

Marine

Production gel coat process



Mirka® DEROS 650CV
150 mm, orbit 5 mm

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
	STEP 5	Net interface + Galaxy 150mm, Grit 1000
Pre-polish sanding (for light colours)	STEP 5	Net interface + Galaxy 150mm, Grit 1000
	STEP 5	Net interface + Galaxy 150mm, Grit 1200
Pre-polish sanding (for dark colours)	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

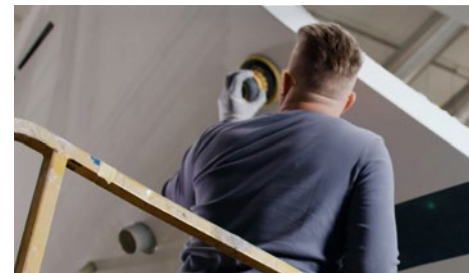
NOTE!

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.



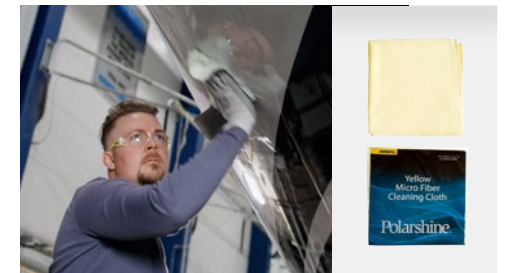
STEP 5

- 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 Micro fiber cleaning cloth. The sanded area is ready to be polished.

Dedicated to the finish.

Marine

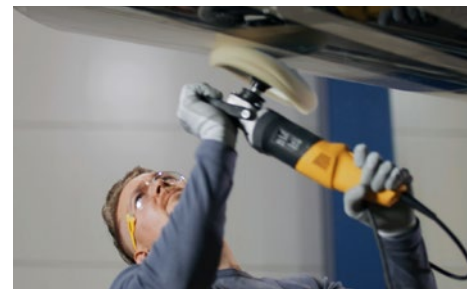
Production gel coat process



Mirka® PS1437
Polisher, 150 mm

Scratch removal	STEP 1		Polarshine® 45 Polishing compound and Twisted wool pad
	STEP 2		Polarshine® 12 Black with a Black waffle M foam pad
Final polishing (for dark colours)	STEP 2		Polarshine® 12 and a Waffled polishing foam pad
	STEP 3		Micro fiber cleaning cloth

POLISHING



STEP 1

- Start by attaching the Twisted wool pad to the Mirka® PS 1437 polisher tool.
- Apply Polarshine® 45 polishing compound to the Twisted wool pad. Start polishing.

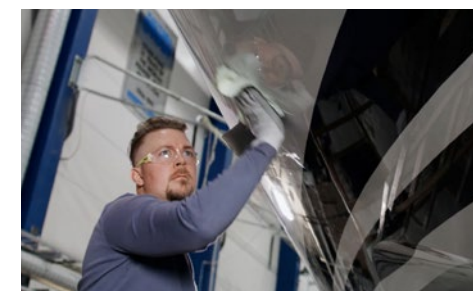


STEP 2 (recommended for dark colours)

- Change to a Black waffle M 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 Micro fiber cleaning cloth.

Dedicated to the finish.