

Marine

Mould gelcoat process



Mirka® DEROS 650CV
150 mm, orbit 5 mm

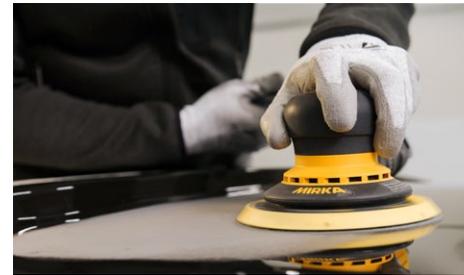
Defect removal	STEP 1	 Galaxy 150mm, Grit 600
	STEP 2	 Net interface + Galaxy 150mm, Grit 800
Scratch conditioning	STEP 3	 Net interface + Galaxy 150mm, Grit 1200
	STEP 4	 Net interface + Galaxy 150mm, Grit 2000
	STEP 5	 Abralon J3 150mm, Grit 3000
Pre-polish sanding		
Wet sanding		

SANDING



STEP 1

- For orange peel surfaces, start sanding with Mirka® Galaxy 600 grit together with Mirka® DEROS.



STEP 2

- The starting point of this surface is good, we therefore start from Galaxy grit 800 using a Net Interface.



- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.



STEP 3

- Continue sanding until scratches are reduced
- Use Galaxy 1200 or 1500 grit together with a Net Interface.



STEP 4

- Use Galaxy 2000 grit together with a Net Interface.



STEP 5

- When wet sanding, turn off the dust extractor.
- Use Mirka Abralon® 3000.

NOTE!

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

Dedicated to the finish.

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Mirka® PS1437
Polisher, 150 mm

Scratch removal	STEP 1	
	STEP 2	
Final polishing (for dark colours)	STEP 2	
Final polishing (for light colours)	STEP 2	
Cleaning	STEP 3	

POLISHING



STEP 1

- Use Polarshine® 45 and a Lambswool pad Pro together with Mirka® PS 1437 Polisher.



- Polish the surface to eliminate sanding scratches.



- Wipe off any excess polishing compound between the polishing steps.



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 and polish the surface.



STEP 3

- Finally, wipe off excess polishing compound.

Dedicated to the finish.