

# ART Process

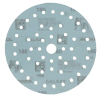
## Standard Repair Process



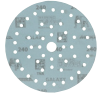
Mirka® Deros 650XCV  
MID65020CAUS  
6", orbit 5 mm



6" Galaxy, 80 Grit



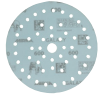
6" Galaxy, 180 Grit



6" Galaxy, 240 Grit



6" Galaxy, 400 Grit



6" Galaxy, 600 Grit



6" Galaxy, 1000 Grit



Net interface



Dry Guide Coat



### Paint stripping

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



### Feather edge

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



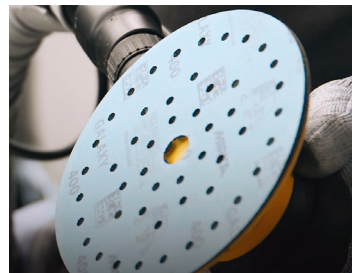
### Body filler sanding

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



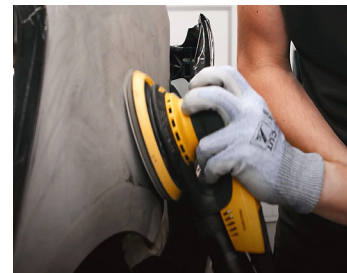
### Scratch conditioning

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



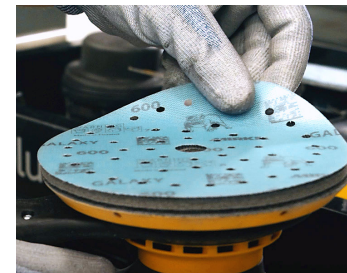
### Primer preparation

- Use Galaxy 400 grit
- Speed 8000 rpm
- No interface



### Paint prep. / Primer sanding

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



### Clear coat sanding

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



### Blending

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

# ART Process

## Post Paint



6" Galaxy, 1500 Grit



Abralon® J3, 3000 Grit



Iridium SR 1.25"



Net interface



Yellow Waffle Foam polishing pad



Black Foam polishing pad



Polarshine® 5 and 20



### Clear coat sanding, Step 1

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



### Clear coat sanding, Step 2

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



### Denibbing / Dust removal

- Use Iridium™ SR
- Sand with AOS-B or AROS-B



**Mirka® AOS-B 130  
AOS130-B**  
1.25", Cordless,  
8000 rpm  
Orbit 3 mm



**Mirka® AROS-B 150  
AROS150-B**  
1.25", Cordless,  
8000 rpm.  
Orbit 5 mm



**Mirka® Deros 650XCV  
MID65020CAUS**  
6", orbit 5 mm



### Polishing, Step 1

- Use MPADYF-3.25W and Polarshine 20
- Set the speed on polisher to 1100 rpm



### Polishing, Step 2

- Use MPADBF-3.25 and Polarshine 5
- Keep the same speed, 1100 rpm



**Mirka® ARP-B 300  
ARP300-B**  
3", Cordless,  
Orbit 0 mm

**Mirka® AROP-B 312  
AROP312-B**  
3", Cordless,  
Orbit 12 mm