



Top Coat Rubbing

The purpose of top coat rubbing is to level the surface by removing nibs and orange peel texture common from spray applications of finishing material. Leveling is usually followed by polishing operations to bring the surface to a desired degree of luster and to clean and remove the residue of previous operations. 3M brings together a number of products to form a compatible system. It provides greater efficiency and precision. Flexibility is a major advantage of the system. Experimentation with various combinations will lead to a procedure that works best with your operation. Once you have a technique established, it can be used again and again for consistently superior results.



Guidelines for achieving 45 to 55 sheen

1. One round with Imperial Wetordry paper 401Q, grade P600 loaded on a rubbing machine and used with a cutting oil.
2. One round with Scotch-Brite Cleaning and Polishing Material Type T on rubbing machine used in conjunction with Finesse-it Compounding Material.

Guidelines for achieving 55 to 75 sheen

1. One round with Imperial Wetordry paper 401Q, grade P600 loaded on a rubbing machine and used with a cutting oil.
2. One round with Imperial Wetordry paper 401Q, grade 1200 with a cutting oil.
3. One round with Scotch-Brite Cleaning and Polishing Material Type T with Finesse-it Compounding Material.

Guidelines for achieving 75 to 95 sheen

1. One round with Imperial Wetordry paper 401Q, grade P600 loaded on a rubbing machine and used with a cutting oil.
2. One round with Imperial Wetordry paper 401Q, grade 1200 with a cutting oil.
3. One round with Scotch-Brite Cleaning and Polishing Material Type T with Finesse-it Compounding Material.
4. One round with Scotch-Brite Cleaning and Polishing Material Type T with Finesse-it Finishing Material.

For Best Results

Here are some tips for getting maximum performance from the 3M™ Top Coat Finishing System.

- 1- Make sure that your lacquer is cured properly before beginning the top coat rubbing procedure.
- 2- Use plenty of cutting oil for even results.
- 3- Be careful not to over cut the lacquer finish. If some orange peel or minor defects remain after coated abrasive cut down, the Finesse-it™ / Scotch-Brite™ step(s) should take them out.
- 4- Clean the surface between steps with a diluted soap solution (a few drops of liquid detergent in a pint of water).
- 5- If you use rags, be sure they are 100% cotton.
- 6- Always rub in the direction of the wood grain.
- 7- Use an adequate amount of Finesse-it™ material to keep the surface wet in the Scotch-Brite™ surface conditioning products rubbing steps.
- 8- Spread out the Finesse-it evenly on the surface with the Scotch-Brite™ product being used before you begin rubbing.
- 9- Double loading of Scotch-Brite™ Cleaning and Polishing Material Type T may enhance results.
- 10- Use ebony colored Finesse-it™ on dark wood and ivory on light colored wood.



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