



Z12450 ALUMINUM POLISHING KIT

STEPS TO POLISHING:

STEP 1: Determine if the material you wish to polish needs to be sanded first. A good rule of thumb is if a fingernail can catch the edge of a scratch, it will need to be sanded before it can be polished. Work up in grit from the coarsest applicable paper to the finest. Wet sand in a consistent motion without cross hatching. Follow the grain of the material, if visible, until there are no scratches visible and a satin finish is achieved. (1000 grit wet is usually a good place to end up before polishing.)

STEP 2: Start polishing by using any felt bobs, felt cones, or buffs except for the loose single stitched buff. (The single stitched buff is the buffing wheel with 1 row of stitching around its center.) The purpose of the different shaped buffs and bobs is to get into different areas of the object being polished. Insert the first buff into any standard electric drill or bench grinder and choose the coarsest applicable compound by consulting the compound chart below.

STEP 3: Coat the buff or felt bob by lightly spinning it onto the chosen compound. Use the compounds sparingly. Only a small amount is needed for them to work properly. Next, spin the coated buff or felt bob onto the surface to be polished. Best results are obtained at 3,000 RPM or less. Working at a higher rate heats the work surface and prevents the compound from working properly. Slight pressure works best. Let the coated buff do the work. A residue will come off the material while polishing (metal should produce black soot). Continue polishing as needed, reapplying more compound if necessary. Before changing from one compound to another, remove the previous compound by spinning the buff against a metal edge to remove the residue. For best results, use a different buff for each compound. Also, remove compound from the piece being polished before applying next compound.

STEP 4: Repeat the process with the next finer compound as shown in the chart below. Continue polishing until the surface appears shiny with no visible scratches.

STEP 5: To finish the project and achieve a mirror-like finish, use the finest application compound with the loose single stitched buff. Again, use very light pressure and let the buff do the work. (It's not always necessary to go all the way to the finest applicable compound.)

STEP 6: Once work is completed, depending on the material, wash the material with warm, soapy water to remove any excess buffing compound or residue. Then, dry with a soft cloth or chamois. Depending on the material, protect the restored finish with a clear coat.

COMPOUND CHART	Coarse ● —————> Fine		
Material	Black Emery	Brown Tripoli	White Diamond
Aluminum	●	●	●