Polishing Process Chart

1. **Bodyline Polishing Products**
The full Bodyline polishing range

2. **Precleaning**
Clean the panel before denibing.
Top Tip—this helps to see the inclusions clearly and prevents contamination causing rogue scratches.

3a. **Small Area Inclusion Removal**
For small isolated dirt inclusions, use the denib block with the denib abrasive disc.
Top Tip—use the Bodyshine to lubricate the abrasive.

3b. **Large Area Inclusion Removal**
For larger areas with more inclusions, use the P1500 Film Disc on a 3/5mm DA Sander.
Top Tip—use an interface DA pad to soften the abrasion.

4. **Sanding Area**
Check all the dirt inclusions have been removed and wipe the dust away.

5. **Bodyshine Application**
Use the 2000 grit Blend and Finish to remove the P1500 scratches.
Top Tip—use the Bodyshine to lubricate and help the cut of the 3000 grit Blend and Finish pad

6. **Sanding with 2000 B+F and Bodyshine**
Remove the scratches using a DA sander keeping the surface damp.
Top Tip—disconnect dust extraction while using bodyshine.

7. **2000 Grade Sanding vs P1500 Sanding**
The difference between the P1500 film and 3000 grit Blend and Finish is clearly evident, the gloss should now be returning within the bare substrate area.

8. **Foam Head Cleaning**
Start with the orange compounding head. Cleaning the head is vital to remove dried polish and prevent hologram scratches.
Top Tip—this is best done dry, by holding a coarse abrasive against the head, while being spun gently.

9. **Application of Polish**
Apply a small amount of polish to the panel.
Top Tip—too much polish will prevent the compounding head from cutting.

10. **1st Step Compounding**
Start the machine with the head placed on the panel, set at about 1400 RPM and keep moving, breaking down the compound.
Top Tip—wipe the polish lightly into the head, prior to starting the machine to prevent excess compound ‘fling’

11. **2nd Stage Finishing Polishing**
Leave the polish on the panel and swap to the black polishing head, clean the head as before, polish with what compound is left on the panel to give final gloss finish.

12. **Cleaning and Checking**
Clean with the Bodyshine spray and microfibre cloth to remove any polish and check the final finish.

13. **Creating Fine Compound**
Keep polishing until you are happy the scratches are removed and that the polish has been broken down to a very fine compound.
Top Tip—polish in sections e.g. wings in halves, bonnets in quarters

Health & Safety in the bodyshop:
• Ensure that the working area is clean and tidy
• Wear protective ear and eye equipment
• Wear suitable respiratory equipment when working with hazardous materials
• Wear protective gloves
• Lubricate sander as per manufacturer’s instructions
• Non lubrication can cause damage to the machine

Products:
- Microfibre Cloth
- Denibbing Block
- Orange Compounding Foam
- Easycut Liquid Compound
- Black Polishing Foam
- Finishing Glaze
- Gripped Film Abrasive Disc P1500
- 2000 Grit Blend and Finish Disc
- Bodyshine Cleaning Liquid

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