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## **Coating: High gloss finish with subsequent polishing/buffing"**

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High gloss finishes require experience in using the equipment and materials as well as an established workflow and careful application from sanding the raw material, through priming right through to the final coating. Errors that have already occurred when pre-treating the substrate or when priming have an adverse effect right up to the final layer, and in most cases can only be rectified insufficiently and at great expense.

### **Coating materials:**

PUR, clear and coloured HYDRO (see separate technical information)

### **Sanders:**

- Orbital sander, 2.5 to 5 mm lift, e.g. by Mirka, Festool, Metabo/Sander, 3M
- Specialist abrasive 1,000 - 3,000th grain size, where necessary up to 4,000th grain size as well

### **Polishing tools:**

- Hand polisher with electronic speed regulator of 700 - 2,000 revolutions/minute, e.g. from Fein, Mirca, Festool, Flex
- With buffing wheel (Molton, lambskin, felt, foam rubber)
- Soft polishing cloths

### **Polishing pastes:**

#### e.g. from Bauerrichter

- Shine wax 16
- 16/10 V 'Spezialsalbe'
- High shine wax GG 358
- Specialist 25/2 polish

#### e.g. from Mirka

- Polarshine T12
- Polarshine F 05
- Polarshine UF 3

#### e.g. from 3M

- Finesse-it
- Perfect-it III extra fine

Please request detailed information about suitable polishing pastes and working techniques from the manufacturers.



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### **Care:**

ZD 520 furniture polish

### **Workflow:**

#### Priming:

- 2-3 coats of primer, sprayed clean as topcoat
- Leave each to dry at least overnight
- 320 - 600 abrasive grain or
- 3 coats of wet-on-wet primer
- Allow to dry for 20 - 45 minutes between each coat
- Leave to dry at least overnight
- 400 - 600 abrasive grain

Please refer to the technical information for each product.

#### Hint:

- Repeat priming as long as necessary until the finished layer of primer appears completely smooth before final sanding.
- After the final layer of primer, several days should be set aside to let the primer harden completely.
- With clear coatings we recommend initial priming with a DG 572-1 PUR insulation primer to ensure bonding, even with difficult timber and
- See also "Clear High Gloss Finish" technical information to improve the condition of the subsequent finish.  
With a coloured PUR high gloss finish, an intermediate finish with diluted UNA colour in the same shade as the coloured PUR high gloss, applied between the primer coat and the high gloss, improve the condition of the high gloss finish.

#### High gloss finishing:

- 1 x high gloss finish
- Leave to dry at least overnight
- 600 -1000 abrasive grain
- 1 x high gloss finish
- Leave to dry for at least 2 - 5 days depending on the product
- or, better still,  
2 - 3 wet-on-wet high gloss finishes
- Allow to dry for 30 - 60 minutes between each coat
- Leave to dry for at least 2 - 5 days depending on the product



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### Polishing with specialist sanding products:

- 1,000 or 2,000th grain surface sanding
- Three-dimensional and small parts with orbital sander
- Flat parts with automatic or belt sander
- 1,000 - 3,000th grain dry/wet polishing sanding with orbital sander

Hint: The finer the grain, the less effort required to polish.

### Polishing/buffing:

- Depending on the object and surface, cover the hand polisher with lambskin, rubber foam, Molton or felt, dampen with polishing paste and if necessary also use a brush to dampen the surface to be buffed with polishing paste.
- Use the polishing machine fitted with a buffing wheel to polish evenly and softly with moderate pressure.  
To avoid buffing through or overheating, use a maximum working speed of 1,200 revolutions/minute.
- Repeat the process with the finest polishing wax until the surface presents the desired shine.
- To avoid buffing through or overheating, use a maximum working speed of 1,200 revolutions/minute.
- Polish again with a foam rubber wheel and polish or water.
- Max. working speed of 1,200 revolutions/minute.
- If required, cleaning and final polish with soft cloth and polish.

Warning: The pastes must be smooth and creamy. If the pastes have thickened they can be diluted with Hesse DH 1305 or OV 190 polishing fluids.

The quality of each high gloss finish depends on the technique used by the person applying it, the condition of the equipment, the room conditions and the drying conditions.

### Machine and paste manufacturers:

- Bauerrichter; [www.bauerrichter.de](http://www.bauerrichter.de)
- Fein; [www.fein.de](http://www.fein.de)
- Festool; [www.festool.de](http://www.festool.de)
- Metabo; [www.metabo.de](http://www.metabo.de)
- Mirka; [www.mirka.de](http://www.mirka.de)
- 3M; [www.mmm.com](http://www.mmm.com)



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**Note:**

This information is advisory and is based on the best knowledge available and careful research in line with the current state of the art. This information cannot be held as legally binding. We also refer you to our terms and conditions of business.

The Material Safety Data Sheet according to the regulation (EC) No. 1907/2006 is available.