FINISHING RECOMMENDATIONS FOR DURASEIN NOCTURNE

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The appearance of the finish on a solid surface countertop is something that can vary dramatically. A variety of factors including equipment, abrasives, techniques, lighting conditions and even material color can have an effect on the final look of the countertop finish. It is the responsibility of the fabricator to develop the finishes and processes that they offer and to educate their customers about the details and expectations about those finishes. Although finishing can be thought of as an art form, there are procedures and techniques that can help to assure finishes that are efficient and consistently high quality.

Dark colors can be a challenge. The appearance of dark colors can vary dramatically under varying lighting conditions. Even minor scratches at the surface can be visible. The level of finishing can also have a significant effect on the appearance of the color. For these reasons, we are providing the following recommendations for finishing Durasein Nocturne. Keep in mind that these steps are just one suggestion of how to achieve the desired finish. The type of paper, style of sander, dust control, operator proficiency and other factors will contribute to the ultimate finish.

GENERAL POINTERS FOR FINISHING SOLID SURFACE TOPS:

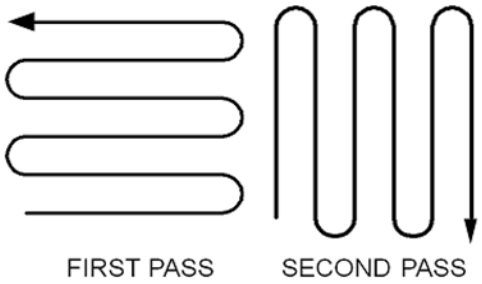
- Establish a uniform procedure used by every finisher in your company. Define a process that works for you and always use the same process with all your employees.

- Use the right equipment. In the first one or two stages (coarser grits) use sanders with a rigid backer pad. As the grits get finer use more gentle finishers like the random orbital finishing sanders with a flexible backer pad.

- Use engineered abrasives with uniformly controlled particle size to reduce random scratches and pig-tailing. Examples are micron finishing papers and other grade abrasives that are engineered for solid surface and manufactured with controlled particle sizes. Typical “P” grade papers used in woodworking contain poorly controlled particle sizes for the type of finishes required for solid surfacing. They contain relatively large random particles that scratch the surface and produce visible scratches and cloudy areas. Be sure your abrasives are designed for solid surfacing.

- Eliminate the use of papers coarser than 180 grit. Although commonly used, abrasives with 120 grit and 100 grit can result in cloudy areas that are difficult to remove. For dark colors, eliminate papers courser that 400 grit.

- Use “pattern sanding” with proper overlap techniques to assure uniform coverage at each stage of the finishing process.



- Check your sander pads. Wear-and-tear and abuse can lead to damaged pads that can result in a poor finish. Also, firmer pads should be used in the beginning steps but softer back-up pads can help achieve a better look with the finer finishing steps.

- Use sanders with dust extraction. This will keep the surface cleaner and allow the sandpaper to work more efficiently.

- Carefully clean the surface between grits. Dust can get trapped and result in scratches in the surface. Water in a spray bottle, with just one drop of liquid detergent added, will do the trick. Microfiber cloths work well for this.

- Keep heat of friction at a minimum. Let the tools do their job without the operator pressing down excessively. Sanders will do their best job at design speeds. Pushing down on the sander results in uneven scratching and unwanted heat build-up as well as pre-mature wear and tear on the equipment.

SPECIFIC STEPS FOR NOCTURNE AND OTHER DARK COLORS:

The factory finish on Durasein Nocturne is equivalent to 400 grit. The recommended steps to sand Nocturne to match the finish the sheet to Durasein 2x2 samples is:

400 grit (firm backer pad);

Change to soft backer pad; 600 grit Wurth Velvet Part Number WR58734306096110

- **AV6006 600G AIR VELVET DISC 6"**

800 GRIT; gold buff PAD Wurth Velvet Part Number WR58734308096110

- **AV8006 800G AIR VELVET DISC 6"**

Some gloss finishes may require increasingly finer grits and polishing compounds. It is a good idea to provide your customers with samples that are actually produced with the sanding process used in your shop.

Keep in mind that these steps are just one suggestion of how to achieve the desired finish. The type of paper, style of sander, dust control, operator proficiency and other factors will contribute to the ultimate finish.

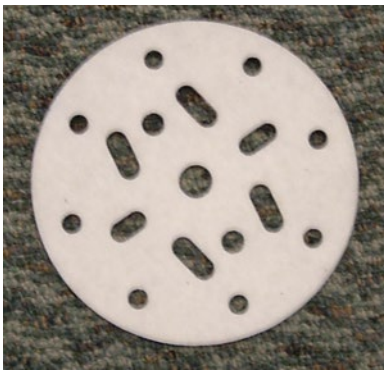
PROCESS DETAILS:

Sander Type:

Random orbital sanders are the recommended type of equipment for finishing Durasein® solid surface. Particularly good are models that have variable speed and connections for dust extraction. Some manufacturers have larger models that can be used for covering large deck areas in shorter amounts of time. The random orbital pattern helps to provide uniform finishing without being overly aggressive.

Interface pads:

Interface pads, or backer pads, should be an integral part of the finishing process. Use a thin, rigid pad on your sander to help keep the sander's original pad in good condition. The interface pad takes the wear & tear of continually mounting and removing the abrasive discs.



Use a thicker, softer pad on your sander to help maintain gentle pressure on the countertop. It helps to reduce any potential to scratch the top with the edge of the abrasive paper.

Dust extraction:

Use sanders with dust extraction. This will keep the surface cleaner and allow the sandpaper to work more efficiently. Dust extraction at the source has been proven to be an effective way to get better finishes on your tops

Cleaning between Steps:

Carefully clean the surface between grits. Dust can get trapped and result in scratches in the surface. Water in a spray bottle, with just one drop of liquid detergent added, will do the trick.