

## RECOMMENDED PROCEDURES

From the initial plug, to the mold, and onto the finished part, the complete line of TR professional quality compounds, releases, polishes and related products are designed to produce

the best finish possible at maximum efficiency and minimum cost. The TR 4-step method for producing a high quality surface is reflected in the finished part.

## PRODUCTION TOOLING: MASTERS, PLUG OR MOLDS

Gel-Coat after sanding – center magnified 1000 times.



Figure 1

### 1. Sanding

The initial step in surface preparation should begin after a minimum two week curing period. Grit selection will be determined by the smoothness and condition of the original surface. Progressively finer grit is employed until 600-1200 wet and dry imparts a smooth, satin finish as seen in *Figure 1*.

**Note:** Various compound grit size should not be equally compared or confused to sandpaper grit size. Different results are obtained with compound by its buffing action and techniques.

Gel-Coat after compounding – center magnified 10,000 times.

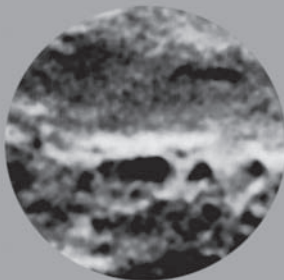


Figure 2

### 2. Compounding

The fine scratches left from the sanding are now removed with a machine buffer and *TR-311 Buffing Compound*. It is important to buff the entire surface, bringing it to a reflective sheen (as seen in *Figure 2*) since previous residue and microscopic imperfections must be removed. Deeper sanding marks and dull spots may require initial buffing with *TR-309 Regular Compound* followed by *TR-311 Liquid Compound* for final finish gloss and smoothness.

Gel-Coat after sealing – center magnified 1000 times.

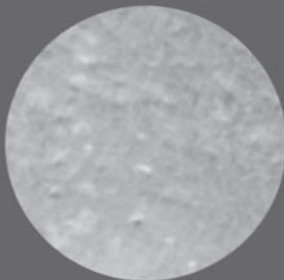


Figure 3

### 3. Sealing

With a machine buffer and clean pads (keep clean to avoid unnecessary scratches) apply two coats of *TR-301 Sealer Glaze*. This application further removes fine scratches, fills in and closes over minute porosity, and produces a high gloss, reflective surface (see *Figure 3*) which is ideally receptive to wax. Each coat should be buffed in opposite directions; once vertically and once horizontally, to insure complete coverage.

Gel-Coat after waxing – center magnified 10,000 times.

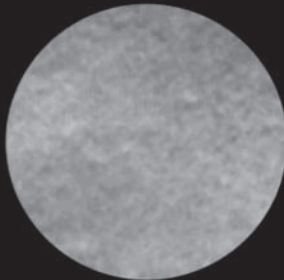


Figure 4

### 4. Waxing

Apply *TR Mold Release Paste Wax* using a circular, overlapping motion. The area being waxed should appear moist, or wet, to assure good coverage. Hand buff with a clean, dry cloth to obtain a final high-gloss finish. *TR-100 Gold*, *TR-102* and *TR-104 Hi-Temp* should dry thoroughly before removing (polishing wipe). When using *TR-108*, hand buff immediately. Do not allow *TR-108* to set before wiping.