

No. 537

## High-gloss finish on authentic wood surfaces



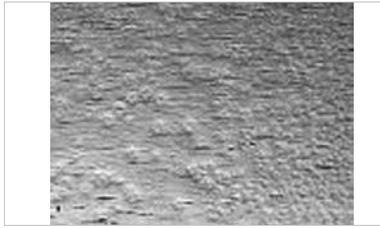
A

### Description

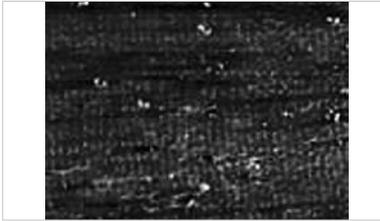
High-gloss surfaces are experiencing an unexpected renaissance in the furniture industry. This primarily concerns the kitchen furniture industry, but also in the music industry (loudspeakers, instruments), as well as in the case of free-standing cabinets, e.g. in the bedroom, as well as in the bathroom and interior fittings, the high-gloss finish has now become a fixed feature.



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However, cells (see Fig. 537/02), bubbles (see Fig. 537/03), as well as sanding marks or irregularities in the paintwork, are often faults which can be remedied by sanding and polishing thus resulting in a high-quality surface again.

High-gloss polishing is a time-consuming procedure. Therefore, when preparing the surfaces to be painted attention should be given to the careful selection of the subsurfaces, a clean environment and paint/lacquer application and drying according to the manufacturer's instructions.

Here Festool offers the user a complete selection of tools, sanding and polishing agents, as well as the optimal clamping system VAC SYS.

Using the vacuum clamping system VAC SYS a quick, safe and "clean" clamp of the workpieces is made possible, as well as ergonomic work.

The application example describes a quick procedure on how high-gloss surfaces can be achieved efficiently in three steps.

## B

### Tools/Accessories

Festool offers various alternatives for creating edge grooves. The two alternatives should facilitate the selection, even if components are already available:



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Designation	Order No.
Vacuum clamping system Vacuum set VAC SYS Set SE 1 (see Fig. 537/05)	712223
Eccentric sander ETS 150/3 EQ Plus (see Fig. 537/06)	571542
CTM series mobile dust extractor	
Stickfix abrasive sheets Ø 150 mm:	
• Titan 2 STF-D150/8-P 1500-TI 2	492349
• Platin 2 STF-D150/0-S 2000-PL 2	492371
• Platin 2 STF-D150/0-S 4000-PL 2	492372
Rotary polisher SHINEX RAP 150 FE (see Fig. 537/08)	570762
Premium sheepskin pad LF-PREM.-STF-D150	49383
Foam polishing pad orange PS-STF-D150X30-M-OCS	493852
Polish SPEED CUT MPA 5000	496299
Polishing cloth MPA microfibre	493068
Finish cleaner MFA-F	439066



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## C

### Preparation/Set-up

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Important prerequisite for optimal success!

The following points must be observed for a brilliant high-gloss effect and are decisive in the result:

- careful preparation of the subsurface
- dust-free environment during application
- sufficient hardening of the high-gloss paint
- observe the processing recommendation, and above all the drying times of the paint/lacquer manufacturer
- clean work environment during polishing

The following 3 work steps are described and must be followed precisely:

1. Sand the surface using Festool eccentric sander ETS 150/3 EQ with Titan 2 sandpaper.
2. Sand and polish using Festool eccentric sander ETS 150/3 EQ and Platin 2 sandpaper
3. Polish with Festool rotary polisher SHINEX RAP 150 FE and SPEED CUT MPA polish MPA 5000.

Using the Festool vacuum clamping system VAC SYS Set 1 the workpieces are held securely for sanding and polishing and can be positioned and adjusted accordingly thanks to the tool's ergonomic design. For secure clamping of larger workpieces it is possible to connect another clamping unit (VAC SYS SE 2) to this system.

Thus the workpieces are away from the table area and unintentional absorption of particles during polishing is avoided. The vacuum clamping system is an ideal aid for sanding and polishing.

## Procedure



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For authentic wood and veneered surfaces

In general, the eccentric sander is moved without applying huge pressure and in a slow motion over the surface (cross-grinding). For the following work steps all grits are sanded, if they are wet and no dust extractor is used, until no more glossy areas are visible on the surface.

Attention: Do not sand too dry! There is then the risk that the sanding dust will clump too much and leave scratches or marks on the surface.

### 1. Sanding the surface:

Sand the surface using eccentric sander ETS 150/3 and sanding disc Titan 2 P 1500 until no more glossy areas are visible.

### 2. Polishing and sanding:

Sand the surface with Platin 2 S 2000 and S 4000 until a homogeneous, fault-free surface is obtained.

Tip: After each grit change the surface must be cleaned using the microfibre cloth.

### 3. Polishing:

SHINEX RAP 150 FE, premium sheepskin pad and polish SPEED CUT MPA 5000

- Position sheepskin pad on rotary polisher SHINEX RAP 150 FE.
- Apply polish MPA 5000 on the workpiece surface.
- Using the deactivated rotary polisher SHINEX RAP 150 FE and the sheepskin pad apply the polish evenly on the surface.
- Start up rotary polisher SHINEX RAP 150 FE at speed level 1 and distribute the polish evenly.
- During operation adjust the speed level to 3 - 4.
- Guide the tool freely over the surface. Otherwise there is a risk of excessive heating of the surface!
- Wipe the surface several times using the green microfibre polishing cloth and check. If required repeat the process described. No recognisable sanding marks should remain and the surface should have a consistent and even gloss level.

If required:

Polishing with MPA 8000 and orange pad.

Tip: Wash the microfibre cloths under running water after each polish change or at the end of work.

# FESTOOL

Our example for use is a recommendation tried and tested in practice. However the actual conditions pertaining in each situation are completely outside of our control. We therefore do not provide any form of guarantee. Any legal claims arising out of this are not to be made against Festool. Please observe without fail the safety and operating instructions included with the product.

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