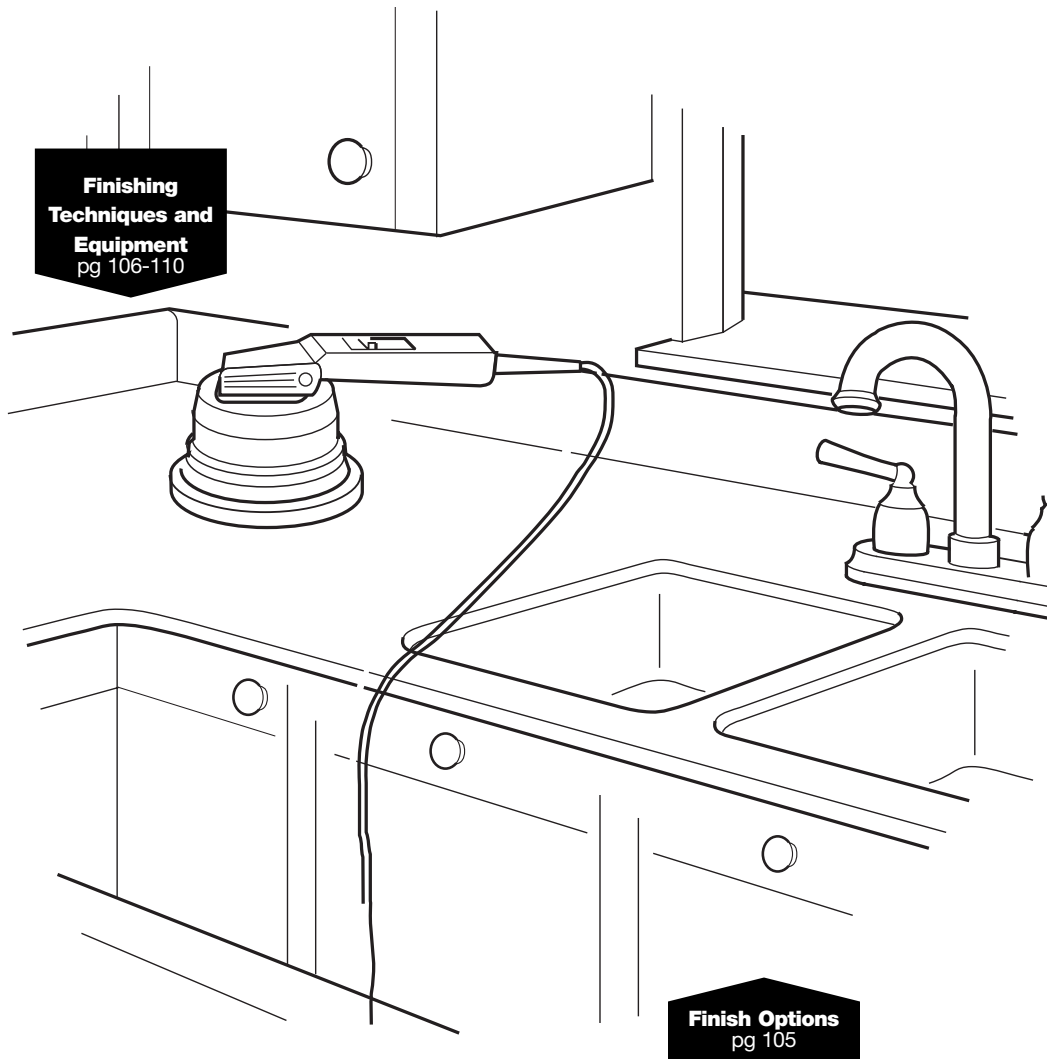


# Finishing Visual Index



## Finishing Formica® Solid Surfacing

Formica® Solid Surfacing sheets and molded shapes are finished to a satin finish in the factory but fabrication and installation operations, as well as customer selection of other finishes, make it necessary for the fabricator and/or installer to adjust the final finish.

There are three basic finishes that are used. Each of these have certain advantages and disadvantages which should be seriously considered for each application. The properties of these finishes are described below:

Finish	Properties	How Maintained
<b>Matte</b>	<p>A soft, low gloss finish which “hides” minor scratches, etc.</p> <p>Best used on light colors.</p>	<p>Soap and water, abrasive cleaners, Scotch-Brite® pad #7447 or equivalent.</p>
<b>Satin</b>	<p>A soft, semi-gloss finish which enhances visual appearance of dark solids and patterns.</p> <p>Slightly more stain resistant than matte finish.</p>	<p>Soap and water, abrasive cleaners, Scotch-Brite® pad #7448 or equivalent.</p>
<b>Polished</b>	<p>A high gloss finish which enhances the visual depth, and character of dark solids and patterns.</p> <p>Most stain resistance due to surface characteristics.</p> <p>Most difficult to maintain minor scratches, and mars are more noticeable.</p> <p>Resanding and polishing require special skills and equipment.</p>	<p>Soap and water, non-abrasive cleaners on a soft, non-abrasive cloth.</p>

## Sanding Abrasives

The abrasive mineral of choice for finishing solid surfacing material is aluminum oxide. It is available in various sizes from coarse to extremely fine in either the P-graded grit or micron forms. The following is a relative comparison of these two grading systems.

P-Grade	Micron
P120 grit	100 micron
P150 grit	N/A
P180 grit	80 micron
P220 grit	60 micron
P320 grit	40 micron
P400 grit	30 micron
P600 grit	15 micron

Both the P-graded grit and micron systems have a tight control of the size distribution. This results in fewer deep scratches and a better finish in fewer steps. The use of standard grit sized abrasives is not recommended due to the large distribution range for each grit size, which can result in a poorer finish quality and more sanding steps.

Aluminum oxide abrasives are available in various forms, which have their own specific purpose and utility. The basic forms used to finish solid surfacing material are as follows:

### Sanding discs

Available with heavy weight paper or film backing in various diameters and hole configurations to fit various random orbital sanders. Can be obtained in both wet or dry sanding versions with hook-and-loop backs.

#### Micron

3M® 268L or 366L film backed discs in 100, 80, 60, 40, 30 and 15 micron sizes.

3M® Trizact® film\* in 268XA-A35, -A10, -A5 micron sizes.

#### P-Graded Grit

3M® 255L film backed discs or Mirka® Q-Silver in P-120, -150, -180, -220, -320, -400, -600 grit sizes.

*\*The Trizact® abrasives have a unique uniform aluminum oxide structure, which causes it to last much longer than conventional forms of aluminum oxide abrasive particles. This results in a more uniform finish from start to finish, since the abrasive is not changing as it wears.*

## Non-woven Nylon Abrasive Pads:

Used for final finishing to matte or satin finish, maintenance, etc. Generally used in two grades:

**Maroon** (very fine) for matte finish

3M® Scotch-brite® #7447

Mirka® Mirlon #447

**Gray** (ultra fine) for satin finish

3M® Scotch-brite® #7448

Mirka® Mirlon #448

## Mirka® Abralon Foam Backed Pads:

An alternate to the non-woven nylon pads for final finishing to a matte or satin finish. The foam backing results in more even pressure, which helps eliminate certain finishing problems. Can be used wet or dry with hook-and-loop equipped sander bases. Generally used in the following sequence to obtain a matte or satin finish after first sanding to a P220 grit or 30 micron level.

**Abralon 8A-241-180:** Preliminary step (Evens out finish on high and low pressure areas)

**Abralon 8A-241-360:** Gives matte finish

**Abralon 8A-241-500:** Gives satin finish

**Abralon 8A-241-1000:** Gives a satin-plus finish

Abralon pads can also be used to obtain higher gloss levels without the use of buffing and polishing compounds. This can be accomplished by first sanding to a P320 grit or 30 micron level and then wet finishing with the Abralon pads in the following sequence.

**Abralon 8A-241-360**

**Abralon 8A-241-500**

**Abralon 8A-241-1000**

**Abralon 8A-241-2000**

**Abralon 8A-241-4000**

## **Liquid Polishing Compounds:**

Used to obtain polished finishes after pre-finishing to a P600 grit or 15 micron level. Must be used with a power buffer.

**First buffing step:** 3M Finesse-it® Compounding Material #051144-77340

**Final buffing step:** 3M Finesse-it® Finishing Material #051144-81235

## **Major Abrasive Suppliers:**

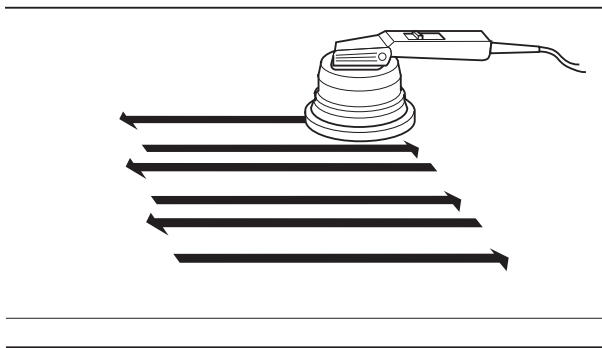
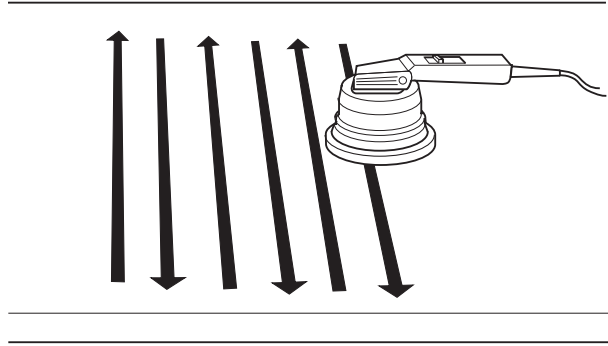
3M Abrasive Systems Division  
3M Center, Building 223-6N-01  
St. Paul MN 55144-1000  
888-364-3577  
<http://www.mmm.com/abrasives>

Mirka Abrasives Inc  
7950 Bavaria Road  
Twinsburg, OH 44087  
800-843-3904  
<http://www.mirka-usa.com>

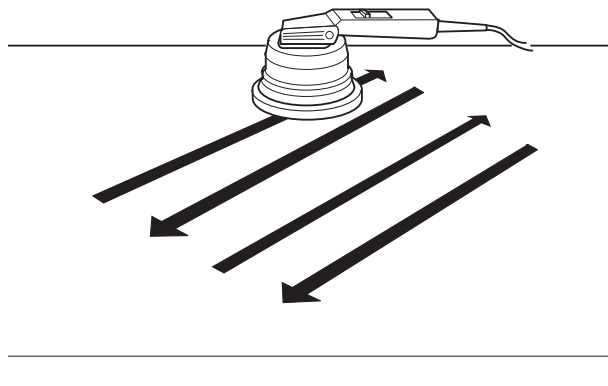
# Finishing

## Basic Sanding Technique

- 1** First, sand in one direction. Overlap about one-third with each pass.



- 2** Next, sand in a direction that is perpendicular to the first step. Overlap about one-third with each pass.

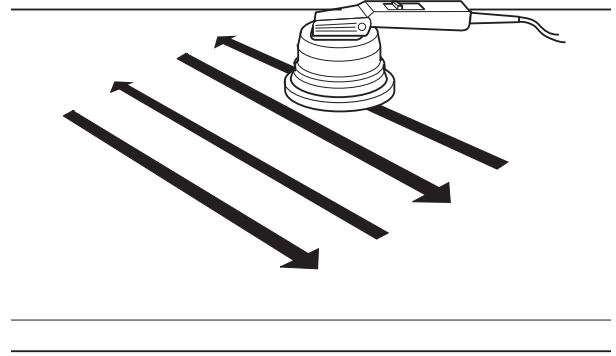


- 3** Next, sand at a diagonal as shown. Overlap about one-third with each pass.

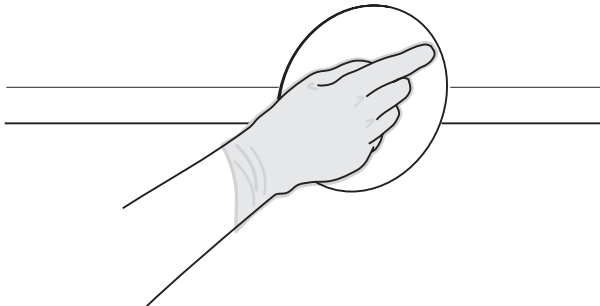
# Finishing

## Basic Sanding Technique

- 4** Finally, sand in opposite diagonal direction as shown. Overlap about one-third with each pass.



- 5** Remove paper from sander and hand sand the edges.



- 6** Brush off and wipe clean with a damp cloth.

*Repeat steps 1-5 with each abrasive size until desired finish is obtained.*

