



3M Colour Coded Polishing Process

PERSONAL SAFETY

• Comfort Particle Mask P3



• Hearing Protection



• Comfort Goggles



• Reusable Overall



• Safety Gloves



Sanding Spot Defects



- 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™ Trizact™ Fine Finishing Disc 5000, 75 mm



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

Sanding Area Defects



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



3M™ Trizact™ Fine Finishing Disc 3000, 150 mm



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



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

Polishing Step



- Add a small amount of 3M™ Perfect-It™ Fast Cut Plus Extreme onto the green foam pad on the rotary polisher.
- Polish in an overlapping pattern with rotary speed: 600-1400 rpm
- 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.



3M™ Perfect-It™ Fast Cut Plus Extreme



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



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



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 reappearance at the end of the polishing process.



3M™ Perfect-It™ Finish Control Spray



3M™ Professional Panel Wipes

Fine Polishing Step



- Change foam to a yellow foam and add small amount of 3M™ Perfect-It™ Extra-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

Hologram Removal (Optional)



- 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

