

EnduraPanel

Bringing **colour** to life

Repair & Maintenance

Repairing EnduraPanel Gloss Panel

FINE SCRATCHES

Fine scratches can be buffed out with 3M Trizact Spot Finishing or a commonly available micro-polish such as Brasso. Use a clean soft cloth and always polish in a circular motion. Remove polish residue with warm water immediately.

DEEPER SCRATCHES

3M has developed a complete restoration system for EnduraPanel.

Equipment and supplies required:

Electric 6" Dual Action sander (capable of connecting to a dust extractor for dust-free application)

3M Hookit 6" 15-hole interface pad

3M 150mm Hookit 15-hole Back Up Pad

3M P600 260L 150mm 7-hole sanding discs

3M P800 260L 150mm 7-hole sanding discs

3M P1000 260L 150mm 7-hole sanding discs

3M P1500 260L 150mm 7-hole sanding discs

3M P3000 150mm finishing discs

Electric, hand held, variable-speed angle polisher capable of handling 200mm pads

3M 5709 Adaptor (to attach polishing back-up pad to polisher)

3M 5718 Perfect-It Back-Up Pad

3M 5735 Perfect-It Polishing Foam Pad

3M P3000 6070 Trizact Spot Finishing Material

Dust extractor complete with integrated appliance socket

Water spray

Cloths

Repair Principles :

The principle involved in repairing and polishing surfaces is to progressively use finer and finer abrasives to flatten the previous step's scratches. Initially using the least-abrasive disc to remove the scratch or scuff will minimise the number of steps to finish the job. Using a coarse abrasive to start with will mean extra work to finish and also may remove too much acrylic material causing a distorted, uneven surface.

Method :

The degree of damage to the acrylic sheet will dictate what grit size is used for initial removal of the scratch or scuff marks. The deeper the scratch the more aggressive or lower number grit size abrasive is required.

1. Set up dust extractor unit and attach DA sander
2. Attach back up pad and Interface pad on DA sander
3. Inspect the damage to the acrylic panel



Scratched Panel

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Repairing EnduraPanel Gloss Panel cont

4. Depending on the depth of scratch, select abrasive disc and attach to interface pad.



Dry sanding with 3M 260L

5. Sand damaged area of acrylic sheet to remove damage. Carefully wipe any dust from surface before starting next sanding step. Inspect for scratches. Continue sanding if previous step's scratches have not been removed.

6. Repeat step 5 with progressively finer abrasives including P1500 – try not to over-sand damaged area. Feather edges beyond previous step.



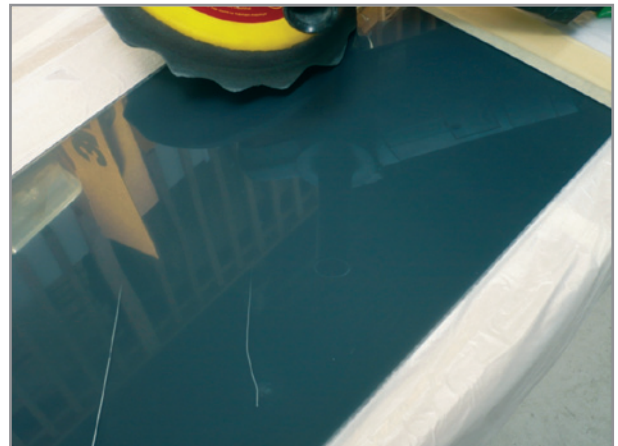
Damp finish with 3M P3000 Finishing Disc

7. Attach P3000 disc to the interface pad. Spray SMALL amount of water on the disc (this acts as a lubricant). Too much water and the disc will aqua-plane. Keep the disc moist.

8. Sand areas of no more than 400mm x 400mm. Any larger and the disc may dry out too quickly. Continue sanding until a greyish/white sludge is seen around the edge of the disc.

9. Carefully wipe sanded area.

10. Attach the adaptor to the polisher and attach the 5718 back-up pad to the adaptor. Place the foam pad on the back-up pad.



Polishing with 3M Trizact Spot Finishing

11. Apply about 20-25mm amount of 6070 Spot Finishing Material to the buff. Without starting the machine, spread the 6070 Spot Finishing Material over the area being refurbished.

12. With the polisher on a low speed, begin polishing using back and forth movements. If the Buff is new there may be a need for extra Spot Finishing Material. Increase the speed of the polisher to no more than 1800 rpm maintaining back and forth movement.

13. If there are any scratches visible there may be a need to go back to step 5, 7 or 11 depending on the amount and depth of scratch.

Repairing EnduraPanel Frosted Panel

Equipment and supplies required:

All of the equipment required for the repair of EnduraPanel Gloss panel

Mobile Bead Blasting gun

Air compressor

Alluminium Oxide abrasive grit

1. Repair of EnduraPanel frosted Panel is much the same as for gloss panel. Remove the scratch or damage following the above process, finishing at step 6.
2. The surface must now be returned to a Frost finish using a 'bead blast' technique. Practice before attempting this repair as the variables of grit size, distance and angle of nozzle from surface and air pressure will all impact upon the final finish.

Maintaining EnduraPanel

Wash with mild soap or detergent, using plenty of warm water. Dry with a soft cloth or chamois.

Grease, oil or tar can be removed with Metholated Spirits or Isopropyl Alcohol. Solvent residue should be removed by washing immediately.

Do Not Use: window cleaning sprays, scouring compounds, steel wool, harsh scrubbing brushes, chloroform, acetone, benzene, toluene, xylene, dichloromethane, amyl acetate, glacial acetate acid, butyl alcohol, butyl acetate, cellusolve, cresols/phenols, ethyl acetate, chlorinated solvents, halogenated solvents, methyl alcohol, sulphuric acid, dilute acids, MEK methyl ethyl ketone (PVC pipe glue).