



PFK-1 Sanding Pad Equivalents

Yellow Pad	Light Green	Orange	Purple	Light Blue	Gray
600 Grit	800 Grit	1500 Grit	2400 grit	4000 Grit	12,000 Grit

Corian, Solid Surface and Acrylic Pen Finishing Guideline Steps

Sand as you normally would to 220 or 320 grit. For Deep Scratch Removal start wet sanding with the Yellow sanding pad. If you do not have deep scratches, start with a few drops of water on the green pad with a light touch and sand the pen blank. Follow with the orange pad and a few drops of water and repeat the process with all the pads. For A High Gloss Finish use all of the pads and then use the Acrylic Polish ASR-1 and the Acrylic Pen Buffing System APBS-1.

Acrylic Material Pen Finishing Guideline Steps

Sand as you normally would to 220 or 320 grit. Then wet sand using a few drops of water on the Green pad lightly touching the material. Wipe off the slurry and then proceed to the Orange pad and then all the other subsequent pads using the same technique as the green pad. When finished use the Acrylic Scratch Remover ASR-1 for a lasting shine.

Stabilized Wood Finishing Guideline Steps (use the pads dry)

Sand your material as you normally would to 220 grit. Using the sanding pad DRY and a medium lathe speed of about 1500 RPM, start sanding with a LIGHT touch using the light green or orange sanding pad depending on the condition of the pen. Follow with the rest of the sanding pads to the desired shine and then use the finish of your choice!

Helpful Hints:

- After each grit sanding pad, make certain to wipe away any sanding debris with a soft cloth prior to continuing on with the next step to avoid contamination scratches.
- Light pressure should be used to control the sanding pad. Do not push hard with the pad – it will put scratches into your work. A light touch is needed.
- Remove the sanding pad from the pen surface prior to turning the lathe off.
- The beginning condition of the pen material will determine your starting point. For deeper scratches in solid surface and Acrylics use a few drops of water on each pad and start with the Yellow pad, then follow with the next color sanding pad and a few drops of water until all of the damage is removed. After each grit, wipe the slurry (caused by wet sanding) off and continue on to the next higher grit using a few drops of water with each pad.
- To increase the life of your pads, flick them with your finger to get the dust off the pads. You can even soak them in water to remove any debris. Allow them to dry thoroughly before using them on wood!

Trouble Shooting:

- **Swirl Marks or Scratches In The Finish:** Do not skip steps. Spend approximately the same amount of time using each sanding pad. Be sure too completely remove the sanding residue after each sanding pad before moving onto the next step. If you do not remove the residue, it may cause some of your scratches! Lathe speed should be approximately 1500 - 1800 rpm. Do not use on extreme high speeds. Use a few drops of water and Light pressure on each pad for all material other than wood! Do not use water on wooden pen blanks!

*Please Note: Not everyone's idea of a particular finish is the same. Depending on the color, fewer or more steps may be required in order to achieve the look you desire. It is a good idea to check the finish between each sanding pad until you are satisfied with your finish. For Technical advice see - www.bgartforms.com