


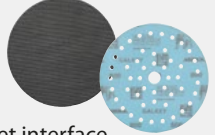
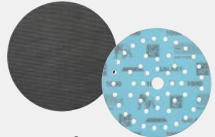
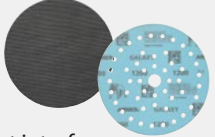


# Marine Production gel coat process

Defect removal	STEP 1		Galaxy 150mm, Grit 240
	STEP 2		Galaxy 150mm, Grit 320
Scratch conditioning	STEP 3		Galaxy 150mm, Grit 500
	STEP 4		Net interface + Galaxy 150mm, Grit 800
Pre-polish sanding (for light colours)	STEP 5		Net interface + Galaxy 150mm, Grit 1000
	STEP 5		Net interface + Galaxy 150mm, Grit 1200

## SANDING



### STEP 1

- Start by attaching the Mirka® Galaxy, 240 grit, to the Mirka® DEROS 650CV.
- Sand the area



### STEP 4

- Continue by attaching the net interface to the DEROS 650CV.
- Sand with Galaxy, 800 grit

Mirka Deros 650CV  
150mm, 5mm orbit



### STEP 2

- Change to Mirka® Galaxy, 320 grit and continue sanding.



### STEP 3

- Attach and sand with Mirka® Galaxy, 500 grit.



### STEP 5

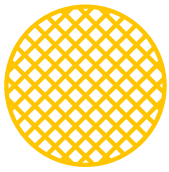
- Finish the sanding with Mirka® Galaxy 1000 grit together with Net interface. (use 1200 grit on dark colours)



### STEP 6

- Clean the sanded area with a Micro fiber cleaning cloth. The sanded area is ready to be polished.

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



# Marine Production gel coat process

Mirka ARP-B 300NV  
77mm, Rotary



Scratch removal	STEP 1	 Polarshine® 45 Polishing compound and Lamswool Pad Pro
	STEP 2	 Polarshine® 12 Black with a Black waffle foam pad
Final polishing (for dark colours)	STEP 2	 Polarshine® 12 and a Waffled polishing foam pad
	STEP 3	 Micro fiber cleaning cloth
Final polishing (for light colours)	STEP 2	 Polarshine® 12 and a Waffled polishing foam pad
Cleaning	STEP 3	 Micro fiber cleaning cloth

## POLISHING



### STEP 1

- Start by attaching the Lamswool Polishing Pad Pro to the ARP-B Polisher.
- Apply Polarshine® 45 polishing compound to the pad. Start polishing.



### STEP 2 (recommended for dark colours)

- Change to a Black waffle foam pad, apply *Polarshine® 12 Black* polishing compound and polish the surface.

### STEP 2 (recommended for light colours)

- Attach a Waffled polishing foam pad and apply *Polarshine 12* to the pad.
- Polish the surface



### STEP 3

- Clean the polished area with a Microfibre cleaning cloth.