

MIRKA

Marine

Top- and Clearcoat Sanding Process



Mirka® DEROS II 650
150 mm, orbit 5 mm



Mirka® POLAROS RP 600
Polisher, 150 mm

Defect removal	STEP 1	Net interface + Galaxy 150mm, Grit 1200-1500
	STEP 2	Iridium Soft 150mm, Grit 2000
Scratch conditioning & Pre-polish sanding	STEP 1	Polarshine® Marine Medium Cut Compound. Lambswool Pad Pro Yellow.
	STEP 2 (Light)	Polarshine® Marine Fine Compound + Polishing Foam Pad Yellow Waffle. Cleaning Cloth Micro Fiber Yellow.
	STEP 2 (Dark)	Polarshine® 12 Black + Polishing Foam Pad Black Waffle M
		Remove polish marks on light surfaces
		Remove polish marks on dark surfaces

SANDING



STEP 1

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



STEP 2

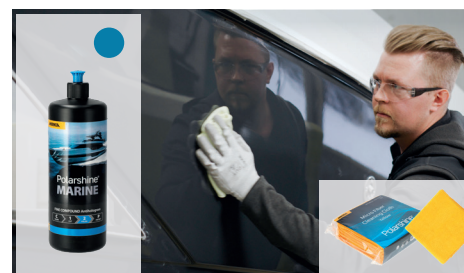
- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.
- Continue with Iridium Soft 2000 grit.

POLISHING



STEP 1

- Polish the surface with Polarshine® Marine Medium Cut Compound and a Lambswool Pad PRO together with Mirka® POLAROS RP 600 to eliminate sanding scratches. 1300-1500 rpm.



STEP 2 (Light colours)

- For light coloured surfaces, change to **Polarshine® Marine Fine Compound, Anti-hologram** with a Polishing Foam Pad Yellow Waffle. Wipe off excess polishing compound.



STEP 2 (Dark colours)

- For dark coloured surfaces, continue with Polarshine® 12 Black and Polishing Foam Pad Black Waffle M to remove polishing marks, haze and holograms. Wipe off excess compound.

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