

Marine

Production gel coat process



Mirka® DEROS II 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
	STEP 5	Net interface + Galaxy 150mm, Grit 1200
Pre-polish sanding (for light colours)		
Pre-polish sanding (for dark colours)		

SANDING



STEP 1

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



STEP 4

- Continue by attaching the net interface to the DEROS II 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		Polarshine® Marine Heavy Cut Compound and Twisted wool pad
	STEP 2		Polarshine® Marine Fine Compound (Antihologram) and a Waffled polishing foam pad
Final polishing (for light colours)	STEP 2		Polarshine® 12 Black with a Black waffle M foam pad
	STEP 3		Micro fiber cleaning cloth
Final polishing (for dark colours)	STEP 2		Polarshine® 12 Black with a Black waffle M foam pad

POLISHING



STEP 1

- Attach the Twisted wool pad to Mirka® PS 1437.
- Apply *Polarshine® Marine Heavy Cut Compound*.



- Start polishing



STEP 2 (recommended for light colours)

- Attach a Yellow waffle polishing foam pad and apply *Polarshine® Marine Fine Compound, Antihologram* to the pad.
- Polish the surface



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 3

- Clean the polished area with a Micro fiber cleaning cloth.

Dedicated to the finish.