

# Marine

## Production gel coat process



Mirka® DEROS 650CV  
150 mm, orbit 5 mm

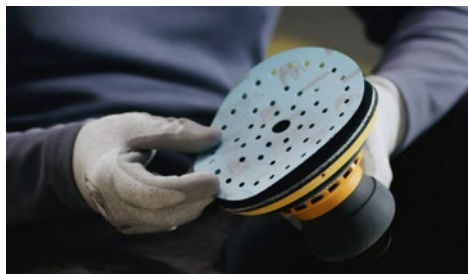
Defect removal	STEP 1	Galaxy 150mm, Grit 240
	STEP 2	Galaxy 150mm, Grit 320
Scratch conditioning	STEP 3	Galaxy 150mm, Grit 500
	STEP 4	Net interface + Galaxy 150mm, Grit 800
	STEP 5	Net interface + Galaxy 150mm, Grit 1000
Pre-polish sanding (for light colours)	STEP 5	Net interface + Galaxy 150mm, Grit 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

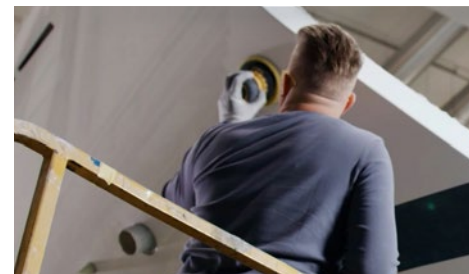
#### NOTE!

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.



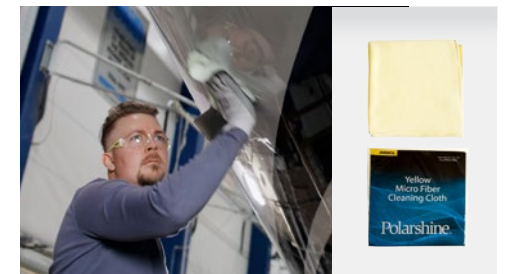
#### STEP 5

- 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.

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Mirka® PS1437  
Polisher, 150 mm

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

### 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.