

Standard operating procedure to create a gloss edge finish on Lumicor sheets.

If your Lumicor application will be exposed to moisture during the fabrication process or in the environment (shower doors, vanity tops, etc.) it is important to seal the edges. Sealing the cut Lumicor edge sufficiently will prevent moisture from wicking into the sheet.

EQUIPMENT

- Safety Glasses
- Dust Mask
- Random Orbital Hand Sander
 - o 150 (for deep saw marks), 220, 400, 600 grit sandpaper and #0000 Super Fine Steel Wool*
- Buffing Wheel or Hand Buffer (Cotton or Flannel Wheel)
 - o 3W770A (White) Buffing Compound*

**Note: Use of Steel Wool pad and 3W770A (White) Buffing Compound is not recommended with Recycled Glass, Java (coffee beans) or Seaside (seashells) décors.*

PROCEDURE

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

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