

Products for the treatment of **Gelcoat in production facilities**



Polishing processes for the **TREATMENT** of Gelcoat in production facilities.

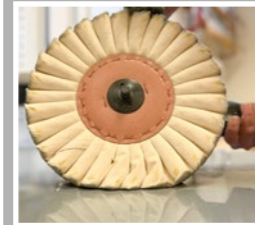


Manual polishing lathe



1. Application of polishing compound

Solid pastes are held against the rotating polishing wheel and wet it in this way. Polishes, on the other hand, are dispensed from the bottle directly onto the workpiece.



2. Polishing

The workpiece is held against the rotating polishing wheel and constantly moved. When the polishing compound is used up, fresh polishing compound is applied.

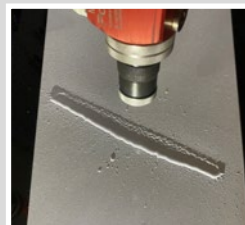
Typical usage

Solid pastes are often used for small components that can be held well against the polishing stand. Edges of covers are often polished to a high gloss in the polishing lathe. There are suitable solid pastes for practically all gelcoat and top-coat variants. For a perfect mirror finish, however, a polish must be used in the last step.

Advantages of the solid paste

Solid pastes are very easy to use and have a very long shelf life. In applications, the pastes and the corresponding polishing wheels can be changed very quickly. For larger workpieces, hand-guided machines such as angle grinders, straight grinders or satin finishing machines are also available on which suitable polishing wheels can be mounted.

Flatbed polishing machine with cotton rings



1. Spray burst of high-pressure dispensing gun

Emulsions and diluted ointments are applied to the polishing roller by high-pressure gun or alternatively to a large area of the part by brush.



2. Flatbed-polishing of cotton

Wide, rotating polishing shafts are fitted with polishing wheels to form a polishing roller. This rotates above a conveyor belt on which flat parts are laid out.

Typical usage

Flatbed machines are used for series production and larger orders. The heavy polishing unit with the rotating rollers is moved linearly over the table until the desired surface quality of the workpieces is achieved. Larger flatbed machines are equipped with several different polishing units and a conveyor belt.

Advantages of emulsions/creams

Emulsions are predestined for a high degree of automation with only minimal human intervention. Emulsions are automatically dispensed from pressure tanks using high-pressure guns. Due to the absence of solvents, emulsions are practically odourless. Creams are very flexible to use. The application is very robust and allows large process windows.

Rotary manually operated machine



1. Application of polishing compound

The polish is liquid and is applied evenly to a foam pad or lambswool using a dosing bottle.



2. Rotary manual polishing

The machine is held by hand on the component and the speed is slowly increased. Work is carried out only with moderate pressure in a crossing motion.

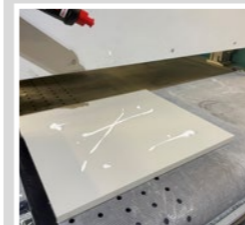
Typical usage

This process is ideal in particular for large components such as boat hulls or body parts that cannot be machined on a flatbed machine due to their contour or geometry. For all applications where the initial quality of the surfaces to be polished differs greatly, e.g. due to shape contours or shape defects, selective reworking can be carried out.

Advantages of polishes/creams

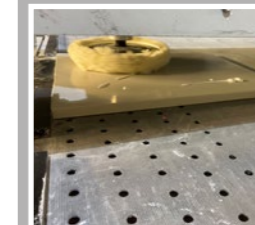
Polishes or thinned creams can be combined with different polishing pads or lambswools; users are thus very flexible and can easily react to different initial qualities, the machines are hand-guided and can therefore be used in any position. High productivity values can be achieved with high-quality polishes.

Flatbed machine with foam pad or lambskin



1. Application of polishing compound

Polishes are applied to large areas of the workpieces from a dosing bottle or via a high-pressure nozzle. Water is often sprayed on as well.



2. Flatbed-polishing pads

Rotating foam pads or lambswools move on the surface of the workpieces to be processed, which lie on a conveyor belt.

Typical usage

This is often the last operation in a linked flatbed polishing process with several polishing units. Polishing marks created by the combination of cotton and coarse polishing agents are reliably removed. Especially for dark Gelcoat, this is the only possible choice for the series process.

Advantages of polishes

Polishes produce a particularly fine and streak-free polishing pattern on flatbed machines, which cannot be achieved with emulsions or creams. Polishes can be easily dispensed by the operator at the machine. The cleaning of the surface is easy, so that the quality control of the final surface is possible.

Our product options

for the specific process

		Pre-polishing						Polishing				Finishing			
Cut (20 = heavy Cut, 1 = low Cut)		20	18	16	14	12	10	8	7	6	5	4	3	2	1
Manual polishing lathe	Solid pastes	GW 18		P 195	P 204			GW 16				P 175			
	Polishes											G 52			SFP 3800 PO 281
Rotary manually operated machine	Creams						AS 30								
	Polishes					SHCC 300 IF			HCC 1100		HCC 1000	HCC 400 IF	MCP 2000	FF 3000	SFP 3800 PO 281
Flatbed polishing machine with cotton rings	Creams					AS 61									
	Emulsions		PE 75						PE 57 E			PE R 10			
Flatbed machine with foam pad	Polishes								HCC 1000				MCP 2000	FF 3000	

Our product program for polishing Gelcoat in production facilities

Name of product	Container*	Art.-No.	Cut	Gloss	Contained solvents			Polishing Tool			Description
					Organic solvents	Odorless organic solvents	Water	Cotton	Lambswool	Foam pad	
Solid pastes											
GW 18	Handpieces of 1,2 kg	12001.056.001	20	3 - 4				•			Very abrasive paste for pre-polishing, removes deep defects. GW 16, for example, is suitable as a follow-up step.
P 195	Handpieces of 1,3 kg	07978.056.001	16	7 - 11				•			Abrasive paste optimised for pre-polishing plastic parts. Polishing marks can be removed afterwards with e.g. P175.
204	Handpieces of 1,3 kg	07936.056.001	14	9 - 14				•			Abrasive paste when slightly more abrasiveness is required than with GW16, gloss is slightly reduced with P204.
GW 16	Handpieces of 1,2 kg	12002.056.001	8	13 - 16				•			Standard paste and starting point for all polishing work on Gelcoat surfaces. Unsurpassed combination of abrasiveness and gloss.
P 175	Handpieces of 1,3 kg	07984.056.001	4	17 - 18				•			Finishing paste for touching up after pre-polishing. Produces a high gloss that can only be surpassed by polishes.
G 52	Handpieces of 1,2 kg	12146.056.001	4	17 - 18				•			Finishing paste as an alternative to P175 with a little more grease. For uniform gloss on components with complex geometry.
Creams											
AS 30	Buckets of 1 kg	14995.203.001	10	6 - 9		•	•		•		Inexpensive cream for pre-polishing. Diluted with water, glycerine or white spirit as required.
AS 61	Buckets of 15 kg	14033.210.001	12	11 - 15	•			•			Cream for pre-polishing. Can be thinned with liquid hydrocarbons, e.g. white spirit, depending on the desired viscosity.
Emulsions											
PE 75	Hobbock of 40 kg	21988.220.001	18	4 - 6			•	•			Coarse and quick pre-polishing paste for severe imperfections. A follow-up step with PE R10, PE57E or a polish is often necessary.
PE 57 E	Hobbock of 40 kg	21034.220.001	7	14 - 16			•	•			Fine polishing emulsion when very fine pre-sanding. Is also suitable as a follow-up step for PE75. A polish can be a follow-up step.
PE R 10	Hobbock of 35 kg	20918.220.001	4	16 - 17			•	•			Finishing emulsion produces a high gloss that can only be surpassed by polishes.
Polishes											
SHCC 300 IF	Bottle of 1 Litre	22204.261.001	12	8-12		•	•		•	•	Very abrasive polish for large-area and productive use, removes heavy sanding marks in a very short time.
HCC 400 IF	Bottle of 1 Litre	22202.261.001	5	12-18		•	•		•	•	Abrasive polish, particularly suitable for removing individual imperfections and for refinishing. Very good combination of cut and gloss.
HCC 1000	Bottle of 1 Litre	22984.261.001	6	6-8	•		•			•	Abrasive inexpensive polish for removing sanding marks, optimised for use with foam pads.
HCC 1100	Bottle of 1 Litre	22930.261.001	8	5	•		•			•	Abrasive polish for removing traces of abrasion, optimised for use with lambswool.
MCP 2000	Bottle of 1 Litre	22106.261.001	3	15-18	•		•			•	Particularly suitable for automated finishing on flat-bed machines after PE75. Use with foam pads.
FF 3000	Bottle of 1 Litre	22029.261.001	2	19	•		•			•	Suitable for automated finishing on flatbed machines. Produces slightly more gloss, but is less abrasive than MCP2000.
SFP 3800	Bottle of 1 Litre	22992.261.001	2	19	•		•	•		•	Finishing polish for absolute high gloss. Use with molleton rings on the hand polishing lathe or foam pad.
PO 281	Bottle of 1 Litre	22730.251.001	1	20		•	•	•		•	Special polish for polishing decorative parts for the best possible shine. More productive cleaning of surfaces compared to SPF3800.

* other containers upon request

Perfection in Polishing

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