

Mirka Iridium™

Automotive Refinishing Process



Mirka® DEROS II 650
150 mm, orbit 5 mm



PAINT REMOVAL

- Use Iridium grit 120 together with DEROS II 650.
- Speed 8,000–9,000 rpm



FEATHER EDGE

- Use Iridium grit 220 and speed 8,000 rpm
- Sand flat and make a smooth transition from old paint to metal

BODY FILLER APPLICATION



BODY FILLER SANDING

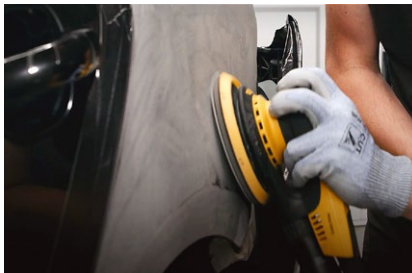
- Start with Iridium grit 120 and continue with grit 220 together with DEOS II 383. Speed 7,000 rpm.
- Apply Dry Guide Coat between the steps



PRIMER PREPARATION

- Use Iridium grit 320
- Speed 7,000 rpm

PRIMER APPLICATION



PRIMER SANDING

- Use Iridium grit 320 with 5 mm interface and speed 7,000 rpm.
- Block sand the damaged area with 400 grit if needed.
- Sand the primer with disc if needed.



PRIMER/CLEARCOAT SANDING AND BLENDING

- Use **Iridium Soft** grit 500 by hand to sand edges. Continue using the same disc with machine. Speed 7,000 rpm.

If you intend to follow the sanding step with **OPTIONAL BLENDING**, use **standard Iridium 500**, instead of Iridium Soft 500.

OPTIONAL



BLENDING (OPTIONAL)

- **Iridium Soft** grit 600/800
- Speed 7,000 rpm



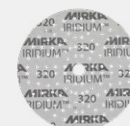
Iridium 150 mm,
Grit 120



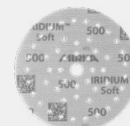
Iridium 150 mm,
Grit 220



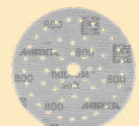
Iridium 70 x 400 mm,
Grit 120, 220 and 400



Iridium 150 mm,
Grit 320



Iridium Soft 150 mm,
Grit 500



Iridium Soft 150 mm,
Grit 600/800