

1. CLEANING

Wash with mild soap or detergent and lukewarm water, rinse well and wipe dry. A soft, non-abrasive cloth should be used.

Furniture polishes such as Johnson's Lemon Pledge or Scott's Liquid Gold are effective in removing mars and fingerprints and will give a good shine to molded parts.

DO NOT USE: Scouring compounds, gritty cloths, gasoline, strong solvents, or metal scrapers such as razor blades.

2. POLISHING

Furniture polishes (mentioned above) will give a high gloss shine to molded parts.

Occasional waxing with a car wax will give both shine and protection, and will cover up minor scratches. Products tested include:

- Liquid Turtle Wax (Turtle Wax Inc.)
- J-Wax (S.C. Johnson)
- Rally Cream Wax (DuPont)

Of these, Turtle Wax produced the best gloss.

CAUTION: As with most plastic materials, avoid contact with strong solvents, paints, lacquers, varnishes, aerosol sprays containing solvents, gasoline, cleaning solutions, fingernail polish and remover, etc. Contact Ineos Nova for additional information when required. A Technical Bulletin on the subject of chemical resistance is available upon request.

3. SCRATCH REMOVAL

Hairline scratches, which can be seen but not detected by fingertip or fingernail, can be removed or masked by automotive cleaning waxes. Of the 3 brands tested, Turtle Wax gave the highest gloss. These waxes should be used as directed. Repeated application will remove hairline scratches.

Minor scratches and deeper scratches (readily detected with fingernail or fingertip) can be removed only by techniques involving sequential treatments with finer and finer abrasives or polishing compounds.

For deep scratches, buff with heavy duty "cutting" stick material applied to the rotating wheel and allow to dry before buffing. Use light to medium hand pressure and move the buffer about slowly until the plastic is removed and the scratch is no longer evident. Clean the wheel then apply a light to medium grade of "cutting" stick material to the buffer and proceed as above. It would be preferable to change the direction of buffing on the plastic surface at this time.

A final polish should then be applied using a fine grade of "polishing" (high-coloring) stick applied to a second (clean) buffing wheel to prevent scratching from the ore abrasive particles in the cutting compounds. Use of a car

wax such as Turtle Wax with a rotary polishing motion will help remove the fine buffing marks remaining after polishing with the buffing wheel and will give a satisfactory finish.

SCRATCH REMOVAL TECHNIQUES

- Micromesh Kits

Available from:
Micro Surface Finishing Products
Box 456
Wilton, IA 52778

These kits have consistently given good results in removing all degrees of scratches. When used according to the directions supplied by the manufacturer, deep scratches can be removed and the surface restored to almost the original high gloss.

- Buffing Wheel Method

An alternate method to the Micromesh Kit is the use of cotton (muslin) buffing wheels (4" or 6" in diameter) and several grades of buffing compounds mounted in stick form. The buffing wheels may be mounted on a fixed, rotating arbor shaft or used in a small 1/4"-3/8" variable speed drill (portable type). Peripheral speed of rotation should be held below 1000 feet per minute to prevent overheating of the plastic surfaces.

RECOMMENDED MATERIALS ARE:

- Cotton buffing wheels (tightly sewed) 4" to 6" diameter
- Heavy-duty cutting buffing stick, Learok No. 857
- Fine to medium cutting buffing stick, Learok No. 884-E
- Polishing (high coloring) buffing stick, Learok No. 312

SOURCE: The Lea Manufacturing Company
237 East Aurora Street
Waterbury CT 06720

- Abrasives

A third procedure uses the following abrasive materials in succession: 600 sandpaper, 3/0 paper, pumice, rottenstone, cleaning car wax. This procedure has the advantage of using readily available materials. It does **not** produce as high a gloss in the final finish as the first 2 methods, so it is recommended only for those areas where the highest gloss is not necessary. All steps should be done with light pressure and a circular hand motion.

NOTE: With any of the 3 procedures listed, it is necessary to remove all of the lines from the previous abrasive before proceeding to the next finer one. If this is not done, dullness and scratches will remain after the treatments.

4. STATIC CHARGES AND THEIR TREATMENT

S/MMA copolymers are excellent electrical insulators, as are most plastic materials and, as such, are very slow to dissipate static charges. Static charges, which attract dust to the surface of the material, may be generated by wiping or rubbing the surface with a dry cloth or by buffing.

Plastic articles may also build up a static charge by rubbing against the wrapping material during shipment, or they may have such charge induced in them during manufacturing or finishing operations.

Wiping the surface of the part gently with a soft, lint-free cloth dampened with water containing a mild detergent solution will usually eliminate the static charge. Repeat occasionally, as required.