

Marine

Production gel coat process



Mirka® DEROS 650X CV
6", orbit 5mm

Defect removal	STEP 1		Galaxy 6", Grit 240
	STEP 2		Galaxy 6", Grit 320
Scratch conditioning	STEP 3		Galaxy 6", Grit 500
	STEP 4		Net interface + Galaxy 6", Grit 800
Pre-polish sanding (for light colors)	STEP 5		Net interface + Galaxy 6", Grit 1000
	STEP 5		Net interface + Galaxy 6", Grit 1200
Pre-polish sanding (for dark colors)			

SANDING



STEP 1

- Start by attaching the Mirka® Galaxy, 240 grit, to the Mirka® DEROS 650X CV.
- Sand the area



STEP 4

- Continue by attaching the net interface to the Mirka® DEROS 650X CV.
- Sand with Galaxy, 800 grit

NOTE!

Extending the sanding process and using finer grits reduces polishing time and lowers the total production time and cost.



STEP 2

- Change to Mirka® Galaxy, 320 grit and continue sanding.



STEP 5

- Finish sanding with Mirka® Galaxy, 1000 grit, with the net interface (use 1200 grit on dark colors).



STEP 3

- Attach and sand with Mirka® Galaxy, 500 grit.



STEP 6

- Clean the sanded area with a microfiber cleaning cloth. The sanded area is ready to be polished.

Dedicated to the finish.

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<p>Scratch removal</p> <p>Final polishing (for light colors)</p> <p>Cleaning</p>	<p>STEP 1</p>  <p>Polarshine® 45 polishing compound and twisted wool pad</p>
	<p>STEP 2</p>  <p>Polarshine® 12 and lambs wool polishing pad</p>
	<p>STEP 3</p>  <p>Microfiber cleaning cloth</p>

POLISHING



STEP 1

- Start by attaching the twisted wool pad to the polisher.
- Apply Polarshine® 45 polishing compound to the twisted wool pad.



STEP 2

- Attach the lambs wool polishing pad and apply Polarshine® 12 to the pad
- Polish the surface



- Start polishing.



STEP 3

- Clean the polished area with a microfiber cleaning cloth.

Dedicated to the finish.