



Product Training

Sanding

A brand of

 **BASF**

We create chemistry



Sanding

The most important functions of sanding:

- Smoothing
- Adhesion
- Shaping
- Removing material
- Creating a high-grade surface quality



Sanding

Factors having an impact on the sanding result

- Type of primer filler/surfacer used
- Spray pattern
- Level of curing
- Cleanliness of the surface
- Shape of the surface



Sanding

Factors having an impact on the sanding result

The operator

- Pressure applied
- Machine movement
- Sanding technique



Sanding

Factors having an impact on the sanding result

Abrasives

- Mineral type
- Structure, distribution and grit size





Sanding

Factors having an impact on the sanding result

Design features

- Backing plate
- (shape, extraction routes, hardness, etc.)





Sanding

Factors having an impact on the sanding result

Machine

- Model type, orbit diameter
- Speed, type of drive
- Extraction





Sanding

Orbit diameter

The term 'orbit diameter' means the distance which the backing plate travels in its orbital movement while it rotates.

A perfect result also depends on the right choice of backing plate hardness and on the use of the correct grit size of the abrasive.

By adapting the orbit diameter, the hardness of the backing plate and the recommended grit sizes to the task at hand you will achieve high sanding efficiency paired with excellent results.



Sanding

Orbit diameter in pre-treatment

Sanders with orbit diameters are used in pre-treatment operations for high working efficiency in terms of material removal as well as speed.

The optimum plate hardness for sanding body filler is hard to medium. Grit sizes ranging from P80 to P240



Sanding

Orbit diameter

It is used mainly for fine sanding and primer filler/surfacer sanding operations. The small orbit diameter gives a very fine sanding result when the appropriate sanding discs are used.

The sanded surface is then ready to be coated with any type of topcoat or basecoat product.



For fine sanding, the backing plate hardness should be medium to soft.

Grit sizes ranging from dry with P400 to manual wet sanding with P800