



Marine Top & clear coat sanding process



Mirka Deros 650CV
150mm, 5mm orbit



Mirka ARP-B 300NV
77mm, Rotary

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|--------------------------------------|--------|--|
| Defect removal | STEP 1 | Net interface + Galaxy 150mm, Grit 1200-1500 |
| | STEP 2 | Net interface + Galaxy 150mm, Grit 2000 |
| Scratch conditioning | STEP 3 | Abralon 150mm, Grit 3000 |
| | STEP 1 | Polarshine® 35 + Lambswool pad Pro |
| Pre-polish sanding | STEP 2 | Polarshine® 12 Black + Black waffle foam pad. Micro fiber cleaning cloth |
| | STEP 1 | Polarshine® 35 + Lambswool pad Pro |
| Eliminate scratches | STEP 1 | Polarshine® 35 + Lambswool pad Pro |
| | STEP 2 | Polarshine® 12 Black + Black waffle foam pad. Micro fiber cleaning cloth |
| Remove polish marks on dark surfaces | STEP 1 | Polarshine® 35 + Lambswool pad Pro |
| | STEP 2 | Polarshine® 12 Black + Black waffle foam pad. Micro fiber cleaning cloth |

SANDING



STEP 1

- Start sanding with Mirka® DEROS 650CV using a Net Interface and Galaxy 1200 or 1500 grit.



STEP 2

- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.
- Continue sanding with Galaxy 2000 grit



STEP 3

- Continue wet sanding with Abralon® 3000.

POLISHING



STEP 1

- Polish the surface with Polarshine® 35 and a Lambswool Pad PRO together with Mirka® ARP-B Polisher to eliminate sanding scratches.



STEP 2

- For dark coloured surfaces, continue with Polarshine® 12 Black with a Black Waffle foam pad to remove any polishing marks, haze and holograms.



- Wipe off any excess polishing compound.

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