

3M TRIZACT FINISHING SYSTEMS

FOR USE ON LUMICLEAR, LUMIGUARD,
LUMIFORM & POLYCARBONATE

3M™ Acrylic Solid Surface Finishing

With 3M™ Trizact™ Film Abrasives

Finishing acrylic-based solid surfaces with 3M™ Trizact™ Hookit™ II film abrasives is quick and easy. Just follow these simple instructions for matte, semi-gloss, high gloss finishes.

Tools You'll Need

- Random orbital disc sander (10,000 – 12,000 rpm)
- Spray bottle

Accessories:

Description	5" Diameter Part Number
3M™ Hookit™ II Disc Pad	PN 05245-1
Hookit™ to Hookit™ II Conversion Pad*	PN 02327

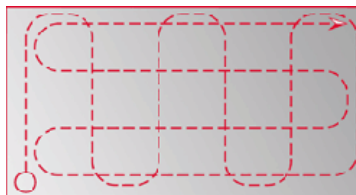
*Converts a standard Hookit or other hook-type disc pad to a Hookit II disc pad

Tips and Techniques

- Do not use Trizact™ abrasives dry.
- Start and stop the sander while resting flat on the surface to eliminate swirls
- While sanding, follow a “North, South, East, West” pattern. (See diagram below) To ensure previous scratches are removed and a uniform finish is achieved, two “patterns” per step are recommended.

Note: If a sanding pattern is visible on the surface of your material after sanding in this pattern, move the sander in a small circular motion, while following the “North, South, East, West” pattern.

Keep it clean! Rinse debris from the Trizact disc after each use, and wipe surface clean following each step to minimize contamination scratches.



Finishing Steps – Matte Finish

1. Apply 3M™ Microfinishing film – 366L, 100 micron (brown) to your Hookit™ II backup pad. Begin sanding your solid surface material in the pattern above. (This step is done dry. Do not spray the surface with water.) This step is intended to remove any defects in the surface of the material and to level the surface. Defects will be highlighted while sanding. Sand until all defects are removed and the surface is level.

After you've sanded the entire surface, wipe the surface clean. If all previous scratches and irregularities have been removed, and the surface appears flat and uniform, proceed to Step 2. If defects remain, repeat Step 1. (Be sure to rinse all debris from your work surface and abrasive disc.)

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2. Replace the 100 micron (brown) disc with 3M™ Trizact™ Hookit™ II disc – 268XA, A35 (green). Spray the work surface till it is damp, not flooded. Begin sanding in the same pattern and at the same rate as the previous step. Spray with water as necessary to keep the surface damp. Repeat the pattern twice OR sand at a rate of 1 minute per square foot of material.

Rinse the debris from the Trizact disc and your work surface. Wipe the surface clean and inspect your work. For many materials and colors, you will now have a satisfactory, matte finish. If not proceed to Step 3.

3. Repeat the procedure using 3M™ Trizact™ Hookit™ II – 268XA, A10 (blue). Rinse the debris from the Trizact disc and your work surface. Wipe the surface clean and inspect your work. You should now have a uniform matte finish. (Gloss level 12 – 15.)

Option: When generating a matte finish, Scotch-Brite™ hand pad 7447 (maroon) can be used instead of the Trizact A10 disc. On some solid surfaces, Scotch-Brite pads can “draw the color out” of the material better than Trizact film. The Scotch-Brite pad can be used by hand or trimmed to fit your sander. Can be used wet or dry.

Finishing Steps – Semi-Gloss Finish

1 2 3 Follow the matte instructions above. (Using 366L 100 micron, and Trizact 268CA, A35, and A10.)

4. With 3M™ Trizact™ Hookit™ II – 268XAm A5 (orange) on your sander, spray the surface and sand in the usual “North, South, East, West” pattern. Repeat the pattern twice. Wipe the surface clean and inspect your work. You should now have a uniform semi-gloss finish. (Gloss level approx. 45.)

Option: When generating a semi-gloss finish, Scotch-Brite™ hand pad 7448 (gray) can be used instead of the Trizact™ A5 disc. On some solid surfaces, Scotch-Brite pads can “draw the color out” of the material better than Trizact film. The Scotch-Brite pad can be used by hand or trimmed to fit your sander. Can be used wet or dry.

Finishing Steps – High Gloss Finish

1 2 3 4 Follow the procedure for semi-gloss finishes through the Trizact film A5 (orange) step. (Abrasives used so far are 366L 100 micron, and Trizact 268XA – A35, A10, and A5.)

1. Using Trizact™ Hookit™ II – 568XA (white), spray the surface and polish in the usual sanding pattern. Two to four passes may be necessary.

Rinse the debris from the Trizact disc and your work surface. Wipe the surface clean and inspect your work. You should now have a rich looking, high gloss finish. (Gloss level approx. 80.)

Alternate Step 5. If you desire a very high gloss (level higher than 80), or encounter swirl marks using the standard sequence, use 3M™ Wet-or-dry™ Polishing Paper – 286Q, 9 micron (blue) instead of Trizact 568XA (white). Buff with Finesse-it™ Finishing Material – Easy Clean-up (PN 83483-9). 3M™ Imperial™ Polishing Film discs – 968M can be used as carrier for this compound using your random orbital sander. (These are sold separately – NOT included in the standard kit.) For faster buffing time, use a rotary buffing tool and a wool buff pad.

*Polycarbonate material will not polish to optically clear. Very fine scratches will remain after all steps in this process are complete.