



Polishing

BY HAND

Remove machine marks with a sharp steel scraper. Next use medium sandpaper Nos. 150, 300 and 400 in this order. After this process, polish on a cloth wheel, **using alkaline-free polish paste such as green chromium oxide at a wheel speed of 30-35 m/sec.** Apply light uniform pressure over the entire surface. End by polishing on the cloth wheel without polish.

To avoid heat build-up in the sheet, which may lead to discolouration, allow cooling intervals or use a Reiter polishing disc.

BY MACHINE

Smooth the cutting marks or flash with wet medium sandpaper No. 220 until they are invisible. Then change to wet cork band. In order to obtain a high polish, end by polishing on the power disc. To avoid heat build-up in the sheet, which may lead to discolouration allow cooling intervals or use a Reiter polishing disc.

Vapor Polishing

Set up a small electric heater and a suitable vacuum flask or modified pressure cooker as shown in the attached sketch.

Raise the temperature of a suitable amount of methylene chloride to 40° when the solvent will begin to boil. Direct the methylene chloride vapour from the end of the hose towards the edge of the sheet. Keep the hose approximately 10 mm from the surface to be polished.

A convenient length of hose is approximately 500 mm. If the hose is too long, the cooling effect will cause condensation of the vapour before it reaches the exit. If it is too short, manoeuvrability is restricted.

Slowly and steadily direct the vapour along the sheet edge. The surface will become glossy almost immediately. When the surface has been allowed to air dry (1 minute), the vapour may be reapplied as necessary to produce a uniform surface.

It is always better to return to an area for touch up than apply too much vapour at one time. Excessive methylene chloride will cause flaws, runs or damage eventually the mar-resistant coating.

Keep the sheet masked where possible. Restrict the vapour to the edges of the sheet.

Quickly wipe off drops of liquid methylene chloride that may inadvertently come into contact with the surface or edge of the sheet.

Within a few minutes the sheet will be dry enough to handle. Take all necessary precautions to prevent scuffing or other damage during transportation.

Warning: Use only in well ventilated areas and/or enclosed fume cupboard and avoid direct solvent or fume contact.

