ensure that you remove all sanding scratches at the stage, in order to avoid their reapperance at the end of the polishing process.



Plus

Finish Control Spray



3M™ Professional Panel Wipes



- ► Change foam to a yellow foam and add small amount of 3M™ Perfect-It™ Éxtra-Fine Plus onto the pad.
- ► Polish area and surrounding in an overlapping pattern with rotary speed 600-1400 rpm
- ► Processing: keep polishing foam flatly on the surface for glossy finish, reduce pressure towards end of the polishing step.
- ► Wipe off any excess polish and inspect area most colours are fine now.



3M™ Perfect-It™ Extra Fine PLUS

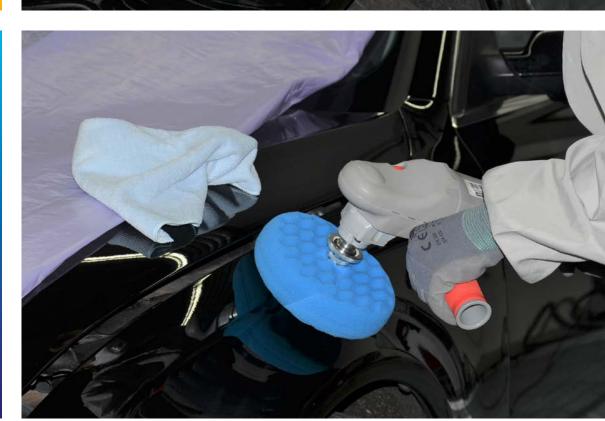


3M™ Perfect-It™ **Quick Connect Double Sided** Convoluted Yellow Polishing Pad



3M™ Perfect-It™ **High Performance** Cloth





- ► Add 3M[™] Perfect-It[™] Ultrafina SE onto the blue foam pad on the rotary polisher.
- ► Processing: polish with reduced speed moving in an overlapping pattern covering generously the whole area.
- ► Wipe off polish residues with the extra soft 3M[™] Perfect-It[™] High Performance Blue Cloth Ultrafina polishing cloth to avoid generating new micro scratches on the surface.

Tip: Always keep the polishing foam wet (using polish), as this delivers a more even coat of polish on the surface and will prevent the generation of the micro scratches from a dry pad.



3M™ Perfect-It™ **Ultrafina SE**



3M™ Perfect-It™ **Quick Connect Double Sided** Convoluted Blue Polishing Pad



3M™ Perfect-It™ **High Performance** Cloth