

SUBSTRATE

SAND PAPER GRADE

DRY SANDING PROCESS

Removal of old Paint

P80 – P180 – P320



Clean substrate of all contamination

Bare Steel

P80 – P150



Apply guide coat to substrate

Reducing deep scratching in bare metal

P120 – P240



Sand substrate with hand block using P240

Aluminium

P180 – P280



Clean surface after first sand ensuring surface is free of dust and dirt. Recommended to clean with 1-951 silicone remover to remove all dust from scratch marks

Ecoat to be prepared for wet on wet process

P320 – P400



Apply guide coat to substrate

Stainless Steel

P280 – P320



Sand with P320. Use interface pad
Use osculating finishing Sander (3.0 mm orbit)

Spray Polyester

P120 – P220 – P320



Sand with P400 to topcoat with 2000 Series BeroMix. Use interface pad
Sand with P500 to topcoat with 500 Series BeroBase
Use osculating finishing sander (3.0 mm orbit)

Polyester Filler

P80 – P180 – P280



Sand with P500 to topcoat with 500 Series BeroBase Use interface Pad

Paint edges

P220 – P320

HS Surfacer/final sand for topcoat 2000 Series 2K

P220 – P320 – P400 final sand with interface pad

HS Surfacer/final sand for topcoat 500 Series BeroBase

P220 – P 320 – P500 final sand with interface pad

Prepare panels for blending

Grey scotch brite
Or P800 used on machine with 3.0mm osculating action