


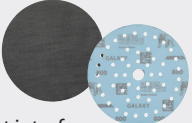
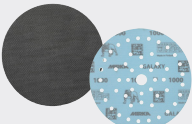
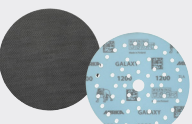


# Marine Production Gel Coat Process



Mirka® DEROS 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 colors)		
Pre-polish sanding (for dark colors)		

## SANDING



### STEP 1

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



### STEP 2

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



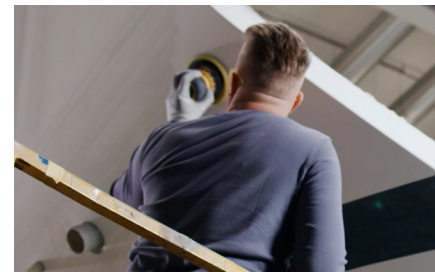
### STEP 3

- Attach and sand with Mirka® Galaxy, 500 grit



### STEP 4

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



### STEP 5

- Finish the sanding with Mirka® Galaxy 1000 grit together with Net interface (use 1200 grit on dark colors)



### STEP 6

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

### NOTE!

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