

SOP - Glass Refinishing of Tempered or Standard Glass (5" System)

Step 1



Clean and Prepare the Glass

- Clean the surface using a silicone free window cleaner.
- Evaluate the area of the repair and determine the maximum diameter of repair area for each grit in the sequence.

***Note:** Some repairs will be limited in available surface area to complete the process, for these repairs a 3" Abralon disc selection may be ideal.

Step 2



Abralon 180

8A-232-180

Damage Removal

- Use a rotary electric polisher and a dry Abralon 180 disc
- Use machine at approximately 800 RPM
- Use Abralon 180 grit disc to remove the damage to the glass
- Heat is generated during this process. Excessive heat can cause the glass to shatter. Allow glass to cool if glass surface temperature becomes too hot.
- All damage to glass should be removed during this step before proceeding to Step 3.
- To minimize surface distortion, maintain the face of the sanding tool completely flat.

Step 3



Abralon® 360,500,1000

8A-232-360/500/1000

Refinement & Distortion Mitigation

- Use machine at approximately 1000 RPM
- Follow sequential grit order (from coarse to fine), starting with Abralon® 360. Do not skip Grits.
- Sanding process is Abralon® 360, 500, 1000
- Each sequential grit should increase the repair area diameter by 1/2" -1" (overlap the previous grit scratches by 1/2"-1")
- Sand approximately for 1-1/2 minutes for each grit. (Do not sand for a shorter time, or scratches will not be removed during polishing)
- Wipe clean with a microfiber cloth between each sanding step.
- Finish sanding with Abralon® 1000, ensuring previous sanding marks are removed. Clean the surface with silicone free window cleaner.

Step 4



Polarshine® E3

PE3-1L

Polishing Felt Pad

MPADFP-5

Note: If using a new felt polishing pad, apply a 1/4" bead of polish around the face of the pad (1-1/2" in from the edge) and a 1" diameter spot in the center. If felt polishing pad had been used in a previous repair, apply a 3/4" diameter amount of polish to the face of the pad (nickel size)

- Start at approximately 2150 RPM for 2 minutes, and then finish with a speed of 2650 RPM.
- Apply a firm pressure to the polisher while polishing.
- Wipe away polishing compound residue with a microfiber cloth to inspect repair area for scratch removal.
- Focus on the perimeter of the repair area, these scratches will be the last to be removed.
- If scratches are still visible, apply more compound, and continue polishing until scratches are removed.

** For smaller repair areas, a 3" system can be used.*