

3M™ Perfect-It™ Denibbing System Failure Modes

Sanding

- Sanding at the incorrect speed (too fast, too slow)
- Sanding clears that are too soft may smear the clear – use water when sanding soft clear
- Pressing down too hard while sanding will cause rounded nibs or divots – very light down pressure recommended, let the tool do the work
- Sanding on edge will cause deeper scratches, hard to buff out – keep abrasive flat
- Not sanding long enough – after the shiny is gone, sand for a few more seconds
- Sanding in one spot too long can result in a divot – treat the abrasive like a file and shave the nib off as you move across it.
- Not refining the 1000 grit scratches with 1500 will result in sand scratches remaining after polishing.
- Clogging of the disc will occur while sanding, wipe the disc clean between nibs. Excessive loading of discs can result in deep sand scratches and lower cut rate.

Machine Polishing

- Running the polisher lower than 70 psi will delay scratch removal (70-90 psi).
- Not using enough polish will reduce cut and increase heat which causes sticking.
- Buffing more than one nib at a time (connecting the dots) with the **purple polish** can result in missed sand scratches.
- Moving the polisher too much while buffing will take from time spent on the nib directly (small 5” circular pattern recommended)
- Slinging will result if buff pad isn't collapsed while polishing. Push trigger on and release while the pad is collapsed on the surface to minimize sling.
- Using a foam buff pad too long may cause foam to soften from heat or become soaked with polish. This will result in loss of cut.

Swirl Elimination

- When using the 3” polisher for this step, losing the haze spot is very easy
- When using the 3” polisher for this step, there may be some remaining haze–Using a full size polisher for this step and “connecting the dots” will give optimum results.
- Buffing this product dry is not recommended. Keep the Ultrafine Polish wet.