

# Marine

## Top- and clear coat sanding process



Mirka® DEROS II 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® Marine Medium Cut Compound + Lambswool pad Pro
	STEP 2 (Light)		Polarshine® Marine Fine Compound, Anti- hologram + Waffled polishing foam pad
Pre-polish sanding	STEP 1		Polarshine® Marine Medium Cut Compound + Lambswool pad Pro
	STEP 2 (Dark)		Polarshine® 12 Black + Black waffle M foam pad
Eliminate scratches	STEP 1		Polarshine® Marine Medium Cut Compound + Lambswool pad Pro
	STEP 2 (Light)		Polarshine® Marine Fine Compound, Anti- hologram + Waffled polishing foam pad
Remove polish marks on light surfaces	STEP 1		Polarshine® Marine Medium Cut Compound + Lambswool pad Pro
	STEP 2 (Light)		Polarshine® Marine Fine Compound, Anti- hologram + Waffled polishing foam pad
Remove polish marks on dark surfaces	STEP 1		Polarshine® Marine Medium Cut Compound + Lambswool pad Pro
	STEP 2 (Dark)		Polarshine® 12 Black + Black waffle M foam pad

### SANDING



#### STEP 1

- Start sanding with Mirka® DEROS II 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

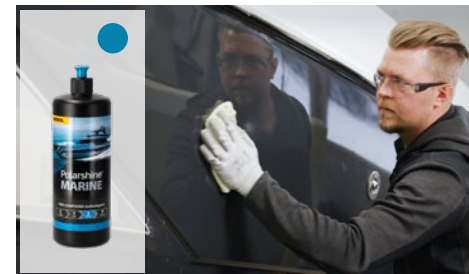
- Continue wet sanding with Abralon® J3 3000.

### POLISHING



#### STEP 1

- Polish the surface with *Polarshine® Marine Medium Cut Compound* and a Lambswool pad PRO together with Mirka® PS1437 Polisher to eliminate sanding scratches.



#### STEP 2 (Light colours)

- For light coloured surfaces, change to *Polarshine® Marine Fine Compound, Anti-hologram* with a Yellow Waffle polishing foam pad. Wipe off excess polishing compound.



#### STEP 2 (Dark colours)

- 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 excess compound.

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