

SOP - High Gloss Wood Finishing

- Remove dirt nibs, runs or sags in clear and topcoats
- Produce level, high gloss finish



1. SAND



Gold P800, Polarstar P1500
 #23-612-800, #FA61205094
MR-5 Sander (alt. CEROS 550CV)
915GV20 Backup Pad
9155-5 Interface Pad

Level orange peel and any defects using Gold 800. Follow with 1500 grit (dry) using moderate speed. The coating should "powder" when sanding. If you can not produce dust, then it is not dry enough to sand. Sanding too early risks producing "pills" which will damage the surface. Polarstar has sharp, silicon carbide abrasive which cuts faster than competitive products. You will not need to sand as long to remove surface defects.

2. FINESSE



Abralon 3000
 #8A-241-3000
MR-6 Sander r (alt. CEROS 650CV)
916GV15 Backup Pad

Refine sand scratches using 3000 grit Abralon with a 50% overlap pattern (wet). Spray the pad and surface with clean water. If too much is used, it will be evident by water "slinging" from the pad, and the abrasive will float over the surface with reduced cutting action.

3. BUFF



Polarshine T10
 #MMCT10-1L
MPADTW-7.5-1.5 Wool Pad
(7" Rotary Buffer)

Buff using T10 compound in conjunction with a twisted wool pad (MPADTW-7.5-1.5). Use a slow speed (1,500 rpm) to prevent "burning" the finish. Keep the pad clean from compound build-up. (If shop does not use twisted wool, you can substitute a lambs wool pad MPADLW-7.5)

4. POLISH



Polarshine VF5
 #MMVF5-1L
MPADBF-8 Foam Pad
(7" Rotary Buffer)

Polish using VF5 with a black foam pad (MPADBF-8). Use a slow speed (1,500 rpm) to prevent "burning" the finish. Wipe surface clean using a lint-free microfiber cloth.

5" GRIP DISCS

Gold 5" Grip Disc

	Grit	Wt.	Qty Per Pkg	Shop Price/Pkg
23-612-800	800	C	50	\$20.02

Polarstar™ 5" Film-Backed Grip Disc

FA61205094	1500	FILM	50	\$42.57
------------	------	------	----	---------

6" GRIP DISCS

Abralon® 6" Foam Grip Disc

8A-241-3000	3000	FOAM	20	\$81.38
-------------	------	------	----	---------



Description	Size	Qty Per Pkg	Shop Price/Pkg
-------------	------	-------------	----------------

POLARSHINE™ POLISHING COMPOUND

MMT10-1L	T10 Medium Compound	Medium	1 liter	1	\$37.12
MMVF5-1L	VF5 Fine Polishing Compound	Fine	1 liter	1	\$56.14

WOOL POLISHING PADS

MPADLW-7.5	Lambs Wool Pad	Med. (Polishing)	7.5" dia.	1	\$23.02
MPADTW-7.5-1.5	1-1/2" Twisted Wool Pad	Cutting	7.5" dia.	1	\$12.82

FOAM POLISHING PADS

MPADBF-8	1-1/4" Black CCS Foam Pad	Finishing	8" dia.	1	\$15.17
----------	---------------------------	-----------	---------	---	---------

FINISHING SANDERS

		Dimensions	Qty Per Pkg	Shop Price/Pkg
MR-5	Random Orbital Sander	(5mm orbit)	1	\$214.76

BACKUP AND INTERFACE PADS

915GV20	Grip Faced Multihole Backup Pad	6" (5/16-24)	1	\$37.94
9155-5	Grip Faced Foam Interface Pad	6" dia. x 5mm	5	\$44.30