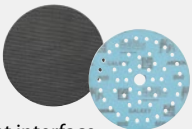
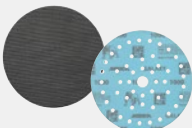
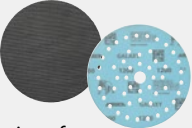


Marine

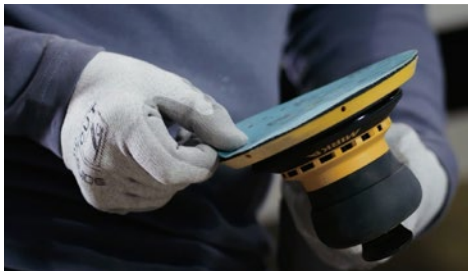
Production Gel Coat Process



Mirka® DEROS II 650
150 mm, orbit 5 mm

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

SANDING



STEP 1

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



STEP 4

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

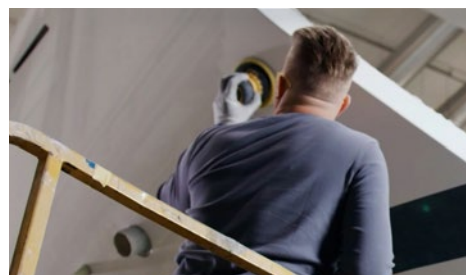
NOTE!

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



STEP 2

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



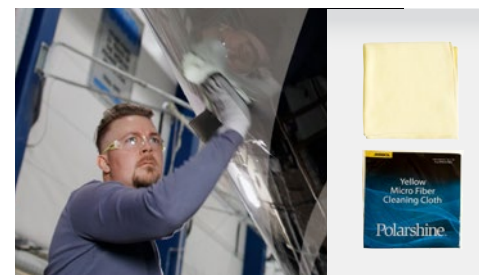
STEP 5

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



STEP 3

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



STEP 6

- Clean the sanded area with a Cleaning Cloth Micro Fiber. The sanded area is ready to be polished.

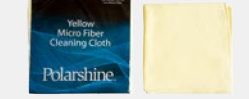
Dedicated to the finish.

Marine

Production Gel Coat Process



Mirka® POLAROS RP 600
Polisher, 150 mm

Scratch removal	STEP 1	 Polarshine® Marine Heavy Cut Compound and Twisted Wool Pad
	STEP 2	 Polarshine® Marine Fine Compound (Antihologram) + Polishing Foam Pad Yellow Waffle
Final polishing (for light colours)	STEP 2	 Polarshine® 12 Black + Polishing Foam Pad Black Waffle M
	STEP 3	 Cleaning Cloth Micro Fiber
Cleaning	STEP 3	

POLISHING



STEP 1

- Attach the Twisted Wool Pad to Mirka® POLAROS RP 600 (1300-1500 rpm) and apply **Polarshine® Marine Heavy Cut Compound**.
- Start polishing



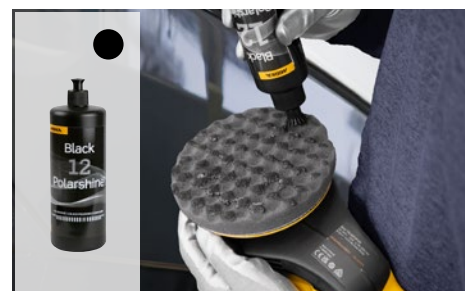
STEP 2 (recommended for light colours)

- Attach a Polishing Foam Pad Yellow Waffle and apply **Polarshine® Marine Fine Compound, Antihologram** to the pad and start polishing the surface.



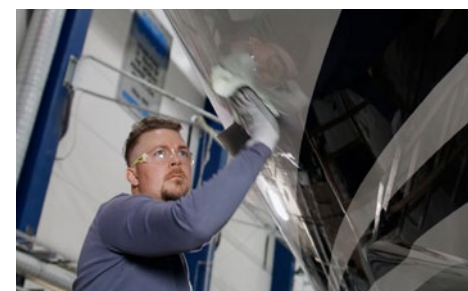
NOTE ON USING TWISTED WOOL PADS WITH POLAROS RP 600

When using the 125 mm Twisted Wool Pad with the POLAROS RP 600, a 5 mm interface pad (Mirka code: 8295535211) must be used to increase the pad height. This is a temporary solution until a dedicated long-term interface is developed. We are working on a more permanent solution for the future.



STEP 2 (recommended for dark colours)

- Change to a Polishing Foam Pad Black Waffle M. Apply **Polarshine® 12 Black Polish- ing Compound** and polish the surface.



STEP 3

- Clean the polished area with a Cleaning Cloth Micro Fiber.

Dedicated to the finish.