

VELSTONE SANDING & FINISHING

Equipment Required

Orbital Rotary sander, Sanding paper, Buffing Wheel, Lambs Wool Bonnet

Matt Finish - Standard

Start with 120 grit paper and, in gradual steps, finish with 240/ 320/400/500/600 and then 900 grit paper. It is imperative that sanding is carried out in circular motion whilst observing that orbital sander isn't operational in one area too long. Make sure any dust created is wiped off before moving to the next grade of paper.

At joint locations, approximate surface area of 100mm on either side of the seam should be sanded as well to achieve a more natural (blended) finish.

Most installations only require a 600 grit finish*.

Satin Finish

Complete the sanding for the matt finish as described above and mount 60 micron paper on the sanding pad. Sand until the scratches from previous operation are removed. Follow up with 30 micron paper and 15 micron paper for a uniform "Satin" finish.

Gloss Finish

Complete the Satin finish process and clean the surface thoroughly with a clean rag. Use heavy duty hand held Buffing machine with a minimum 200 mm disc, buffing adapter and lamb's wool bonnet. Apply 3M Marine Paste Compound, (White) number 009374 or equivalent*, to the bonnet and start buffing. Keep the buffing tool moving at all times to prevent overheating. The buffing tool must be tilted and enough pressure must be applied to flex the pad so that less than 50% of the bonnet remains in contact with the surface. The Marine Paste Compound will remove the 30 and 15 micron sanding swirls created in earlier process. Carry on buffing until all sanding swirls are removed. Change the buffing bonnet if residue starts to build up on the bonnet. During the entire buffing process repeated cleaning of the surface with a clean moist rag is important. Closely examine the surface to see if all sanding marks or swirls have been removed and the surface is clean. Ensure that there is no residual paste or foreign particles on the surface to achieve a super high gloss finish.

Start the next step to achieve High Gloss. Mount a new buffing bonnet and apply 3M Finishing Material, number 03974 or equivalent, on the bonnet. Continue buffing to obtain requisite level of high gloss finish, replacing the buffing bonnet with a clean bonnet as necessary.

It is possible to achieve Mirror finish if all the above steps are meticulously followed.

* High traffic areas (in any colour) or Dark colours are recommended to be given a gloss finish to improve their scratch/stain resistance.

** Any Fast cutting compounds can be used such as **Roberlo** 990F, **Farecla** G3 Liquid FARG3LIQ or **3M** 3M09374