
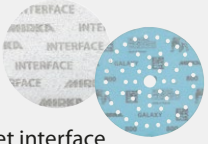
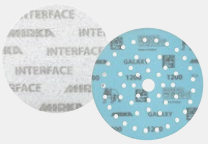
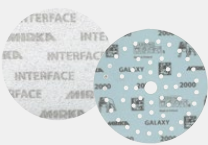



Marine Mould gelcoat process



Mirka Deros 650CV
150mm, 5mm orbit

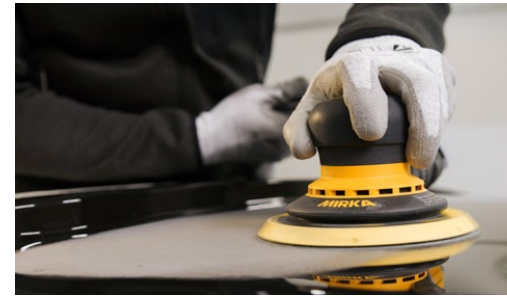
Defect removal	STEP 1	 Galaxy 150mm, Grit 600
	STEP 2	 Net interface + Galaxy 150mm, Grit 800
Scratch conditioning	STEP 3	 Net interface + Galaxy 150mm, Grit 1200
	STEP 4	 Net interface + Galaxy 150mm, Grit 2000
Pre-polish sanding	STEP 5	 Abralon 150mm, Grit 3000
	Wet sanding	

SANDING



STEP 1

- For orange peel surfaces, start sanding with Mirka Galaxy 600 grit together with Mirka DEROS.



STEP 2

- The starting point of this surface is good, we therefore start from Galaxy grit 800 using a Net Interface.

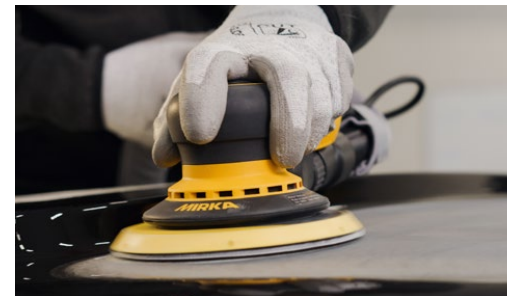


- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.



STEP 3

- Continue sanding until scratches are reduced
- Use Galaxy 1200 or 1500 grit together with a Net Interface.



STEP 4

- Use Galaxy 2000 grit together with a Net Interface.



STEP 5

- When wet sanding, turn off the dust extractor.
- Use Mirka Abralon 3000.

NOTE! By extending the sanding process and using finer grits, the polishing time will shorten and lower the total production time and cost.