



# SOP - High Gloss Wood Finishing

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



## 1. SAND



**Abranet® P800** 9A-232-800  
**Microstar® P1500** FM-612-1500

*MID55020CAUS - 5" Mirka® DEROS Electric Sander  
 (alt. MR-5V Pneumatic Sander)  
 915GV28 Backup Pad*

Level orange peel and any defects using Abranet P800. Follow with Microstar P1500 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.

Microstar was designed to remove runs, dust nibs, excess orange peel or other surface defects in painted surfaces or gelcoat prior to polishing.

## 2. FINESSE



**Abralon® 3000**  
 8A-241-3000

*MID55020CAUS - 5" Mirka® DEROS Electric Sander  
 (alt. MR-5V Pneumatic Sander)  
 915GV28 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® 10**  
 PC10-1L  
**MPADTW-7.5-1.5 Wool Pad**  
 (7" Rotary Buffer)

Buff using PC10 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® FC5**  
 FC5-1L  
**MPADBF-8 Black Foam Pad**  
 (7" Rotary Buffer)

Polish using FC5 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

	Grit	Wt.	Qty Per Pkg	List Price	Shop Price
<b>Abranet® 5" Mesh Grip Disc</b>					
9A-232-800	800	NET	50	\$50.00	\$45.00
<b>Abralon® 5" Mesh Grip Disc</b>					
8A-241-3000	3000	FOAM	20	\$98.50	\$88.65
<b>Microstar 5" Film Backed Grip Disc</b>					
FM-612-1500	1500	FILM	50	\$54.50	\$49.05
<b>Gold 5" 17-Hole Vacuum Grip Disc</b>					
23-647-800	800	C	50	\$25.50	\$22.95
<b>Basecut 5" Grip Disc</b>					
22-612-800	800	B	50	\$16.50	\$14.85

### 5" FINISHING SANDERS

	Description	Size	Qty /Pkg	List Price	Shop Price
MID55020CAUS	DEROS Random Orbital Electric Vacuum-Ready Finishing Sander	5" (5mm orbit)	1	\$415	\$415
MR-5V	Pneumatic Vacuum Ready Finishing Sander	5" (5mm orbit)	1	\$369.50	\$332.55

### 5" BACKUP PADS

915GV28	Grip Faced Multi-Hole Vacuum Backup Pad	5" (5/16-24)	1	\$52.00	\$46.80
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### POLISHES AND PADS

PC35-1L	Polishing Compound 35	Coarse	1 Liter	\$38.50	\$34.65
FC5-1L	Finishing Compound 5	Very Fine	1 Liter	\$71.50	\$64.35
MPADTW-7.5-1.5	1-1/2" Twisted Wool Pad	Cutting	1	\$16.00	\$14.40
MPADBF-8	1-1/4" Black Foam Pad	Finesse	1	\$19.00	\$17.10

### ACCESSORIES

M-9915G	Gray Microfiber cleaning cloth		2	\$15.50	\$13.95
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