



Corian.

TECHNICAL NEWSFLASH

FINISHING AND POLISHING OF CORIAN®, WITH EXTRA ATTENTION TO HIGHLY PIGMENTED COLOURS*

INTRODUCTION

This bulletin is a reminder of some specifics about the finishing and polishing of **Corian® in general, with extra attention** to highly pigmented colours: (dark and intensive colours like black, red, blue, ...)

The sanding of a highly pigmented colour differs slightly from lighter colours because with these darker/ highly pigmented colours defects or imperfections show up more than with a light colour.

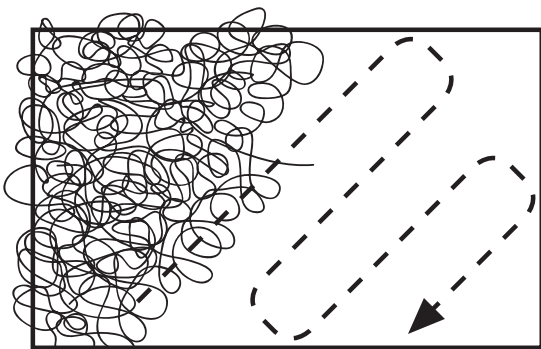
Please consult our guidelines around finishing and polishing Corian® in the technical manual and abridged manual for more information.

CRITICAL SANDING PARAMETERS

The following parameters are key to achieve to a perfect finish:

A. Random movement

Make sure that when moving the sanding machine over the surface this is done in the most random way possible.



B. Pressure

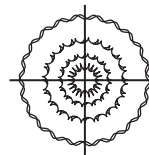
It's important to apply equal pressure all the time. When using abrasives like Abralon we advise applying a slightly higher pressure.

C. Rotational Speed

With most sanding machines the force and speed of the movement can be adjusted. It is recommended to use the highest speed for the first sanding steps (dry), the final finishing steps are best completed at medium speed (wet).

D. Rotational movement

Sanding machines have two positions when it comes to the rotational movement: rotary motion & eccentric motion.



ROTARY Motion (**Forced movement**): combination of rotary and eccentric motions. In this position the sander has a high output (aggressive cut).



ECCENTRIC Motion (**Free turning movement**): this position is selected for sanding with a lower output (fine finish).

We advise to use the eccentric rotation at high speed and medium pressure, when sanding dry, and to switch to rotary rotation at lower speed and slightly higher pressure, when sanding wet or polishing.

E. Sanding pads

It is best to use medium soft pads.

HELPFUL HINTS

- Don't skip sanding steps.
- Clean prior to starting & Clean between each sanding step to remove the dust of the previous step, clean entire surface and inspect for defects and scratches.
- It advisable to clean with water spray and a microfibre cloth.

PNEUMATIC ORBITAL SANDERS

This type of sander is not recommended for the finishing of highly pigmented colours. Most of the time the sanding pads are thinner and harder and the random orbital movement is less controlled.

STILL NOT GETTING THE RIGHT FINISH? COMMON ISSUES








- Moving the sander too fast or unevenly.
- Not overlapping passes while going north/south and east/west.
- Not going over the material a minimum of 3x with each paper.
- Not visually inspecting and wiping down completely between each step.
- Skipping/leaving out sandpaper grades.
- Using a torn pad and/or paper.
- **Sander maintenance not optimal.**

DCT, DEEP COLOURS

- The finishing and polishing of deep colours is not different from the other **highly pigmented** Corian® colours.
- With DCT you can obtain a deeper / more intense colour
- When these colours are used in an environment of intensive use we advise to finish the top not higher than a **standard semi-gloss finish**

SUGGESTED SANDING PROCEDURE

In addition to the proposed sanding steps in the manuals here are some alternative sanding steps for standard (semi gloss) and for high gloss finish. Because the rotation, speed/force and pressure are very important, here is some guidance for the setting of a Festool Rotex RO 150: in general, rough sanding with µ-paper can be done dry, in "Free-rotating" position, and at maximum speed. Make sure there is adequate dust extraction. With Abralon abrasive we advise to use water, a slightly higher pressure, "Forced rotation" and medium speed. Polishing is done with a polishing paste, a special pad like felt or sheepskin, and also with slightly higher pressure, "Forced rotation" and reduced speed.

Standard Semi-Gloss Finish					
Sanding Medium	Rotation	Pressure	Speed	Extraction	Water
White, and light colours					
100µ or P120		Medium	High (6)	Yes	No
60µ or P240		Medium	High (6)	Yes	No
Abralon 500 or similar		Higher	Medium (4)	No	Yes
Black, and highly pigmented colours					
100µ or P120		Medium	High (6)	Yes	No
60µ or P240		Medium	High (6)	Yes	No
40µ or P400		Medium	High (6)	Yes	No
Abralon 500 or similar		Higher	Medium (4)	No	Yes

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High Gloss Finish					
Sanding Medium	Rotation	Pressure	Speed	Extraction	Water
All colours					
100µ or P120		Medium	High (6)	Yes	No
60µ or P240		Medium	High (6)	Yes	No
40µ or P400		Medium	High (6)	Yes	No
Abranet Soft 800 or similar		Medium	High (6)	Yes	No
Abralon 500 or similar		Higher	Medium (4)	No	Yes
Abralon 1000 or similar		Higher	Medium (4)	No	Yes
Abralon 2000 or similar		Higher	Medium (4)	No	Yes
Abralon 4000 or similar		Higher	Medium (4)	No	Yes
Felt pad or sheep skin		Higher	Medium (4)	No	Yes
+ Festool Polishing Paste 500					

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