

Marine

Top- and clear coat sanding process



Mirka® DEROS 650CV
150 mm, orbit 5 mm



Mirka® PS1437
Polisher, 150 mm

Defect removal	STEP 1	 Net interface + Galaxy 150mm, Grit 1200-1500
	STEP 2	 Net interface + Galaxy 150mm, Grit 2000
	STEP 3	 Abralon J3 150mm, Grit 3000
Scratch conditioning	STEP 1	 Polarshine® 35 + Lamswool pad Pro
	STEP 2	 Polarshine® 12 Black + Black waffle M foam pad. Micro fiber cleaning cloth
Pre-polish sanding		
Eliminate scratches		
Remove polish marks on dark surfaces		

SANDING



STEP 1

- Start sanding with Mirka® DEROS 650CV using a Net Interface and Galaxy 1200 or 1500 grit.



STEP 2

- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.
- Continue sanding with Galaxy 2000 grit



STEP 3

- Continue wet sanding with Abralon® J3 3000.

POLISHING



STEP 1

- Polish the surface with Polarshine® 35 and a Lamswool Pad PRO together with Mirka® PS 1437 Polisher to eliminate sanding scratches.



STEP 2

- For dark coloured surfaces, continue with Polarshine® 12 Black with a Black Waffle M foam pad to remove any polishing marks, haze and holograms.



- Wipe off any excess polishing compound.

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