

**MIRKA**

# Galaxy & Iridium Soft PROCESS

## Standard Repair Process



Mirka® DEROS II 650  
150mm, orbit 5mm



Galaxy 150mm, Grit 80



Galaxy 150mm, Grit 180



Galaxy 150mm, Grit 240



Galaxy 150mm, Grit 320/400



Iridium Soft 150mm, Grit 400

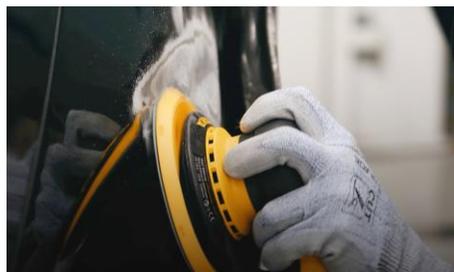


Iridium Soft 150mm, Grit 600



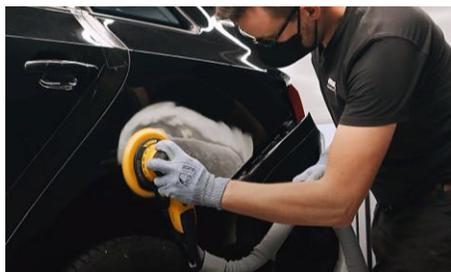
Optional

Iridium Soft 150mm, Grit  
800/1000



### PAINT STRIPPING

- Use Galaxy grit 80 together with DEROS II 650.
- Speed 8000-9000 rpm
- Sand with a small tilt and strip layer by layer



### FEATHER EDGE

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



### SCRATCH CONDITIONING

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



BODY FILLER APPLICATION

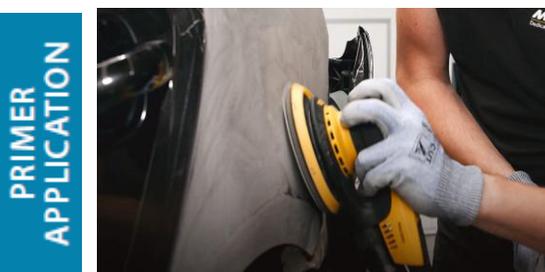
### BODY FILLER SANDING

- Start with Galaxy grit **80** and continue with grit **180** and finish with **240**
- Speed 8000 rpm
- Apply Dry Guide Coat between the steps



### PRIMER PREPARATION

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



PRIMER APPLICATION

### PRIMER SANDING / PAINT PREP.

- Block sand the repaired area with Galaxy 400. Or use Galaxy 400 disc to level the primer
- Use **Iridium Soft** grit **400** to finish the primer
- Speed 6000 – 7000 rpm
- No interface



### CLEAR COAT SANDING/BLENDING

- Use **Iridium Soft** grit **600**
  - **Optional use grit 800/1000**
  - **Use the same disc for hand sanding of edges**
- Speed 6000 – 7000 rpm
- No interface