

# ART Process

## Standard Repair Process



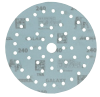
Mirka® DEROS 650CV  
MID65020CAUS  
6", orbit 5 mm



Galaxy 6", Grit 80



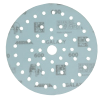
Galaxy 6", Grit 180



Galaxy 6", Grit 240



Galaxy 6", Grit 400



Galaxy 6", Grit 600



Galaxy 6", Grit 1000



Net interface



Dry Guide Coat



### Paint stripping

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



### Feather edge

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



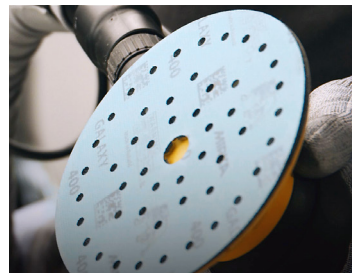
### Body filler sanding

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



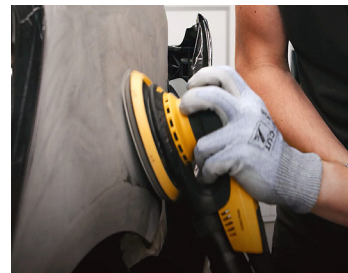
### Scratch conditioning

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



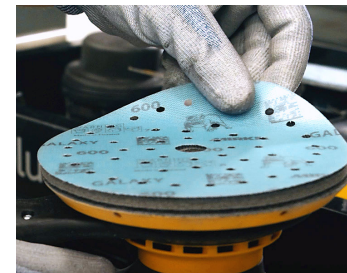
### Primer preparation

- Use grit 400
- Speed 8000 rpm
- No interface



### Paint prep. / Primer sanding

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



### Clear coat sanding

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

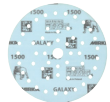


### Blending

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

# ART Process

## Post Paint



Galaxy 6", Grit 1500



Abralon J3 Grit 3000



Iridium SR 1.25"



Net interface



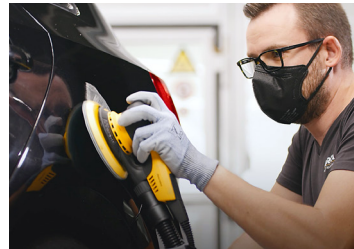
Yellow Waffle Foam polishing pad



Black Waffle Foam polishing pad



Polarshine® 5 and 20



### Clear coat sanding, Step 1

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



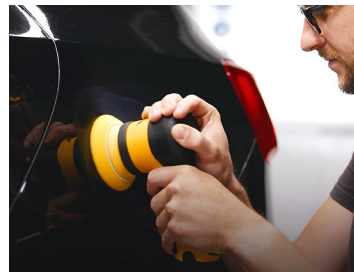
### Clear coat sanding, Step 2

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



### Denibbing / Dust removal

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



### 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® AOS-B 130NV  
AOS130-B  
1.25", Cordless,  
8000 rpm  
Orbit 3 mm



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



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



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

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