RECOMMENDATIONS FOR POLISHING PAINTED SURFACES

• Use buffing speeds of 6 - 24 m/s (Depending on the temperature sensitivity of the paint)
• Carefully set up the sanding process >> it has a significant influence on the surface quality after polishing
• Make sure final sanding is not too rough >> extends polishing times >> pronounced heating of the work piece >> “orange peel” or surface wear/waves

> Use Menzerna high-performance polishing pastes:
  - Optimised bond
  - Better adhesion to the polishing wheel
  - Effective heat dissipation

MENZERNA FOR GLOSS:
+ Automobile interiors
+ Picture frames
+ Boat and yacht building
+ Violin and piano building
+ Arts and crafts
+ Kitchens
+ Furniture

Menzerna demands are solid compounds are suitable for manual work stations as well as fully automated polishing systems. In large and small series, they set consistent surface quality standards with a wide variety of work piece geometries.

Menzerna creams and polishes are developed especially for the industrial processing of highly sensitive wood coatings. With manual or automated application, they produce a deep, glossy finish even with dark colours.
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## MENZERNA POLISHING COMPOUNDS FOR PAINTED SURFACES

### SOLID COMPOUNDS

<table>
<thead>
<tr>
<th>Type</th>
<th>Name</th>
<th>Grit Size</th>
<th>Container Size</th>
<th>Polishing wheel</th>
<th>Colour</th>
<th>Suitable for</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Medium Cut</td>
<td>P204</td>
<td>P600</td>
<td>approx. 1.2 kg (12002.050.001)</td>
<td>Cotton</td>
<td>Beige</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
<tr>
<td>Polish</td>
<td>GW16</td>
<td>P600</td>
<td>approx. 1.4 kg (12003.050.001)</td>
<td>Cotton</td>
<td>Orange</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
<tr>
<td>Finish</td>
<td>P175</td>
<td>P600</td>
<td>approx. 0.4 kg (12004.050.001)</td>
<td>Cotton</td>
<td>Yellow</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
<tr>
<td>Finish</td>
<td>P175</td>
<td>P800</td>
<td>approx. 0.4 kg (12005.050.001)</td>
<td>Cotton</td>
<td>Yellow</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
<tr>
<td>Polish</td>
<td>GW16</td>
<td>P800</td>
<td>approx. 0.5 kg (12006.050.001)</td>
<td>Cotton</td>
<td>Orange</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
<tr>
<td>Polish</td>
<td>P085U</td>
<td>P800</td>
<td>approx. 0.5 kg (12007.050.001)</td>
<td>Cotton</td>
<td>White</td>
<td>Greasy</td>
<td>Paint, plastic/composites</td>
</tr>
</tbody>
</table>

### PROCESS RECOMMENDATIONS*

**Surface before Polishing**

- **Heavy Cut**: PE-COATING, Grit Size P600
- **Medium Cut**: PU-COATING, Grit Size P600
- **Polish**: PU-COATING, Grit Size P800

**Final Surface**

- **Heavy Cut**: PE 75
- **Medium Cut**: PE 57E
- **Polish**: PE R10

**Surface Before Polishing**

- **Heavy Cut**: PO 91L
- **Medium Cut**: AS 61
- **Polish**: PO 85U

**Final Surface**

- **Heavy Cut**: PE 75
- **Medium Cut**: CREAM
- **Polish**: PO 91L

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*The process recommendations provided here were prepared based on our best knowledge. They cover most common practical applications. Additional products are available for other applications.

**Contact**: industry@menzerna.com, www.menzerna.com