



1 Preparation

Work step	Product recommendation	Grit
Paint stripping	siaspeed 150 mm	P080 → P120
Sanding out scratches/dents	siaspeed 150 mm	P180 → P320

2 Bodyfiller: Shaping and flattening

Work step	Product recommendation	Grit
Sanding into shape	siaspeed with siablock	P080 → P120
Flattening	siaspeed with siablock	P180 → P320

3 Bodyfiller/Old paint: Fine sanding

Work step	Product recommendation	Grit
Edges and curves	siaspeed siasoft	P320 → P400
Fine sanding a surface	siaspeed 150 mm	P320 → P400

4 Primer: Fine sanding

Work step	Product recommendation	Grit
Edges and curves	siaspeed siasoft	P600 For critical colours (e.g. silver) P800
Flattening & fine sanding surfaces	siaspeed 150 mm	P400
De-dusting/Refining	siavlies speed 150 mm grey	ultrafine

Sanding new e-coat parts

Work step	Product recommendation	Grit
E-coat with normal hardness	siaspeed 150 mm	P320
Inside of new e-coat parts	siavlies flex red	veryfine
Ultra-hard factory primer	siacarbon 150 mm	P320



Do not skip more than 2 grits!

Hints and tips

Work step	Product recommendation
Making the texture visible	sia black control powder
De-dusting and refining the surfaces	siavlies speed 150 mm, grey or ultra fine
Protection of the random orbital sander against moisture	sia Protection Disc for damp sanding with siaair/siacarat
For curves, contours and ultra fine grits	sia Intermediate Pad
Adapted manual sanding on curves and contours	siablock flexibly adjustable hand sanding blocks and body file

Extract from product range

Article	Product	Grain	Size	Weight	Article No.
1950 siaspeed FiboTec	Multi-hole	80	Ø150 mm	2279.5390.0080	
1950 siaspeed FiboTec	Multi-hole	120	Ø150 mm	8420.1301.0120	
1950 siaspeed FiboTec	Multi-hole	180	Ø150 mm	8420.1301.0180	
1950 siaspeed FiboTec	Multi-hole	240	Ø150 mm	8420.1301.0240	
1950 siaspeed FiboTec	Multi-hole	320	Ø150 mm	8420.1301.0320	
1950 siaspeed FiboTec	Multi-hole	400	Ø150 mm	8420.1301.0400	
1950 siaspeed FiboTec	Multi-hole	500	Ø150 mm	8420.1301.0500	
1950 siaspeed FiboTec	Multi-hole	600	Ø150 mm	8420.1301.0600	
7241 siacarbon	None	320	Ø150 mm	9980.9463.0320	
6120 siavlies speed	None	very fine/red	Ø150 mm	7866.2539.6921	
6120 siavlies speed	None	ultra fine/grey	Ø150 mm	7866.2539.8715	
siapad soft (M8 & 5/16")	15-hole + Multi-hole		Ø150 mm	0020.5740	
siapad soft (5/16")	15-hole + Multi-hole		Ø150 mm	0020.6734	
sia Intermediate Pad	15-hole + Multi-hole		Ø150 mm	0020.5886	
sia black control powder	Set: Block + 2 x 30 g			0020.2302	
6711 siavlies flex	None	very fine/red	115 x 230 mm	0948.3321.6921	
6711 siavlies flex	None	ultra fine/grey	115 x 230 mm	0948.3321.8711	
1950 siaspeed siasoft roll	None	320	115 mm x 25 m	2237.4334.0320	
1950 siaspeed siasoft roll	None	400	115 mm x 25 m	2237.4334.0400	
1950 siaspeed siasoft roll	None	600	115 mm x 25 m	2237.4334.0600	
1950 siaspeed siasoft roll (film)	None	800	110 mm x 25 m	7621.1023.0800	
siablock flexible with dust extraction	41-hole (Multi-hole)		70 x 198 mm	0020.6695	
1950 siaspeed	41-hole	80	70 x 198 mm	8431.5398.0080	
1950 siaspeed	41-hole	120	70 x 198 mm	8431.5398.0120	
1950 siaspeed	41-hole	180	70 x 198 mm	8431.5398.0180	
1950 siaspeed	41-hole	320	70 x 198 mm	8431.5398.0320	
siablock flexible with dust extraction	49-hole (Multi-hole)		115 x 230 mm	0020.6518	
1950 siaspeed	49-hole	80	115 x 230 mm	4366.8648.0080	
1950 siaspeed	49-hole	120	115 x 230 mm	4366.8648.0120	
1950 siaspeed	49-hole	180	115 x 230 mm	4366.8648.0180	
1950 siaspeed	49-hole	320	115 x 230 mm	4366.8648.0320	
siablock flexible with dust extraction	68-hole (Multi-hole)		70 x 400 mm	0020.7045	
1950 siaspeed	68-hole	80	70 x 420 mm	0192.4404.0080	
1950 siaspeed	68-hole	120	70 x 420 mm	0192.4404.0120	
1950 siaspeed	68-hole	180	70 x 420 mm	0192.4404.0180	
1950 siaspeed	68-hole	320	70 x 420 mm	0192.4404.0320	

► You will find more articles and information at www.sia-abrasives.com

Before using and processing the products, please consult the current technical information sheet/safety data sheet. Do not skip more than 2 grits! In the application steps listed a recommendation is concerned; the steps must be adapted according to the requirements. No legal decision can be deduced from this recommendation.