



3M 1-Step 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, 32 mm grade 3000 on denib tool.



466LA Trizact™ A5 Discs 3000



3M™ Mini Orbital Sander, Air Pressure



- Refine scratches with 3M™ Trizact™ Fine Finishing Disc 443SA, grade 8000, 75mm on orbital sander.



3M™ Trizact™ Fine Finishing Disc 8000



Festool LEX 3 77

Sanding Area Defects



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



3M™ Hookit™ 260L+



Festool LEX 3 150/3



Festool Interface-Pad



- Refine scratches with 3M™ Trizact™ Fine Finishing Disc 443SA, grade 3000, 150 mm on orbital sander.
- Refine scratches with 3M™ Trizact™ Fine Finishing Disc 443SA, grade 8000, 150 mm on orbital sander.



3M™ Trizact™ Fine Finishing Disc 3000



3M™ Trizact™ Fine Finishing Disc 8000

Polishing



- Add a small amount of 3M™ Perfect-It™ Famous Finish Material to a purple 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 clean up.
- Note: The softer the coating, the lower the temperature and thus the RPM needs to be.



3M™ Perfect-It™ Famous Finish



3M™ Perfect-It™ Hookit Convoluted Purple Polishing Foam Pad



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



3M™ Perfect-It™ High Performance Ultra Soft Pink Microfiber Cloth



Festool SHINEX RAP 150

Control



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

Note: It's important to ensure that you remove all sanding scratches at this 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



- Re-Polish the area to ensure a high gloss finish is achieved, with no additional compound onto the foam needed.
- Polish area and surrounding in an overlapping pattern with rotary speed 600 - 1400 rpm.
- Keep the polishing pad flat on the surface to ensure an even appearance and glossy finish, reducing pressure towards the end of the polishing step.
- Wipe off any excess polish and inspect area - most colours are fine now.
- For critical colours (very dark or black) - remove the holograms with 3M™ Perfect-It™ Ultrafina SE Compound and blue polishing pads.



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