

Process Standard

Buffing Procedure

Aerospace Coatings

Step 1

Wet sand panel using a DA (Dual Action) sander with 1500 grit sandpaper (3M 30767) to remove all surface defects, or until all texture is gone and panel is in a complete haze.



Products

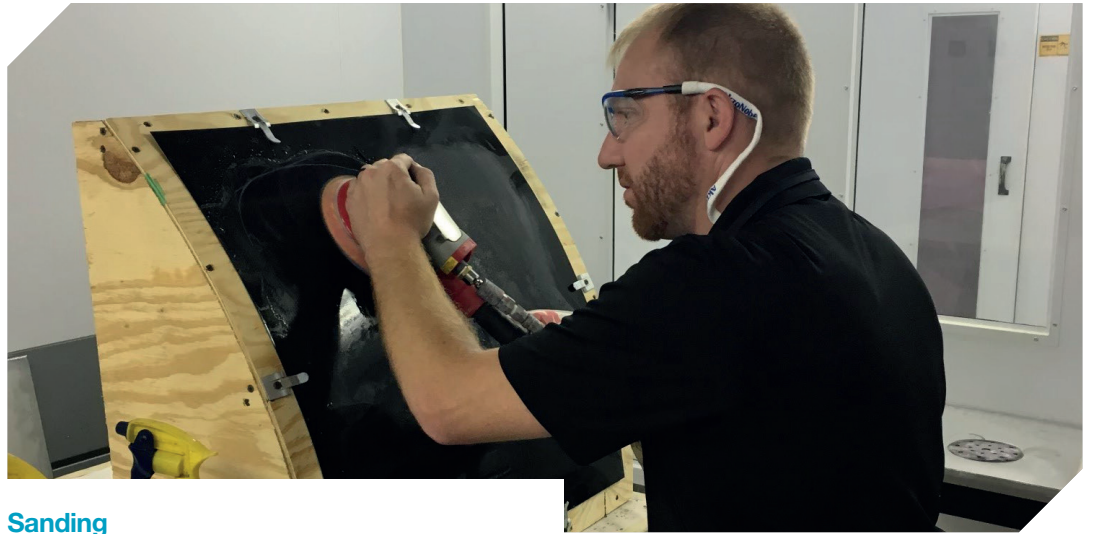
Step 2

Wet sand panel using a DA sander with 3000 grit sandpaper (3M 02085) to refine the 1500 grit scratches to make buffing easier. This should take twice as long as Step 1. You will want to sand until there is foam slurry on the panel.

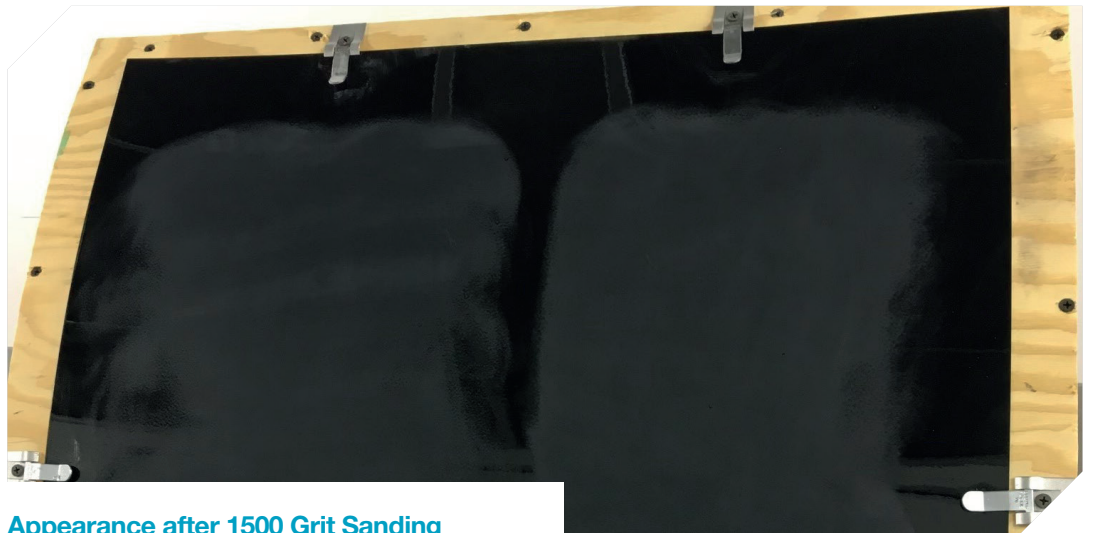


Tools

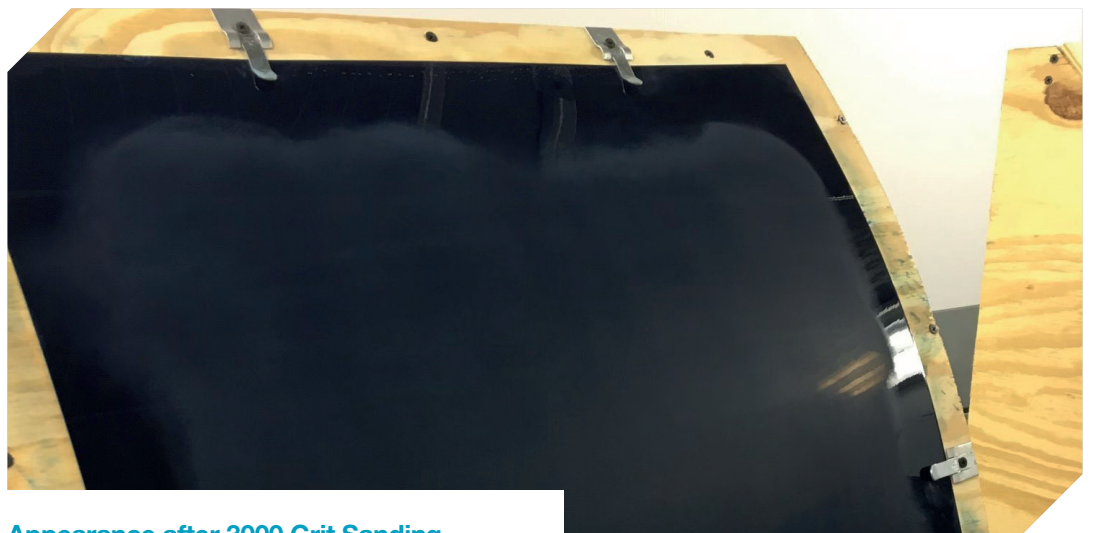
Step 2 continued



Sanding



Appearance after 1500 Grit Sanding



Appearance after 3000 Grit Sanding

Step 3

With buffer and wool pad, apply 3M Aviation Rubbing Compound (3M98544) to the panel. Set the buffer at 1400 rpm and buff the panel. Use a left to right motion as you move down the panel with a 50% overlap. Repeat this process till the panel is brought back to a shine.



Buffing



Wool pad with Aviation compound

Step 4

With buffer and white foam pad, apply 3M Perfect-It EX Rubbing Compound (3M36060) to the panel. Set the buffer at 1400 rpm and buff the panel. Use a left to right motion as you move down the panel with a 50% overlap. Repeat this process until the panel is void of sanding marks and appearance is uniform.

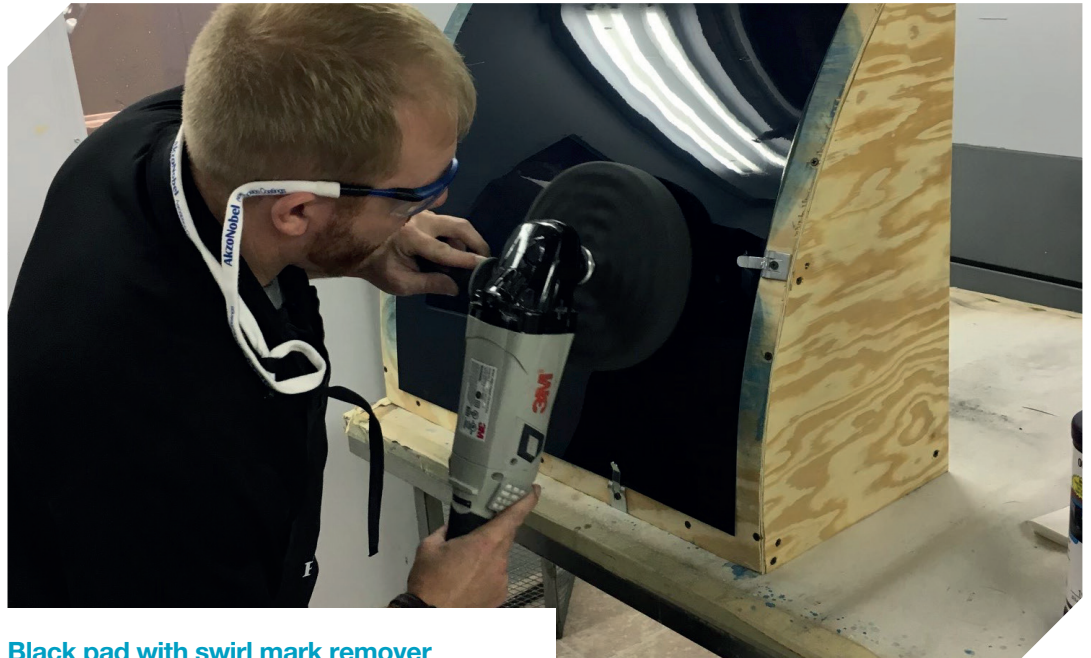


White foam pad with rubbing compound

Step 5

With buffer and black foam pad, apply 3M Perfect-It EX Machine Polish (3M06094) to remove swirl marks left on the panel. Set the buffer at 1200 rpm and buff the panel. Use a left to right motion as you move down the panel with a 50% overlap. Repeat this process till the panel is flawless and there are no swirl marks. Only apply small dots of this product to the panel and move at a brisk pace. If you overheat this product it will gum up on the surface of the panel.

Note: Dark colors may need an additional step of polishing using the 3M Perfect-It EX Ultrafine Machine Polish (3M06068) to remove any fine swirls with the 3M Ultrafine blue foam (3M05708) pad.



Black pad with swirl mark remover

Step 6

Wipe panel clean of any residue with a new/clean micro fiber towel.

Storage: Always follow the storage information and instruction for tools and equipment.

Safety Precautions: Comply with all local safety, disposal and transportation regulations. Check the Safety Data Sheet (SDS) and label of the individual products carefully before using any of the products.



Finished product:



aerospace.akzonobel.com

We've been pioneering a world of possibilities to bring surfaces to life for well over 200 years. As experts in making coatings, there's a good chance you're only ever a few meters away from one of our products. Our world class portfolio of brands – including Dulux, International, Sikkens and Interpon – is trusted by customers around the globe. We're active in more than 150 countries and have set our sights on becoming the global industry leader. It's what you'd expect from the most sustainable paints company, which has been inventing the future for more than two centuries.

For more information please visit www.akzonobel.com.

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