

**karuun®**

**surface manual - brushing | sanding**

# surface steps - brushing | sanding

## material preparation

1. **karuun® stripe (backed or unbacked version)**
2. **press on carrier board**
- 3.\* **pre-sand in WBS sander: grit 180 - 240 (unbacked version only)**

## process steps

- 1.\*\* **watering surface: spray with water 30 - 60°C | wait until surface is 100% dry**
- 2.\*\*\* **brushing - both directions (grain direction): 0,15 mm - Ø 17,5 cm - s. steel - 900rpm**
3. **orbital / rotational sanding „Rotex“: grit 240**
4. **air blowing: 2 - 5 cm distance, 8 bar**
5. **optical check for upstanding and loose fibres and manual finish with “Mirka Abralon” grit 360 – 45° or 90° to the fibre direction**
6. **air blowing: 20 cm distance, 8 bar**

- \* **Backed karuun® stripe version is already pre-sanded and may not be WBS sanded.**
- \*\* **Suggested if the surface is going to be stained or laquered with water based laquer. For non-water treated surfaces watering may not needed.**
- \*\*\* **Brush setup can be provided by OFS for various kind of machines.**

# detailed surface steps

1. watering surface: spray with water 30 - 60°C  
wait until surface is 100% dry



# detailed surface steps

## 2. brushing - both directions (grain direction): 900rpm



- surface pressure: 1 - 2 cm
- slow and constant movement

### Ideal brush specifications

Wheel brush:

Wire Ø: 0,15 mm (or 0,2 mm)

Wire length: 30 - 40 mm

Brush Ø: 100 - 175 mm

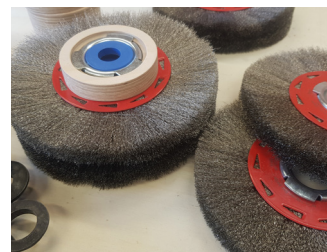
Material: stainless steel or brass

### Device examples:



Makita 9741 Festool BMS 180 E Fine BBQ Brush

### Brush example:



JAZ CU 1703B

<https://www.jazsurface.com/en/wire-brushes/crimped-wire-wheels/narrow-face-wheel-3-rows/>





**before (capillaries are covered)**

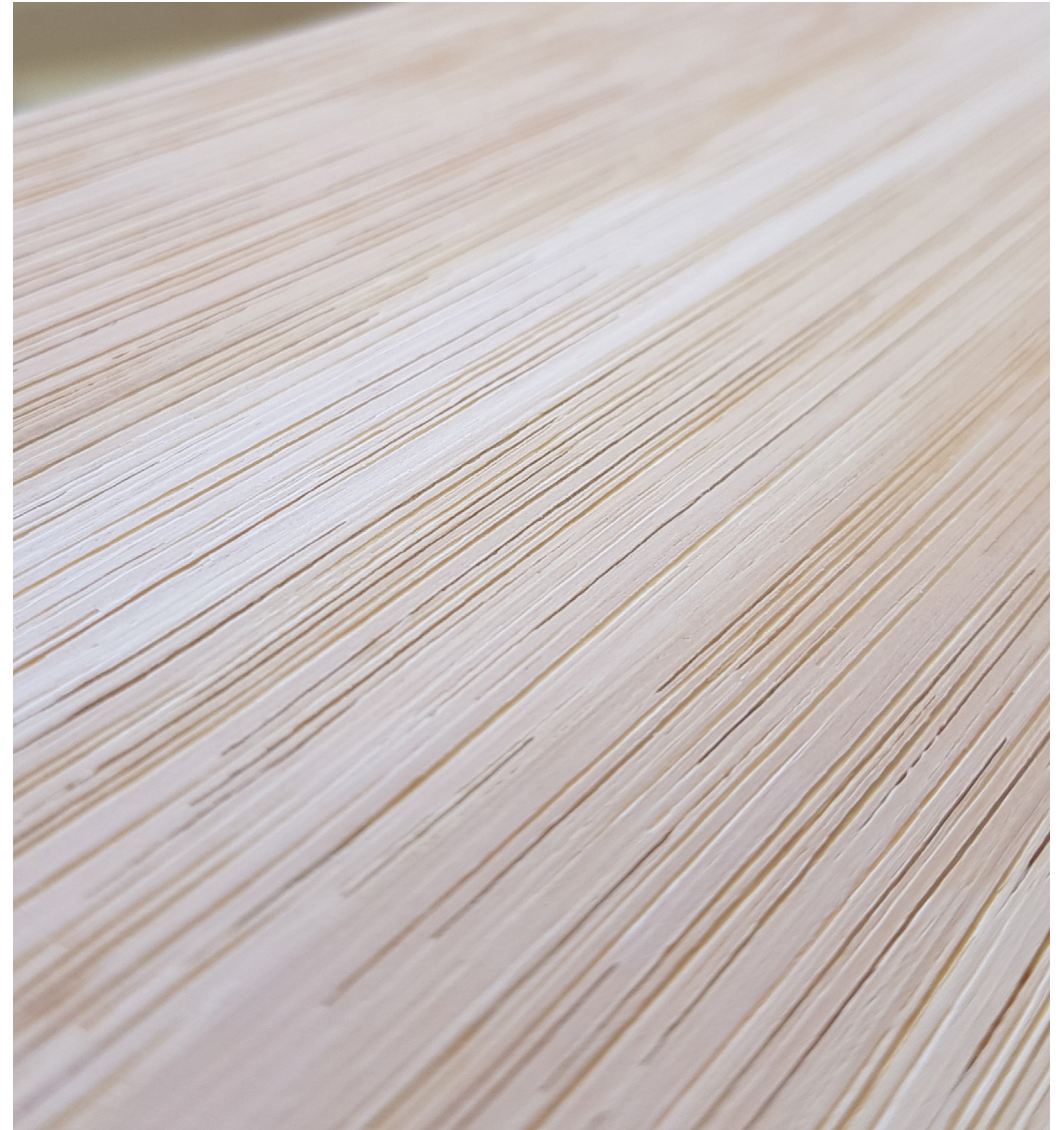


**after (open structure)**





**before**



**after**

# detailed surface steps

## 3. orbital / rotational sanding („Rotex“): grit 240



### Machine examples:



**Festool Rotex**



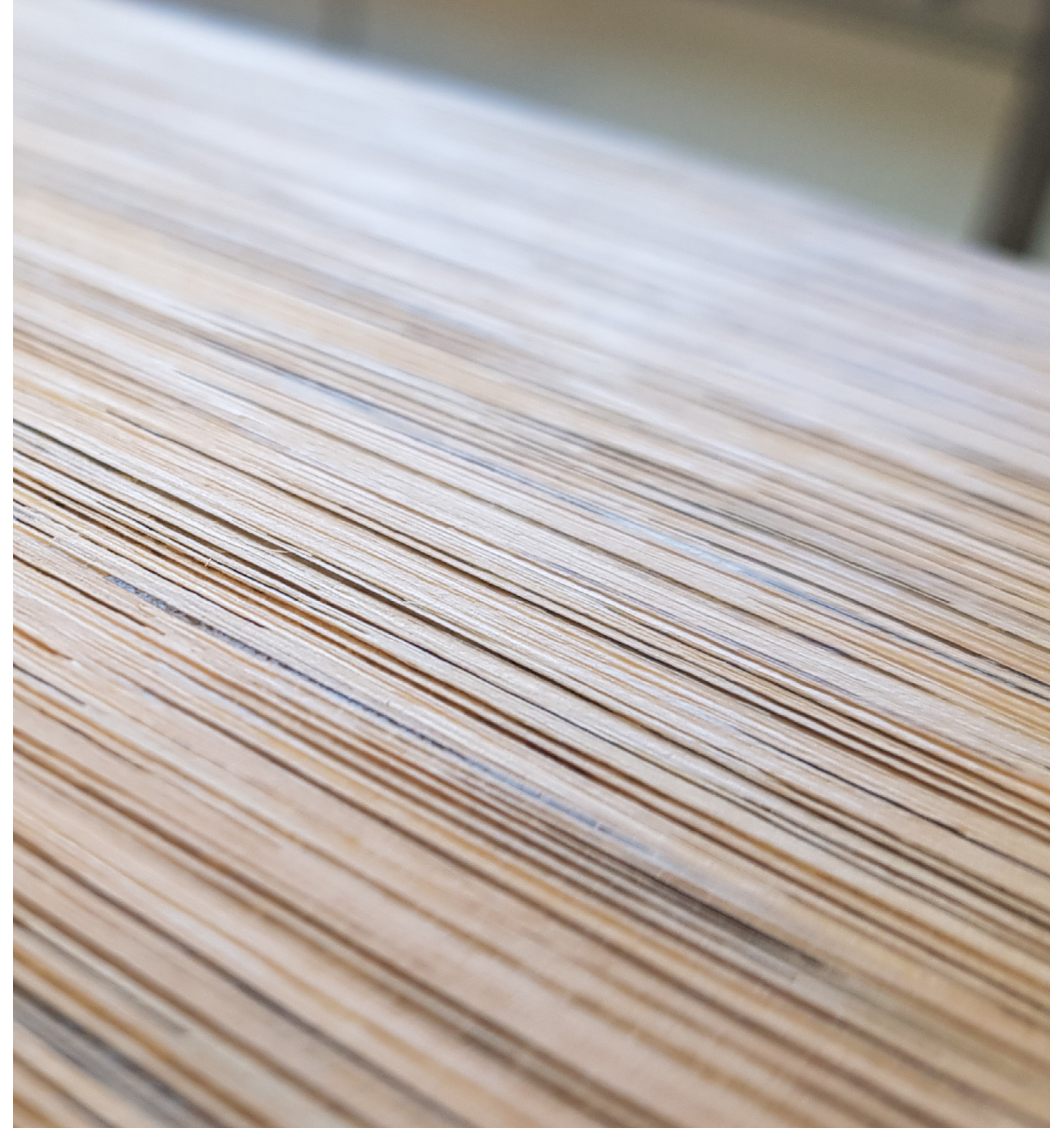
**Mirka Deros**

- ideal movement in 2 steps:
  1. 90° to the grain direction
  2. towards grain direction





**before (lifted fibres)**



**after (no upstanding fibres)**



# **detailed surface steps**

**4. air blowing: 2 - 5 cm distance, 8 bar**



**- 90 degrees to the fibre direction**

# **detailed surface steps**

- 5. optical check for upstanding and loose fibres**  
**manual finish with “Mirka Abralon” grit 360**



- 45/90° to the fibre direction**
- minimum surface pressure**



# detailed surface steps

**6. air blowing: 20 cm distance, 8 bar**





**before brushing | sanding**



**after brushing | sanding**





**before brushing | sanding**



**after brushing | sanding**

**Next step: surface manual - finishing**