

# ART Process

## Standard repair process



Mirka® DEROS II 650  
150 mm, orbit 5 mm

Galaxy 150mm, Grit 80

Galaxy 150mm, Grit 180

Galaxy 150mm, Grit 240

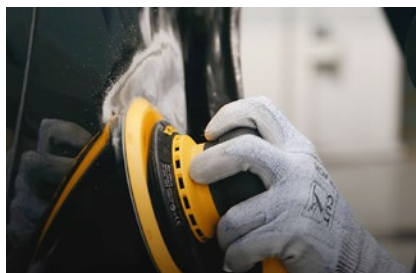
Galaxy 150mm, Grit 400

Galaxy 150mm, Grit 600

Galaxy 150mm, Grit 1000

Net interface

Dry Guide Coat



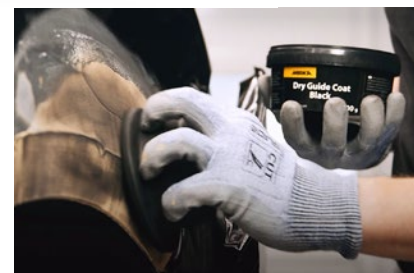
### PAINT STRIPPING

- Use grit 80
- Speed 8000-9000 rpm
- Sand with a small tilt and strip layer by layer



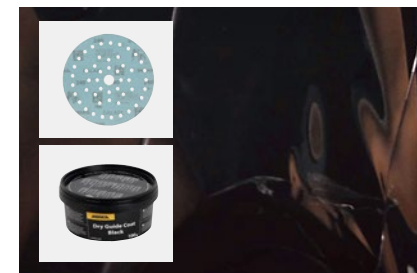
### FEATHER EDGE

- Use grit 180
- Speed 8000 rpm
- Sand flat and make a smooth transition form old paint to metal



### BODY FILLER SANDING

- Start with grit 80 and continue with grit 180. Speed 8000 rpm
- Apply Dry Guide Coat between the steps



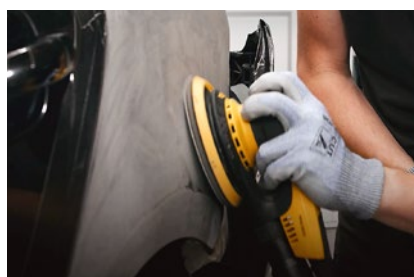
### SCRATCH CONDITIONING

- Use grit 240
- Speed 8000 rpm
- Apply Dry Guide Coat before sanding



### PRIMER PREPARATION

- Use grit 400
- Speed 8000 rpm
- No interface



### PAINT PREP. / PRIMER SANDING

- Start with grit 400 and finish with grit 600.
- Speed 7000 rpm
- Use 5mm interface



### CLEAR COAT SANDING

- Use grit 600
- Speed 7000 rpm
- Use 5mm interface



### BLENDED

- Use grit 1000
- Speed 7000 rpm
- Use Net interface

Dedicated to the finish.

# ART Process

## Post Paint



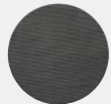
Galaxy 150mm, Grit 1500



Abralon J3 Grit 3000



Golden Finish SR 32 mm



Net interface



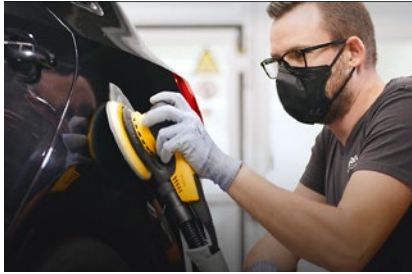
Golden Finish pad 1



Golden Finish pad 2



Polarshine® 5 and 20



### CLEAR COAT SANDING, STEP 1

- Use grit 1500 and Net Interface
- Speed 7000 rpm
- Sand the surface structure to required level



### CLEAR COAT SANDING, STEP 2

- Use Abralon J3 3000 to reduce the scratches from Galaxy 1500
- Speed 7000 rpm



### DENIBBING / DUST REMOVAL

- Use Golden Finish SR
- Sand with AOS-B or AROS-B

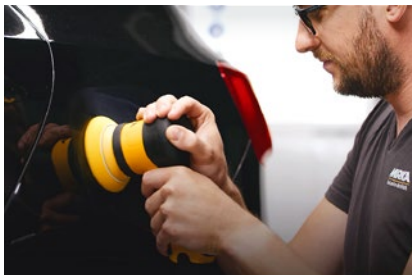


Mirka® AOS-B 130NV

32 mm, Cordless,  
8000 rpm  
Orbit 3 mm

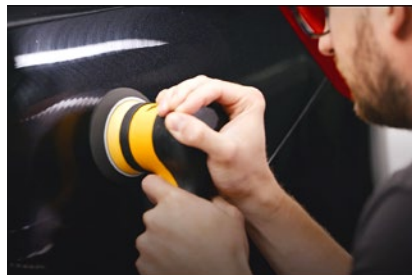
Mirka® AROS-B 150NV

32 mm, Cordless,  
8000 rpm.  
Orbit 5 mm



### POLISHING, STEP 1

- Use Golden finish pad 1 and Polarshine 20
- Set the speed on polisher to 1100 rpm



### POLISHING, STEP 2

- Use Golden finish pad 2 and Polarshine 5
- Keep the same speed, 1100 rpm



Mirka® ARP-B 300NV

77 mm, Cordless,  
Orbit 0 mm

Mirka® AROP-B 312NV

77 mm, Cordless,  
Orbit 12 mm



Mirka® DEROS II 650

150 mm, orbit 5 mm

Dedicated to the finish.