



Random Orbital Finishing Process



Clean Surface:

1. Apply Autokote Final Check Inspection Detailer to the surface to be sanded and wipe dry with a clean Autokote microfiber cloth to remove any contamination before sanding.



AK.1293

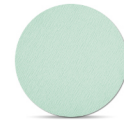


AK.1208



Sanding Spot Defects:

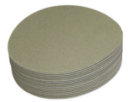
1. Sand and remove defects with a 1500-2000 grit abrasive discs on a random orbital sander.
2. Refine the 1500-2000 grit sanding scratches with 3000 grit foam abrasive disc on a random orbital sander. Keep the 3000-grit foam disc damp with water and make several overlapping passes to ensure all scratches are refined to 3000 grit.



PP.3504-1500*



PP.3504-2000*



PP.863000*



Clean Surface:

1. Apply Autokote Final Check Inspection Detailer to the sanded surface and wipe dry with a clean Autokote microfiber cloth to remove any abrasive dust or sanding residue.



AK.1293



AK.1208



Sand Scratch Removal

1. Add a small amount of Autokote C100 Hyper Cut Compound to your cutting pad on a random orbital polisher.
2. Compound the surface using medium pressure in an overlapping pattern at 3500-5000 OPM keeping the pad flat on the panel.
3. Reduce pressure towards the end of this step to refine the finish.



AK.1290



AK.1352*
(wool)



AK.1261*
(foam)



Clean Surface:

1. Apply Autokote Final Check Inspection Detailer to the compounded surface and wipe dry with a clean Autokote microfiber cloth to remove any compound residue.
2. Verify scratches have been eliminated, if not, repeat the previous compounding step.



AK.1293



AK.1208



Polishing Step:

1. Add a small amount of Autokote P200 Hyper Finishing Polish to your polishing pad on your random orbital polisher.
2. Polish the surface using medium pressure in an overlapping pattern at 2500-3500 OPM keeping the pad flat on the panel.
3. Reduce pressure towards the end of this step to refine the finish.



AK.1291



AK.1267*
(foam)



Clean Surface:

1. Apply Autokote Final Check Inspection Detailer to the polished surface and wipe dry with a clean Autokote microfiber cloth to remove any remaining polishing residue.
2. Inspect the area to ensure it is now defect and swirl free, if not, repeat the previous polishing step.



AK.1293



AK.1206



CLEANING & INSPECTION

PART NO.	DESCRIPTION	UOM
AK.1293	Final Check Inspection Detailer	Quart
AK.1294	Final Check Inspection Detailer	Gallon
AK.1208	16" x 16" Yellow Microfiber Cloth	Each
AK.1206	16" x 16" Green Microfiber Cloth	Each

SANDING DISCS

PART NO.	DESCRIPTION	UOM
PP.3312-1500	XG 3" 1500 Grip Disc	Box
PP.3312-2000	XG 3" 2000 Grip Disc	Box
PP.733000	XG 3" 3000 Grip Profinish Foam Disc	Box
PP.831500	XG 3" 1500 Grip X-Act Foam Disc	Box
PP.832000	XG 3" 2000 Grip X-Act Foam Disc	Box
PP.833000	XG 3" 3000 Grip X-Act Foam Disc	Box
PP.3504-1500	XG 6" 1500 Grip Disc	Box
PP.3504-2000	XG 6" 2000 Grip Disc	Box
PP.762000	XG 6" 2000 Grip Profinish Foam Disc	Box
PP.763000	XG 6" 3000 Grip Profinish Foam Disc	Box
PP.861500	XG 6" 1500 Grip X-Act Foam Disc	Box
PP.862000	XG 6" 2000 Grip X-Act Foam Disc	Box
PP.863000	XG 6" 3000 Grip X-Act Foam Disc	Box

COMPOUND & POLISH

PART NO.	DESCRIPTION	UOM
AK.1201	EZ-Buff Compound (Heavy Cut)	Each
AK.1290	C100 Hyper Cut Compound	Each
AK.1291	P200 Hyper Finishing Polish	Each

CUTTING PADS

PART NO.	DESCRIPTION	UOM	O	R
AK.1333	3" White Wool Pad	Each	✓	✓
AK.1231	3" Maroon Foam Pad	Each	✓	✓
AK.1261	6" Maroon Foam Pad	Each	✓	
AK.1326	6" Microfiber Pad	Each	✓	
AK.1352	6" White Wool Pad	Each	✓	✓

POLISHING PADS

PART NO.	DESCRIPTION	UOM	O	R
AK.1234	3" Yellow Foam Pad	Each	✓	✓
AK.1237	3" Black Foam Pad	Each	✓	✓
AK.1264	6" Yellow Foam Pad	Each	✓	
AK.1267	6" Black Foam Pad	Each	✓	
AK.1329	6" Microfiber Pad	Each	✓	
AK.1359	6" Yellow Wood Pad	Each	✓	✓

O = Indicates pads designed and manufactured for use on random orbital polishers
R = Indicates pads designed and manufactured for use on rotary polishers