Glass Defect Repair System
Conventional coated abrasives tend to dull quickly in a glass repair operation. 3M’s unique Trizact™ film provides long lasting, consistent cut and finish while minimizing the abrasive disc change-over and slurry clean-up.

Micron graded Trizact abrasive films are produced by microreplication — the creation of microscopic 3-dimensional structures applied to a backing in a precise pattern. Trizact film consists of precisely shaped pyramids of fine grade mineral. As the top of these pyramids wear away fresh cutting mineral is continually exposed.

The continual exposure of new mineral ensures a fast, consistent cut rate that easily removes defects such as scuffs, scratches and acid marks on TV/CRT screens, table glass, airplane windscreen and windows, architectural glass and more.

Tests results show that Trizact films last longer than conventional silicon carbide paper and can significantly reduce processing time for scratch and defect removal. 3M Trizact films last longer, cut faster and help provide a superior finish.

The precisely structured surface of Trizact™ film is clearly visible under 50x magnification. 3M is the leading authority on microreplication employing the technology in overhead projector lenses, reflective traffic signs and solar optical film.
3M 268XA
3M™ Trizact™ Film
Removes larger scratches and defects
Use the A35 disc as the first step in removing larger scratches and defects. A small amount of water triggers the cutting action. Controlled water flow helps reduce heat and keep the glass cooler.

3M 268XA
3M™ Trizact™ Film
Refines scratches, removes scuffs and acid marks
Use the A10 disc to refine the scratches left by the A35. Or start with the A10 disc to remove shallow scratches, scuffs and acid marks. Apply a small amount of water to start the grinding action. Control the water flow to avoid generating too much heat.

3M 268XA
3M™ Trizact™ Film
Refines scratches, removes defective AR coatings
Use the A5 disc to further refine any scratches left by the A10. As in previous steps, apply a small amount of water to start cutting action. Avoid extended dwell time to minimize heat build-up.

3M 568XA
3M™ Trizact™ Film
Polishes and leaves glass crystal clear
Use this cerium oxide disc for a final polish. To begin, wet the surface slightly with a small amount of water. As you polish, the pyramids will break down to form a slurry-like solution. The polishing action that occurs will remove scratches left by previous leveling steps.

Aircraft windscreens
Glass furniture
Automobile sunroofs
Our technical support helps guarantee superior results.

### Tools

Glass repair with Trizact film requires a rotary sander (1600 - 1800 RPM) with “on-demand” water feed capability. Contact 3M for recommended supplies.

### Back-up Pads

**General purpose pad for use on contoured surfaces.**

3M™ Stikit™ Disc Pad CWF  
Part number 06681  
Dimensions: 5” x 3/4” x 3/4” CH x 5/8 - 11.

**Siffer pad for use on flat surfaces.**

3M™ Stikit™ Disc Pad - K-Face  
Part number 70148  
Dimensions: 5” x 3/4” x 3/4” CH x 5/8 - 11.

### Process Recommendations

#### TV and CRT Screens

<table>
<thead>
<tr>
<th>Defect Categories</th>
<th>Recommended Process</th>
</tr>
</thead>
<tbody>
<tr>
<td>Scratches, Dings</td>
<td>A35 - A10 - CE0</td>
</tr>
<tr>
<td>Light Scratches, Scuffs</td>
<td>A10 - CE0</td>
</tr>
<tr>
<td>Hard Coats (oxides) A5 - CE0</td>
<td>A5 - CE0 or CE0 only</td>
</tr>
<tr>
<td>Glass Frit</td>
<td>CE0</td>
</tr>
<tr>
<td>Silica Coating (anti-glare, &amp; static)</td>
<td>CE0</td>
</tr>
<tr>
<td>Flouric Acid Spots</td>
<td>CE0</td>
</tr>
</tbody>
</table>

#### Tempered Glass (Aircraft Windscreens, Float Glass and other Harder and Tougher Glass)

<table>
<thead>
<tr>
<th>Defect Categories</th>
<th>Recommended Process</th>
</tr>
</thead>
<tbody>
<tr>
<td>Scratches</td>
<td>A35 - A10 - A5 - CE0</td>
</tr>
</tbody>
</table>

To achieve superior results you need the right “tools”. Let our technical experts explain the best procedure for your glass repair operation.

For complete instructions or for help optimizing your glass defect repair system, contact your authorized 3M distributor or call Superabrasives and Microfinishing Systems Department at: 651-737-1783.

For a list of distributors in your area call 1-800-742-9546.