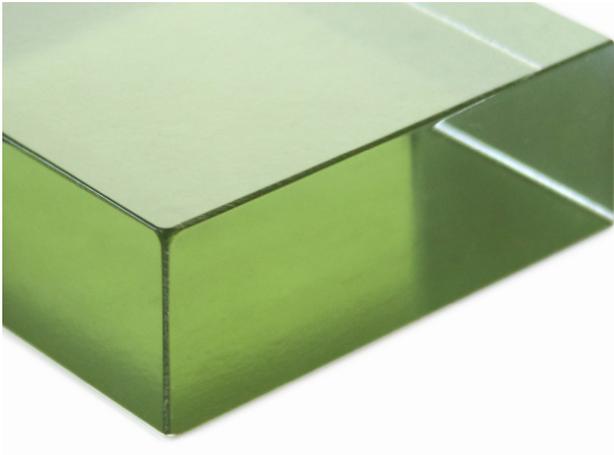


Fabrication

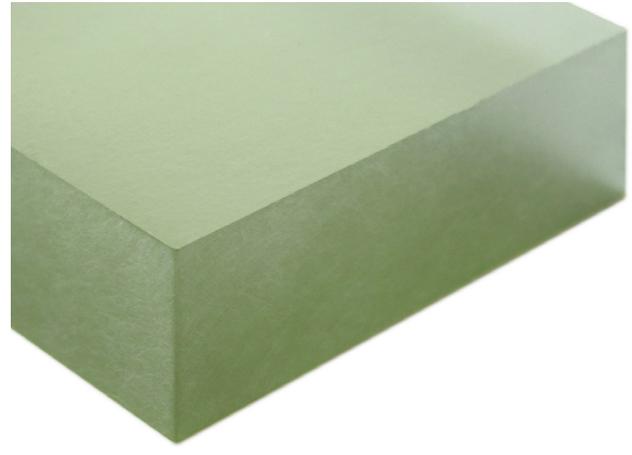
EDGE FINISHING

Resin Panel edges can easily be polished to a gloss or matte finish using common abrasives.

GLOSS EDGES



MATTE EDGES



FINISHING EDGES TO GLOSS

EQUIPMENT & MATERIALS

- Safety glasses
- Dust mask
- Random orbital hand sander
- Buffing wheel or hand buffer (cotton or flannel wheel)
- 150 (optional), 220, 400, and 600 grit sandpaper
- #0000 super fine steel wool*
- 3W770A (white) buffing compound*
- Novus #2 (optional)

*Use of steel wool and 3W770A buffing compound is not recommended with Java (coffee beans) or Recycled Glass décors.

INSTRUCTIONS

- ① Put on safety glasses and dust mask.
- ② Clamp the Resin Panel to a work table to minimize vibration.
- ③ Use 220 grit sandpaper on a random orbital hand sander to remove saw/router marks. If saw marks are especially deep, 150 grit sandpaper can be used first. Keep the sander perpendicular to the edge to prevent rounding. Do not use excessive pressure.
- ④ Use 400 grit sandpaper on a random orbital hand sander to remove the 220 grit marks.
- ⑤ Use 600 grit sandpaper on a random orbital hand sander to remove the 400 grit marks. If easing the edge, perform this step prior to continuing.
- ⑥ Use the steel wool pad (dry) in linear movements to remove the 600 grit marks.
- ⑦ Apply buffing compound 3W770A (white) to a cotton or flannel buffing wheel spinning at full speed. If the part size is too large, use a hand buffer at a speed of 4.
- ⑧ Polish the edge to a gloss finish with the buffing wheel, using slight pressure and a back and forth motion. If needed, Novus #2 can be used to further gloss the edge.

FINISHING EDGES TO MATTE

EQUIPMENT & MATERIALS

- Safety glasses
- Dust mask
- Random orbital hand sander
- 150 (optional), 220, and 400 grit sandpaper
- Red Scotch-Brite

INSTRUCTIONS

- ① Put on safety glasses and dust mask.
- ② Clamp the Resin Panel to a work table to minimize vibration.
- ③ Use 220 grit sandpaper on a random orbital hand sander to remove saw/router marks. If saw marks are especially deep, 150 grit sandpaper can be used first. Keep the sander perpendicular to the edge to prevent rounding. Do not use excessive pressure.
- ④ Use 400 grit sandpaper on a random orbital hand sander to remove the 220 grit marks.
- ⑤ Use the red Scotch-Brite pad in linear movements to remove the 400 grit marks.

EDGE SEALING

Resin Panels containing certain décors can experience moisture wicking. If a panel will be exposed to moisture during the fabrication process or in the installation environment, such as shower doors and vanity tops, edge finishing and sealing should be performed by Lumicor for optimal performance.

These instructions are based on information we believe to be reliable. The information is offered in good faith, but without guarantee, as conditions and method of use are beyond our control. We recommend prospective users determine the suitability of Lumicor materials and suggestions before adopting on a commercial scale. In no case is Lumicor, Inc. liable for direct, consequential, economic, or other damages. Lumicor disclaims all other warranties, expressed or implied, including the warranty of merchantability and fitness for a particular purpose.