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Composite Mold Finishing



Visual Effects 4/2001

Quality from start to finish.



Composite Mold Finishing

The key to the industry's finest composite mold finishing system is Abralon – the newest and most innovative abrasive finishing product available.

Abralon's unique construction features a mesh fabric coated with closely sized abrasive particles. This mesh is laminated to foam with a brushed cloth backing for easy attachment to hook-faced backup pads.

The open mesh and foam construction is ideally suited for use with a lubricant. The lubricant flows around the abrasive grains and is absorbed or released by the foam as required. This keeps the work surface cool and prevents damage.

Features & Advantages

Quality

- Elimination of coarse scratches
- Produces improved finish because of the fine scratch pattern
- Improved mold finish reduces defects in molded parts
- Easily conforms to curved and contoured surfaces - especially with the use of an interface pad

Savings

- Fewer defects increase production and reduce rework time
- Reduced labor time to obtain desired finish
- Decreased buffing time, reduced material usage
- Reduction of total abrasive costs

Suggested Finishing Steps

The following guide is designed as a starting point when finishing composite molds. Final grit selection may be changed to meet specific application requirements.

Each column (competitive vs. Mirka) shows an abrasive sequence to achieve the desired finish.

Abralon should be used with a water mist for lubrication. Remember to wipe the surface clean between steps to prevent contamination scratches.

Surface Repair

Competitive	Mirka
220 grit abrasive	Royal 220
320 grit abrasive	Abralon 360

**To finish seams or level repair areas, begin by using 80 grit abrasive, followed by 150 or 220.*

Mold Finishing

Competitive	Mirka
220 grit abrasive	Royal 220
320 grit abrasive	Abralon 360
400 grit abrasive (wet)	Abralon 1000
600 grit abrasive (wet)	
Buff with compound	

Scratch Removal

Competitive	Mirka
400 grit abrasive (wet)	Abralon 1000
600 grit abrasive (wet)	Abralon 2000
Buff with compound	Buff



Step One: Mirka Royal Abrasives

- Progressive Bond™ Technology provides special grain bonding for extreme edge wear resistance.
- State-of-the-art coated abrasives technology.
- Grit for grit, the finest finishing disc available.
- Unmatched load resistance.
- Flexibility like no other – yet tough, with super edge wear.
- Full resin bonding for strength and durability; with a special non-loading stearate.



Step Two: Abralon

- Combines benefits of abrasive cloth and non-woven products.
- Constructed with a fabric face, foam center and a grip backing.
- Abrasive grains are bonded evenly to the fabric face.
- Openings in the fabric allow solvent and air to flow freely around the abrasive.
- Works especially well when sanding contoured surfaces, corners and sharp edges.
- Open cell design holds large amounts of solvent for lubrication and cooling.
- Foam center also provides for even surface pressure that helps eliminate "finger marks" when hand sanding.

