MIRKA

MARINE
SURFACE FINISHING





About Mirka

Mirka Ltd is a family-owned Finnish company and a world leader in abrasives technology innovation. We offer a complete range of technically superior, high-quality abrasives, innovatively designed tools, complete sanding systems and supplementary products. This total innovative solution delivers real benefits to customers in terms of speed, first-class efficiency, surface finish quality and cost-effectiveness, even when tackling the most demanding applications.

Mirka is the first company in its sector to obtain the three most important quality standards: The production process guarantees reliable quality by following the ISO 9001 quality assurance system. The OHSAS 18001 occupational health and safety management system ensures a high level of work safety. The ISO 14001 environmental management system proves that we consider the environment in all our activities. 97 percent of our products are exported and sold across the globe through our subsidiaries and importers.

> Read more: mirka.com

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Perfect Surfaces for Tough Conditions

Facing harsh conditions with salt, water and wind, marine surfaces need to be built to last, as well as regularly maintained and expertly refurbished to keep that first-class look. When it comes to marine surface finishing, from boat manufacturing – including high-end yacht production – to boat refurbishing and restoration, Mirka can deliver.

Choosing dust-free and ergonomic Mirka products isn't only a health-conscious choice, but it will also improve your profitability, productivity and efficiency.

Mirka's sanding, compounding and polishing products together with our award-winning tools suit everything from heavy-duty sanding of composite moulds to smoothening out the final gel coat finish – from small scale to high volume production.

If you are looking for high-rate efficiency and a world class finish for your marine surfaces; read on to learn more about innovative solutions that give you better results with fewer steps.

PLUG AND **MOULD**

It all starts with building a frame. When **sanding** fibreglass plugs and moulds, our net and multihole abrasives, ergonomic sanders and efficient dust extraction improve work safety and allow you to work faster and more efficiently. Mirka has pneumatic and electric sanders for a range of applications, which can be used in combination with Mirka's abrasives, such as Abranet Ace and Abranet Ace HD from the net sanding range and Galaxy from the film abrasive range. Galaxy film abrasive's precision coating makes it highly durable and clog resistant, with excellent edge wear resistance. The Abranet Ace range's durable net construction and ceramic grains mean that it cannot be beaten when it comes to performance, not to mention offering similarly optimised dust extraction capacity.

When the time comes to add the **finishing** touches, Mirka's range has everything you need. You can pre-treat the surface prior to polishing, with a film or foam backed abrasive. You can also work more efficiently with Mirka's pneumatic or electric tools.

Choose the best abrasive for the job at hand: **Galaxy** film offers outstanding performance on hard gel coats, whilst **Microstar** is designed especially for matting surfaces. If you are familiar with using foam-backed abrasives, **Abralon J3** is a great choice for finishing prior to polishing. The patented, flexible construction allows it to create an even surface while minimising the risk of pressure marks.

SANDING



Abranet® Ace

Abranet® Ace – offers superior cut and performance for more demanding sanding applications, with an optimised net construction and ceramic grains.



Abranet® Ace HD

Abranet® Ace HD – resists high wear and tear and is ideal for heavy-duty applications.



Galaxy

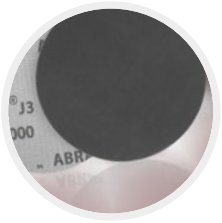
Galaxy – aggressive initial cut for heavy duty applications in coarser grits. Long lasting film-backed disc with excellent edge wear resistance and flatness.

FINISHING



Galaxy

Galaxy – particularly effective for mould sanding on hard gel coats and scratch resistant clear coats.



Abralon® J3

Abralon® J3 – specially developed for surface preparation and finishing prior to polishing.



Microstar®

Microstar® – designed for matting and paint rectification of top- and clear coat.



Polarshine®

Polarshine® Marine Medium Cut – a medium coarse polishing compound designed to achieve a better end result after sanding with just one round of polishing.



SANDING TOOLS AND ACCESSORIES

PNEUMATIC TOOLS



Mirka® ROS2 850CV



Mirka® PROS 650CV



Mirka® OS 383CV



Mirka® ROS2 510CV



Mirka® RPS 300CV



Hose
27 mm x 5,5 m
(with integrated pneumatics)

ELECTRIC TOOLS



Mirka® DEROS II 650 / 680

Mirka® DEOS II 383



Hose 27 mm x 4 m
(4 m CE 230 V with sleeve
+ integrated cable)



Hose 27 mm x 6 m
(6 m CE 230 V with sleeve
+ integrated cable)

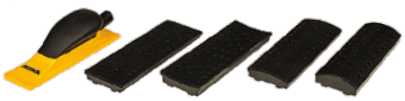


Hose 27 mm x 10 m
(10 m CE 230 V with sleeve
+ integrated cable)

HAND SANDING BLOCKS



File Board 70 x 400 mm
hard / flexible



Sanding block 70 x 198 mm

DUST EXTRACTION



Mirka® DEXOS 1217/1230 M AFC, Mirka® Dust Extractor 1242, 1230 and 1025 L/1125 L

Marine

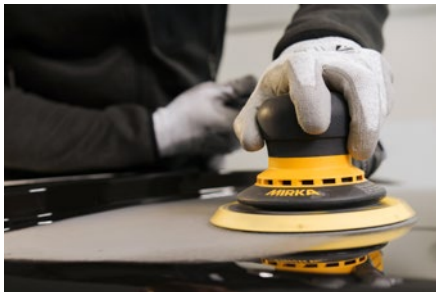
Mould Gel Coat Sanding Process

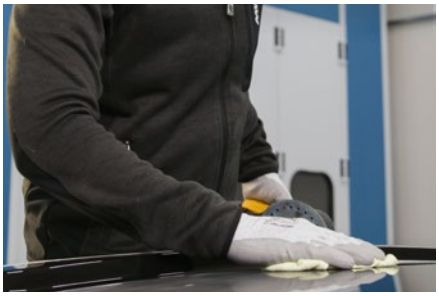


Mirka® DEROS II 650
150 mm, orbit 5 mm

SANDING







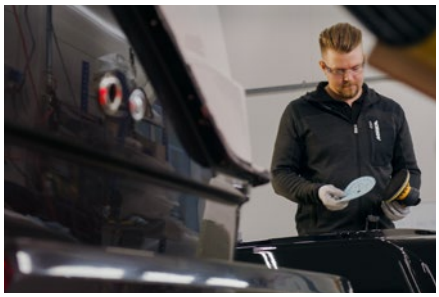
STEP 1

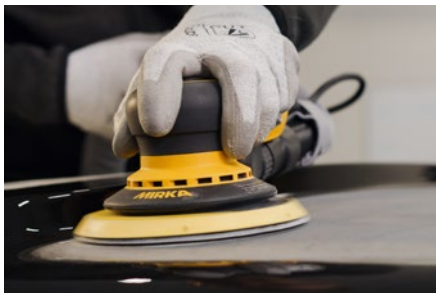
- For orange peel surfaces, start sanding with Mirka® Galaxy 600 grit together with Mirka® DEROS II.

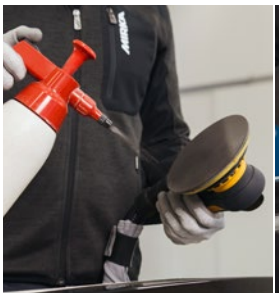
STEP 2

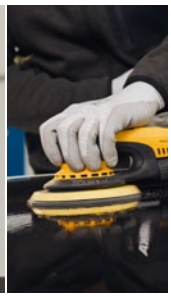
- The starting point of this surface is good, we therefore start from Galaxy grit 800 using a Net Interface.

- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.









STEP 3

- Continue sanding until scratches are reduced
- Use Galaxy 1200 or 1500 grit together with a Net Interface.

STEP 4

- Use Galaxy 2000 grit together with a Net Interface.

STEP 5

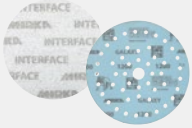
- When wet sanding, turn off the dust extractor.
- Use Mirka Abralon® 3000.



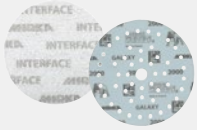
Galaxy 150mm, Grit 600



Net interface + Galaxy 150mm, Grit 800



Net interface + Galaxy 150mm, Grit 1200



Net interface + Galaxy 150mm, Grit 2000



Abralon J3 150mm, Grit 3000

STEP 1	STEP 2	STEP 3	STEP 4	STEP 5
Defect removal	Scratch conditioning	Pre-polish sanding		Wet sanding

NOTE! By extending the sanding process and using finer grits, the polishing time will shorten and lower the total production time and cost.

Marine
Mould Gel Coat Finishing Process



Mirka® POLAROS RP 600
Polisher, 150 mm

POLISHING

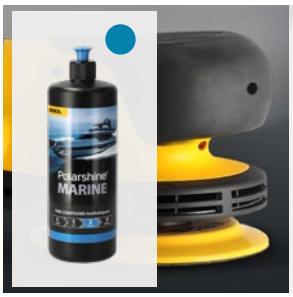


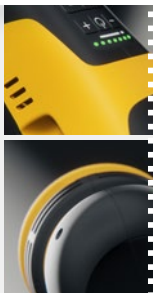




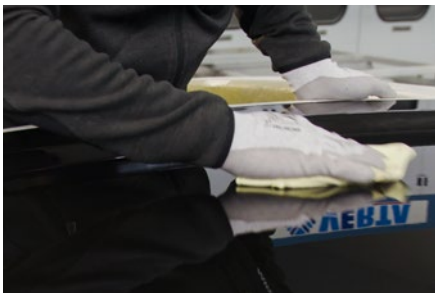
STEP 1

- Use ***Polarshine® Marine Heavy Cut*** Compound and a Lambswool pad Pro Yellow together with **Mirka® POLAROS RP 600** Polisher.
- Polish the surface to eliminate sanding scratches.
- Wipe off any excess polishing compound between the polishing steps.









STEP 2 (recommended for light colours)

- Attach a Polishing Foam Pad Yellow Waffle and apply ***Polarshine Marine Fine*** compound to the pad and polish the surface.

STEP 2 (recommended for dark colours)

- Change to a Black waffle M foam pad, apply ***Polarshine® 12 Black*** polishing compound and polish the surface.
- Finally, wipe off excess polishing compound.



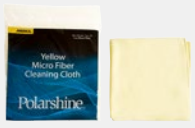
Polarshine® Marine Heavy Cut polishing compound and Lambswool pad Pro



Polarshine® Marine Fine compound, and a Waffled polishing foam pad

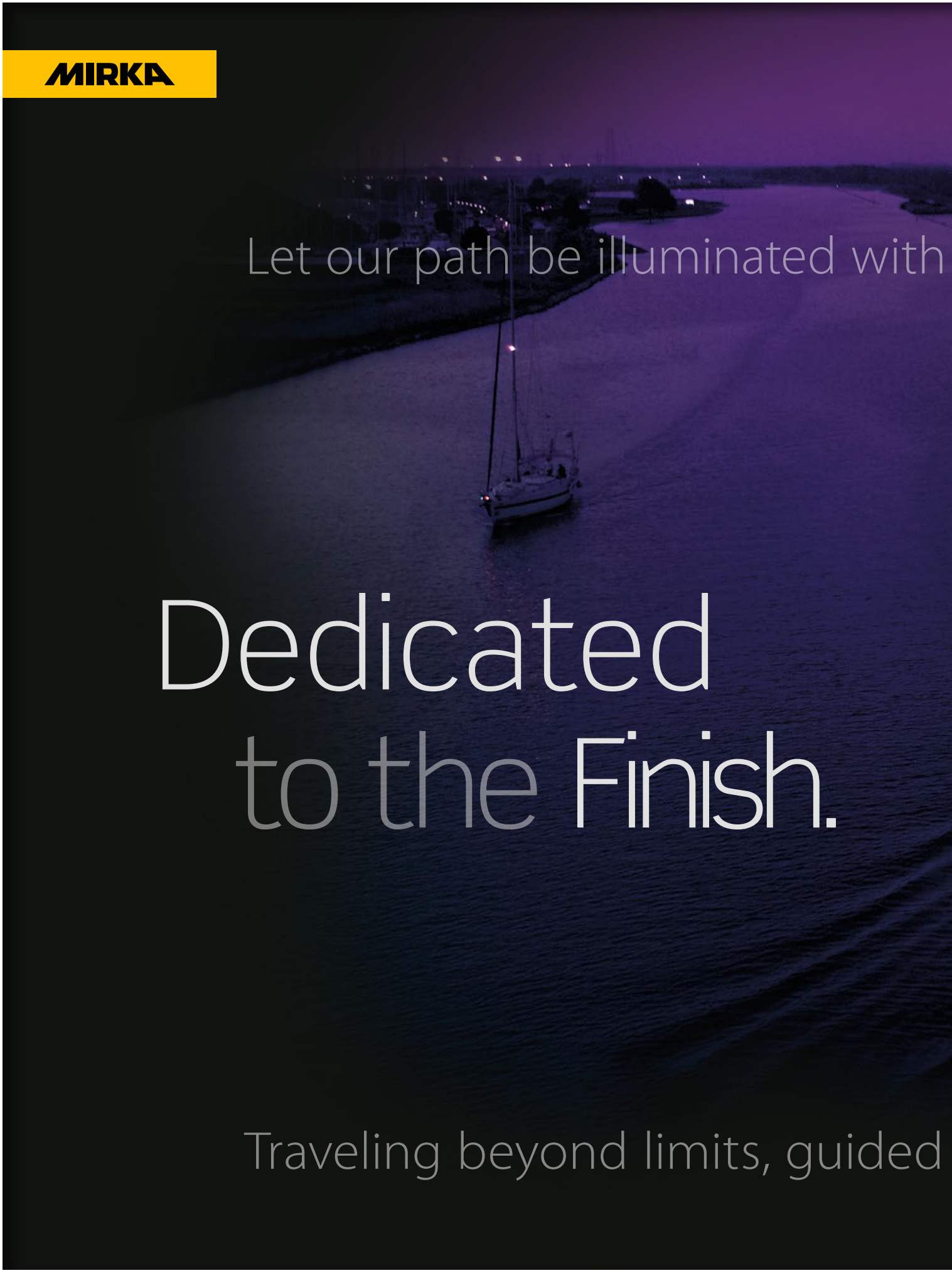


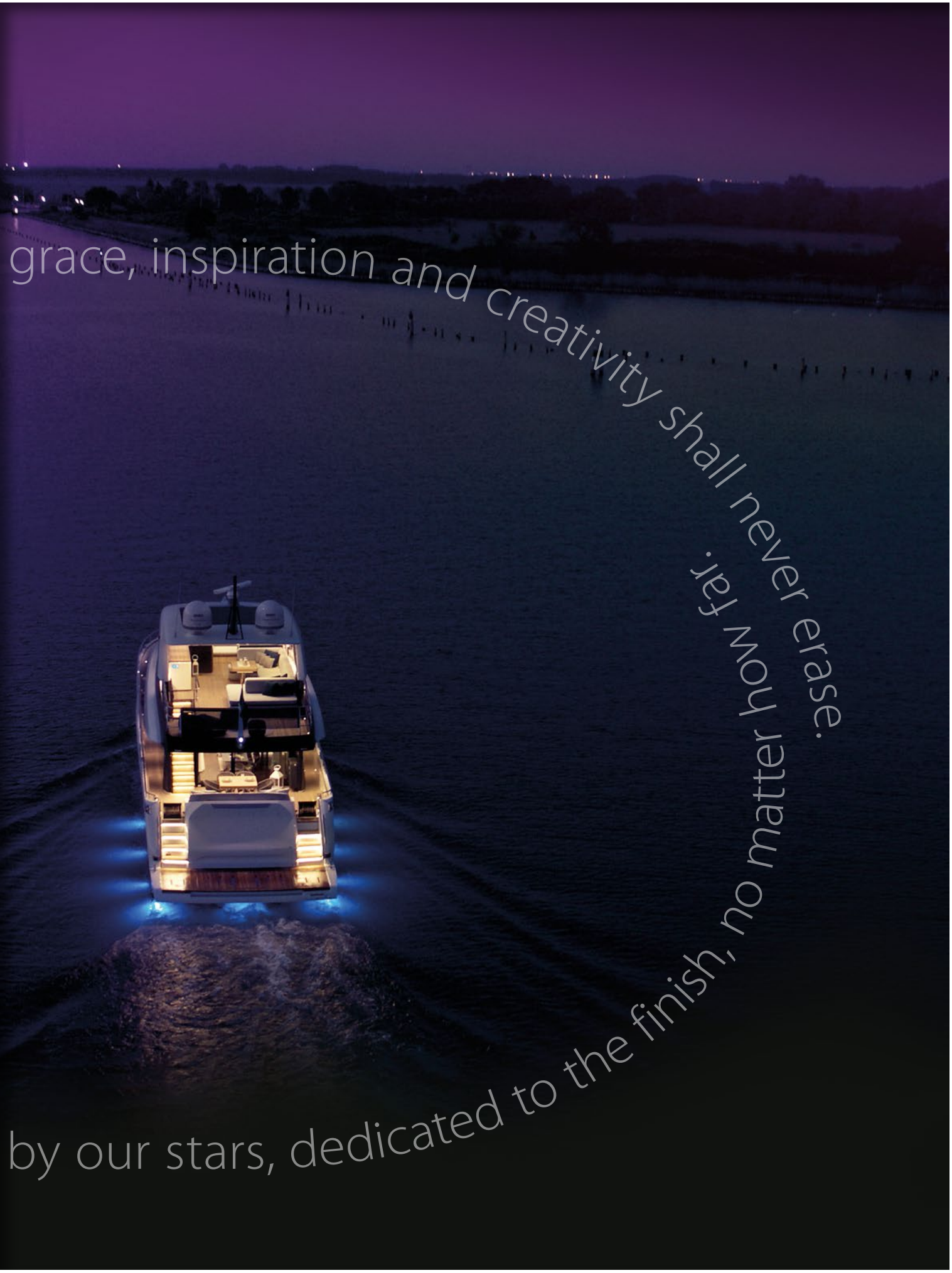
Polarshine® 12 Black with a Black waffle M foam pad



Cleaning Cloth Micro Fiber

STEP 1	STEP 2	STEP 2	STEP 3
Scratch removal	Final polishing (for light colours)	Final polishing (for dark colours)	Cleaning


MIRKA
Let our path be illuminated with
Dedicated
to the Finish.
Traveling beyond limits, guided


grace, inspiration and creativity shall never erase.
no matter how far.
by our stars, dedicated to the finish, no matter how far.

PRODUCTION **GEL COAT**

It is easy to condition a gelcoat finish with Mirka solutions. To get the perfect lustre and shine of a gelcoat surface on a newly manufactured yacht or boat, the crucial component is the exterior layer of the gelcoat. For yachts, the gelcoat surfaces are made to be long-lasting, to be able to resist UV damage and rough conditions at sea, but they must be maintained for a long life. And a maintained gelcoat surface is not only about looks. You will also protect the yacht or boat from salt, filth, mould, and excessive moisture with a well kept gelcoat surface.

ABRASIVES



Abranet® Ace

Abranet® Ace – offers superior cut and performance for more demanding sanding applications, with an optimised net construction and ceramic grains.



Galaxy

Galaxy – particularly effective for mould sanding on hard gel coats and scratch resistant clear coats.

POLISHING COMPOUNDS



Polarshine® Marine

Heavy Cut compound

Polarshine® Marine Heavy Cut is a very coarse polishing compound ideal for marine and industrial gelcoats.



Polarshine® Marine

Medium Cut compound

Polarshine® Marine Medium Cut polishing compound for top- and clear coats. Quick removal of oxidation and sanding scratches.



Polarshine® Marine

Fine compound, Antihologram

Polarshine® Marine Fine is a fine compound for the second step, which leaves a longer lasting high gloss finish.



Polarshine® 12 Black

For dark surfaces

Polarshine® 12 Black and a black waffle pad is recommended for dark-colored surfaces.

PADS



Twisted lambswool pad

A pure wool pad for coarser polishing in marine, wood and ART applications.



Lambswool pad PRO

Made of premium wool fibers optimized to keep performance on high level for demanding use.



Yellow waffle foam

Medium density hardness and waffle shape with excellent elasticity. Optimized pattern improves cutting performance.



Black waffle foam M

Optimized pattern for long-lasting and improved cutting performance. Excellent balance in elasticity and softness. Reduces surface temperature during polishing.



TOOLS AND ACCESSORIES

ELECTRIC TOOLS



Mirka® POLAROS RP 600
Polisher 150 mm



Mirka® DEROS II 350
Sander 77 mm



Mirka® DEROS II 650
Sander 150 mm

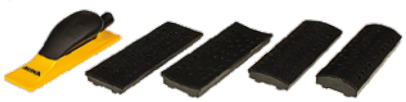


Mirka® LEROS-S 950
Sander 225 mm

TOOLS



File Board 70 x 400 mm
hard / flexible



Sanding block 70 x 198 mm



Mirka® DEXOS 1217 M AFC (17 l)
and DEXOS 1230 M AFC (30 l)



Mirka® Dust Extractor
1230 L AFC and 1242 M AFC

ACCESSORIES



Long file boards
3 different versions, 2 different lengths, for One or Two Operators.
115 × 680 mm rigid
115 × 1600 mm rigid
115 × 1600 mm flexible



Dust extraction hose
27 mm x 4, 6 or 10 m
CE 230 V with sleeve
+ integrated cable



Net Interface 150 mm
Interface that allows the use of non-woven products on power tools.



Universal pad washer
Professional system for cleaning all kind of pads

Cleaning Cloth Micro Fiber Yellow
400 x 400 mm / 5-pack

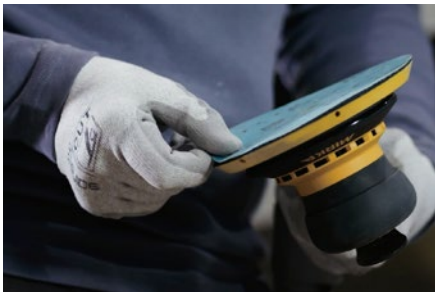
Marine

Production Gel Coat Sanding Process



Mirka® DEROS II 650
150 mm, orbit 5 mm

SANDING



STEP 1

- Start by attaching the Mirka® Galaxy, 240 grit, to the Mirka® DEROS II 650.
- Sand the area



STEP 2

- Change to Mirka® Galaxy, 320 grit and continue sanding.



STEP 3

- Attach and sand with Mirka® Galaxy, 500 grit.



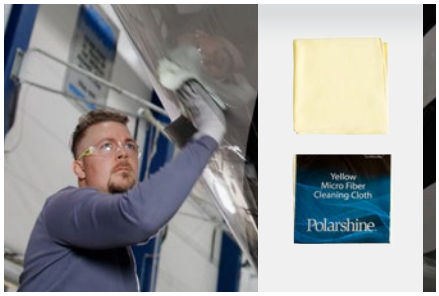
STEP 4

- Continue by attaching the net interface to the DEROS II 650.
- Sand with Galaxy, 800 grit



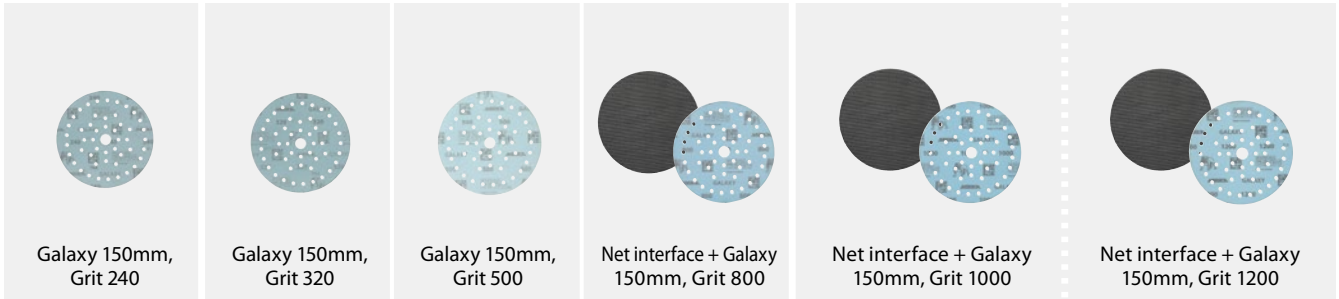
STEP 5

- Finish the sanding with Mirka® Galaxy 1000 grit together with Net inteface. (use 1200 grit on dark colours)



STEP 6

- Clean the sanded area with a Micro Fiber Cleaning Cloth. The sanded area is ready to be polished.



Marine

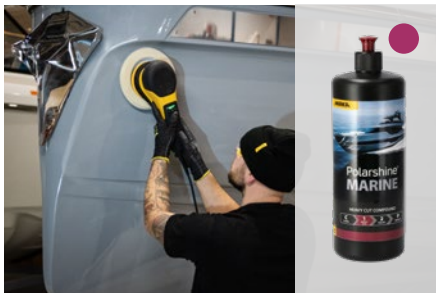
Production Gel Coat Polishing Process



Mirka® POLAROS RP 600
Polisher, 150 mm

POLISHING





NOTE ON USING TWISTED WOOL PADS WITH POLAROS RP 600

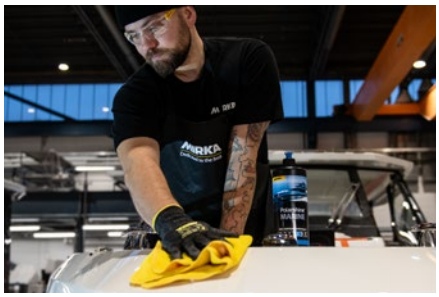
When using the 125 mm Twisted Wool Pad with the POLAROS RP 600, a 5 mm interface pad (8295535211) must be used to increase the pad height. This is a temporary solution until a dedicated long-term interface is developed.

STEP 1

- Start by attaching the Twisted wool pad to the Mirka® POLAROS RP 600 polisher tool.
- Apply ***Polarshine® Marine Heavy Cut*** polishing compound to the Twisted wool pad. Start polishing.







STEP 2 (recommended for light colours)

- Attach a Waffled polishing foam pad and apply ***Polarshine® Marine Fine compound*** to the pad.
- Polish the surface

STEP 2 (recommended for dark colours)

- Change to a Black waffle M foam pad, apply ***Polarhine® 12 Black*** polishing compound and polish the surface.

STEP 3

- Clean the polished area with a Cleaning Cloth Micro Fiber.



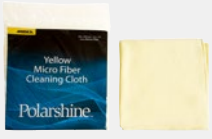
Polarshine® Marine Heavy Cut polishing compound. Twisted wool pad + interface



Polarshine® Marine Fine compound and a Waffled polishing foam pad



Polarshine® 12 Black with a Black waffle M foam pad



Cleaning Cloth Micro Fiber

STEP 1	STEP 2	STEP 2	STEP 3
Scratch removal	Final polishing (for light colours)	Final polishing (for dark colours)	Cleaning

TOP- AND CLEAR COAT

It takes time, effort, and knowledge to build and maintain the perfect yacht or boat. At the manufacturing stage, Mirka's marine solutions can make the surface finishing processes more efficient and with a better end result. The quality of the surface finish and coating can be taken to the next level by sanding or polishing, or removing smaller imperfections such as orange peel, to get an even better lustre. Topcoat marine paints can be applied after surface preparation to ensure that the topcoat paint adheres to the substrate and provides a long-lasting finish that can resist a variety of weather conditions. Mirka provides solutions for both fresh and fully cured topcoat surfaces.

ABRASIVES



Galaxy

Galaxy – particularly effective for mould sanding on hard gel coats and scratch resistant clear coats.



Mirka Iridium™ Soft

Iridium Soft – efficient sanding preventing clogging, pilling and swirl marks. Soft foam backing. Long lifetime.

POLISHING COMPOUNDS



Polarshine® Marine

Medium Cut compound

Polarshine® Marine Medium Cut polishing compound for top- and clear coats. Quick removal of oxidation and sanding scratches.



Polarshine® Marine

Fine compound, Antihologram

Polarshine® Marine Fine is a fine compound for the second step, which leaves a longer lasting high gloss finish.



Polarshine® 12 Black

For dark surfaces

Polarshine® 12 Black and a Black waffle foam M pad is recommended for dark-colored surfaces.

PADS



Lambswool pad PRO

Made of premium wool fibers optimized to keep performance on high level for demanding use.



Yellow waffle foam

Medium density hardness and waffle shape with excellent elasticity. Optimized pattern improves cutting performance.



Black waffle foam M

Optimized pattern for long-lasting and improved cutting performance. Excellent balance in elasticity and softness. Reduces surface temperature during polishing.



TOOLS AND ACCESSORIES

ELECTRIC TOOLS



Mirka® POLAROS RP 600
Polisher 150 mm



Mirka® DEROS II 650
Sander 150 mm



Mirka® LEROS-S 950
225 mm, orbit 5.0

DUST EXTRACTORS



Mirka® DEXOS 1217 M AFC
17-litre container



Mirka® DEXOS 1230 M AFC
30-litre container



Mirka® Dust Extractor
1242 M AFC



Mirka®Dust Extractor
1230 L AFC

ACCESSORIES



Dust extraction hose
27 mm x 4, 6 or 10 m
CE 230 V with sleeve
+ integrated cable



Net Interface 150 mm
Interface that allows
the use of non-woven
products on power tools.



Universal pad washer
Professional system for
cleaning all kind of pads



Cleaning Cloth Micro Fiber Yellow
400 x 400 mm / 5-pack

Marine

Top- and Clear Coat Process



Mirka® DEROS II 650
150 mm, orbit 5 mm



Mirka® POLAROS RP 600
Polisher, 150 mm

SANDING



STEP 1

- Start sanding with Mirka® DEROS II 650 using a Net Interface and Galaxy 1200 or 1500 grit.



STEP 2

- Clean the surface between every sanding step to avoid contamination and get a better visibility of the sanding progress.
- Continue with Iridium Soft 2000 grit

POLISHING



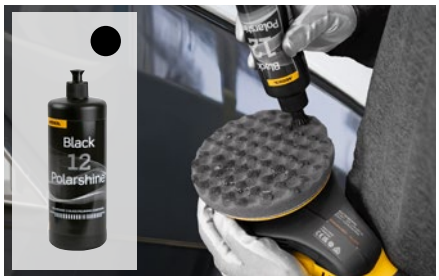
STEP 1

- Polish the surface with Polarshine® Marine Medium Cut and a Lambswool Pad PRO together with Mirka® POLAROS polisher to eliminate sanding scratches.



STEP 2 (LIGHT COLOURS)

- For light coloured surfaces, change to Polarshine® Marine Fine Compound, Anti-hologram with a Polishing Foam Pad Yellow. Wipe off excess compound.



STEP 2 (DARK COLOURS)

- For dark coloured surfaces, continue with Polarshine® 12 Black with a Black Waffle M foam pad to remove polishing marks, haze and holograms. Wipe off excess compound.

 Net interface + Galaxy 150mm, Grit 1200-1500	 Mirka Iridium™ Soft 150mm, Grit 2000	 Polarshine® Marine Medium Cut + Lambswool pad PRO	 Polarshine® Marine Fine Compound + Yellow Waffle Foam Pad. Wipe off excess compound.	 Polarshine® 12 Black + Black waffle M foam pad. Wipe off excess compound.
STEP 1	STEP 2	STEP 1	STEP 2 (LIGHT)	STEP 2 (DARK)
Defect removal	Scratch Conditioning & Pre-polish sanding	Eliminate scratches	Remove polish marks	Remove polish marks on dark or light surfaces

NOTE! By extending the sanding process and using finer grits, the polishing time will shorten and lower the total production time and cost.

DENIBBING

The perfect finish goes all the way to the smallest details. Removing imperfections from painted surfaces requires a skilled hand, but also a high-quality abrasive that gives a consistent finish, together with Mirka's cordless tools.

The triangular silicon carbide grains of the Mirka Iridium SR spot repair abrasive form new abrasive edges whenever they break down during the sanding process, prolonging its sharpness. This gives you a world-class, uniform cut and scratch pattern that is fast and easy to polish out.

ABRASIVES



Iridium SR

High precision spot repair abrasive for correcting small painting defects and removal of dust particles in top coats and clear coats.



Microns and grits

Iridium™ SR3 µ = P5000
Iridium™ SR5 µ = P3000
Iridium™ SR7 µ = P2500

POLISHING COMPOUNDS



Polarshine® Marine Fine

Polarshine® Marine Fine is a fine compound for the second step, which leaves a longer lasting high gloss finish.



Polarshine® 12 Black

Polarshine® 12 Black and a black waffle pad is recommended for dark-colored surfaces.

PADS



Lambswool pad PRO

Made of premium wool fibers optimized to keep performance on high level for demanding use.



Yellow waffle foam

Medium density hardness and waffle shape with excellent elasticity. Optimized pattern improves cutting performance.



Black waffle foam M

Optimized pattern for long-lasting and improved cutting performance. Excellent balance in elasticity and softness. Reduces surface temperature during polishing.



TOOLS AND ACCESSORIES

ELECTRIC TOOLS



Mirka® AOS-B & AROS-B sanders

Cordless sanders are more energy efficient than pneumatic tools. They do not require oiling, which removes the risk of contamination. The sanders deliver consistent performance up to 16 hours in spot repair use. The 10.8V Li-ion battery charges in 45 minutes – so with two batteries, there is no downtime.

Mirka AOS-B has a 3 mm orbit, whereas Mirka AROS-B has a random 5 mm orbit for more efficient stock removal.



Mirka® ARP-B & AROP-B polishers

Cordless polishers ideal for professionals; light, ergonomic and optimised for spot repair polishing. Incredibly nimble, they are easy to move around – with no cord to get tangled or air supply that can get contaminated. Quiet, small and very low maintenance thanks to the *brushless motor*. 77mm backing pads.

ARP-B 300NV: Rotary polisher
AROP-B 312NV: Random orbital polisher / 12 mm orbit.



Mirka® POLAROS RP 600 polisher

The POLAROS® RP 600 is a corded 150 mm rotary polisher for professional use.

With a 750 W brushless motor and a variable speed of 700–2,500 rpm, the POLAROS offers a perfect blend of power, precision, and ease of use. Despite its power, it operates quietly, with a noise level of only 58 dB.

Its low-profile, ergonomic and lightweight design offers enhanced stability and control.

ACCESSORIES



Net Interface 150 mm
Interface that allows the use of non-woven products on power tools.



Universal pad washer
Professional system for cleaning all kind of pads



Cleaning Cloth Micro Fiber Yellow
400 x 400 mm / 5-pack

Marine

Denibbing Process



SANDING & POLISHING



SANDING, STEP 1

- Use Mirka® AOS-B 130NV with a soft edge backing pad.
- Apply the Iridium™ SR3 sanding disc. (Use Iridium™ SR5 on harder surfaces)



STEP 2

- Damp the disc with Mirka's finessing damper. This step makes the lifespan of the disc longer, and it will be a smaller risk of irregular scratches on the surface.



STEP 3

- Sand at a small angle for 1-2 seconds. (If necessary, repeat the sanding step.)
- Wipe the surface clean with Mirka's Cleaning Cloth Micro Fiber Yellow.



POLISHING, STEP 1

- Use Mirka® AROP-B 312NV Ø 77 mm with a yellow Lambswool pad PRO.
- Apply a few drops of Polarshine® 12 Black compound for dark surfaces (or Polarshine 12 on light-colored surfaces).



STEP 2

- Polish for 10-12 seconds at 5000-6000 rpm, in circular motions with the cordless Mirka® AROP-B 312NV polisher.
- Wipe the surface clean with Mirka's Cleaning Cloth Micro Fiber Yellow.



STEP 3

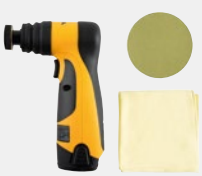
- Change the pad into a Yellow/black polishing waffle foam pad. Prime the whole surface of the pad with Polarshine 12 Black.
- Polish for 5-8 seconds in circular motions
- Wipe the surface clean



Mirka® AOS-B 130NV, Mirka Iridium™ SR3 & SR5 (Soft edge backing pad)



Mirka finessing water damper, 60 ml



Cleaning Cloth Micro Fiber Yellow



Mirka AROP-B 312NV, Lambswool pad PRO and Polarshine® 12



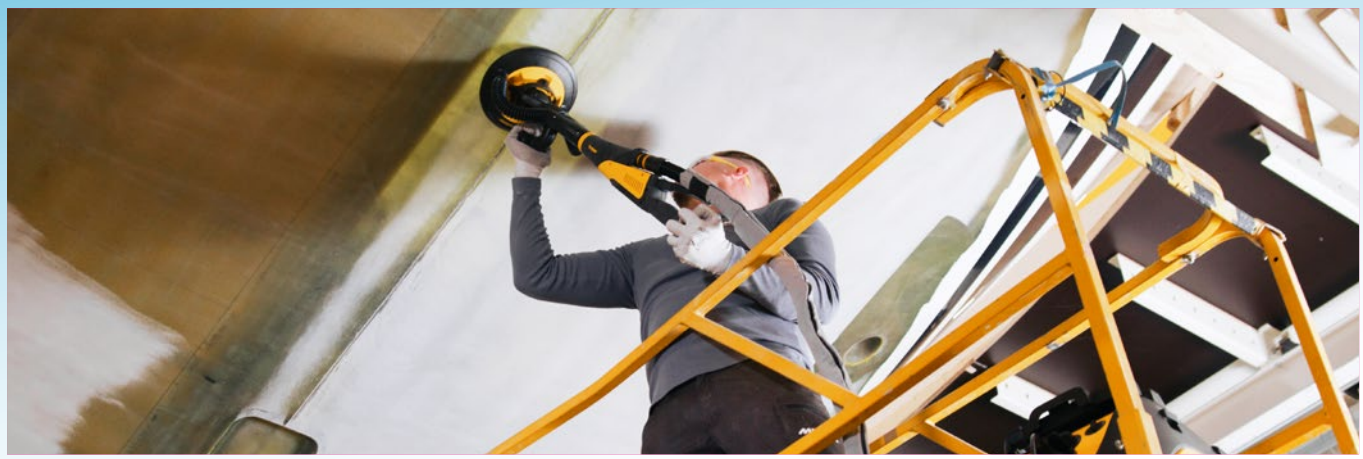
Mirka® AROP-B 312NV + Lambswool pad PRO and Polarshine® 12



+ Black waffle M foam pad & Cleaning Cloth Micro Fiber Yellow

STEP 1	STEP 2	STEP 3	STEP 1	STEP 2 AND 3
Preparation	Apply water	Defect removal and cleaning	Preparation and apply Polarshine	Polishing and final cleaning

SANDING **BELOW WATERLINE**



When sanding below the waterline, we recommend our dust-free sanding solutions – whether you're working on new or old fibreglass surfaces.

Abranet® Ace HD can endure tough wear and tear, making it ideal for heavy-duty and challenging applications: use it with Mirka's electric or pneumatic sanders and dust extraction machines or polishers fitted with a dust suction hood.

Mirka's film-backed, multihole Galaxy abrasive produces excellent results, especially on hard surfaces. Its precision coating repels dust, meaning that it does not clog, and its grits stay sharp for longer.



Abranet® Ace HD



Galaxy

TOOLS AND ACCESSORIES



Mirka® DEROS II 680



Mirka® ROS2 610CV



Mirka® DEXOS 1217/1230 M AFC



Mirka® POLAROS RP 600 polisher



Mirka® LEROS-S 950

Marine

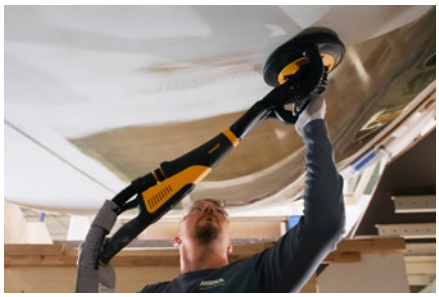
Sanding Below Waterline Process



Mirka® LEROS-S 950
225 mm, orbit 5.0

SANDING







STEP 1

- Take a 225 mm Galaxy 120 grit abrasive and attach it to your LEROS-S 950 sander.

STEP 2

- Sand with the LEROS-S over the whole surface. The LEROS-S with its 2 grip points gives you full control over the sanding process.

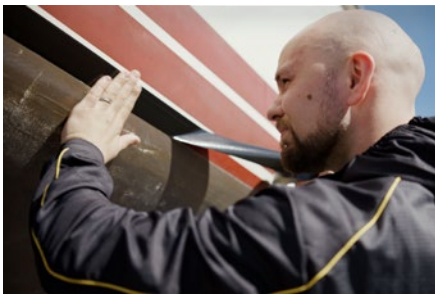
STEP 3

- If you need more reach the LEROS-S can also be fitted with an extension.
- Clean the sanded area.

Sanding & Polishing of Painted Surfaces



ANTIFOULING PROCESS







STEP 1

- Protect the gelcoat waterline with the strong protection tape from Mirka

STEP 2

- Sand the surface with Abranet® Ace HD P80, to remove the coating. Use a net interface to better follow the shape of the hull. Avoid sanding too deep.

STEP 3

- Continue to sand with Abranet® Ace P120 to reduce scratches and to prepare for the primer.



STEP 4

- Rinse the surface with water and let dry.
- It is important to seal the sanded hull with a primer to create a stronger water barrier and to give a better adhesion for the new coating of antifouling.
- Remember to follow the instructions from the chosen antifouling manufacturer.

The choice of the tool depends on the surface: DEROS II 8mm orbit for smaller surfaces and precision, LEROS-S 950 for larger surfaces, and DEOS II 383 for straight lines. Use a combination of all of them, for best results.



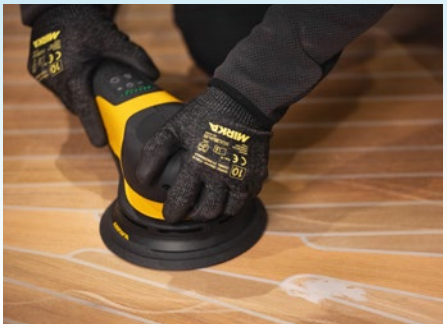
TEAK DECK



TEAK DECK

When working on teak decks, a dust-free working environment is vital. Wood dust exposure is particularly harmful to the lungs. Use Mirka's dust-free sanding solutions, which combine pioneering net abrasives with ergonomic tools and effective dust extractors.

TEAK SANDING PROCESS



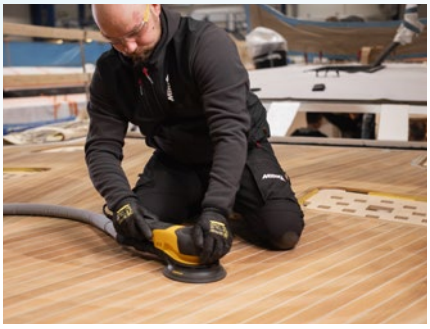
STEP 1

- Attach the Mirka® Galaxy 60 grit to the Mirka® DEROS RS 600.
- Sand the area to level the surface.



STEP 2

- Switch to Galaxy 80 grit and continue sanding to reduce scratches.



STEP 3

- Finish sanding with Galaxy 120 grit for a smooth, even surface. You can use either the DEROS II or DEROS RS for this final step.



Abranet® Ace HD – developed for challenging applications. Thanks to the optimised net construction and ceramic grains, Abranet Ace HD offers a superior cut and performance.



Galaxy – an abrasive designed for aggressive and challenging applications. The long-lasting film-backed disc offers excellent edge wear resistance and flatness.



Ultimax® Ligno – Combining fast cut with long life, thanks to especially good resistance to clogging when sanding substrates. Self-sharpening ceramic grains for extra durability.

TOOLS & ACCESSORIES



Mirka® DEROS II 680CV
150 mm / 8 mm orbit



Mirka® DEROS RS 600
150 mm

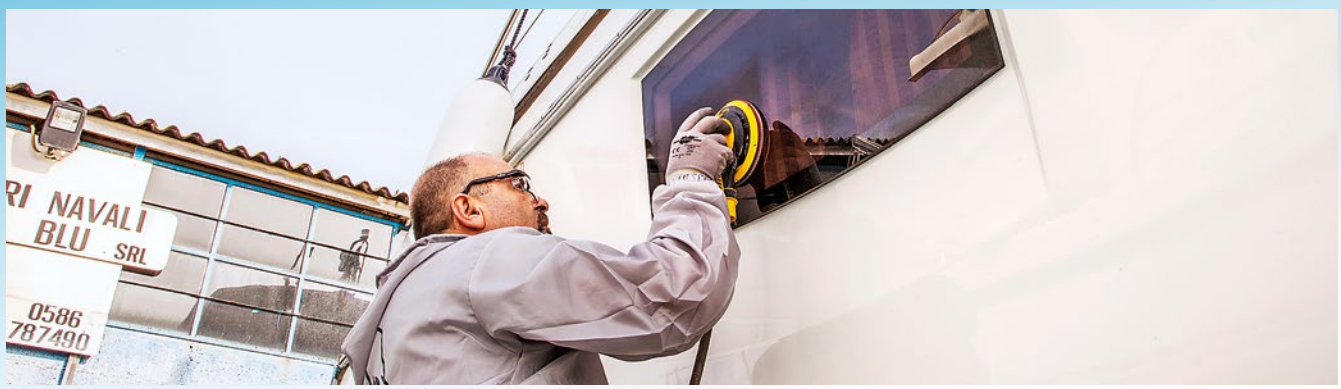


Dust extraction hose
with integrated cable



Mirka® DEXOS 1217/1230 M AFC
M-class dust extractor

RESTORING **GLASS & ACRYLIC**



Scratches and minor imperfections can accumulate on glass windows and acrylic glass. Instead of replacing the entire piece, why not restore it: marks can be easily removed with Mirka products by sanding and polishing. Based on how deep the scratches are and the quality of the material, Mirka has various solutions to produce excellent results. A rule of thumb is: If there are deep scratches start with Abranet (P500-P800), then continue with Abralon (P1000-P3000). Small defects can be treated with only Abralon (P1000-P3000).

1. PRODUCTS FOR GLASS SURFACES

ABRASIVES



Abranet® SIC NS

Multifunctional net abrasive without stearate, developed mainly for glass sanding. High performance and a long lifespan makes it a cost-effective solution. Coated with silicon carbide grains.



Abralon®

Unique, multifunctional abrasive developed for tackling both smooth and profiled surfaces. Patented, flexible construction. Developed especially for pre-treating and finishing surfaces prior to polishing.

TOOLS



POLAROS® RP 600

POLISHING COMPOUND



Polarshine® E3

PADS



Looped wool pad

Felt pad

2. PRODUCTS FOR ACRYLIC / POLYCARBONATE SUBSTRATES

ABRASIVES



Abranet® Ace

Abranet® Ace – offers superior cut and performance for more demanding sanding applications, with an optimised net construction and ceramic grains.



Abralon®

Abralon® – Developed especially for pre-treating and finishing surfaces prior to polishing.

TOOLS



Mirka® DEROS II 650

Developed for effective and dust-free sanding of all kind of surfaces. Brushless motor maintains constant speed even under heavy load. Lowest vibration values in its class. Unique symmetrical design.



Mirka® POLAROS RP 600

A corded 150 mm rotary polisher for professional use. With a 750 W brushless motor and a variable speed of 700–2,500 rpm, the POLAROS offers a perfect blend of power, precision, and ease of use. Despite its power, it operates quietly, with a noise level of only 58 dB.



Mirka® DEROS RS 600

An ergonomic rotary sander built for heavy-duty and general-purpose sanding. It handles tough materials in demanding jobs. Powered by a durable 750 W brushless motor. Selectable slow start and an adjustable speed range of 750–2500 rpm. Lightweight and smooth-running with low noise.

POLISHING COMPOUND



Polarshine® Marine Medium



Polarshine® Marine Fine

PADS



Lambswool pad PRO



Yellow waffle foam

Marine Glass Maintenance
– Scratch Conditioning



Mirka® DEROS RS 600
Sander, 150 mm



Mirka® POLAROS RP 600
Polisher, 150 mm

SANDING & POLISHING



BEFORE SANDING

- Clean the glass and analyse the scratches
- Use suitable grit size of Abralon® to remove scratches
- Sand in shorter sequences to keep the surfaces temperature down and avoid cracking the glass.



STEP 1

- Use Abralon® 360 with Mirka® DEROS RS 600
- Use a low RPM throughout the process



STEP 2

- Wipe the surface clean with Mirka Cleaning Cloth Micro Fiber and water
- Change to Abralon® 500 grit abrasive to reduce sanding marks



STEP 3

- Wipe the surface clean and continue with Abralon® 600 grit
- Finish the sanding with Abralon® 1000 grit.
- Clean sanded area with water and Mirka Cleaning Cloth Micro Fiber



STEP 4

- Move on to the polishing process. Polish the surface with Polarshine® E3 together with Mirka® POLAROS RP 600 and a Looped Wool Pad in shorter sequences until the glass is perfect clear. 1300-1500 rpm.



STEP 5

- Clean area with water and Mirka Cleaning Cloth Micro Fiber



Abralon 125 mm, Grit 360



Abralon 125 mm, Grit 500



Abralon 125 mm, Grit 600



Abralon 125 mm, Grit 1000



Polarshine E3 + Looped wool pad and Cleaning Cloth Micro Fiber

STEP 1	STEP 2	STEP 3	STEP 4	STEP 5
Scratch removal	Scratch conditioning			Polishing

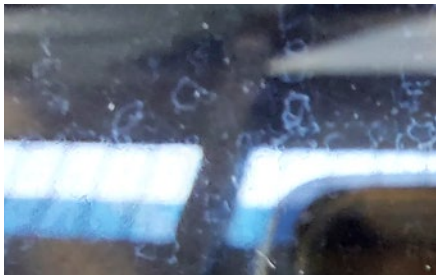
NOTE! By using all recommended sanding steps you will achieve the best possible result after polishing.

Marine Glass Cleaning
– Ghosting Process



Mirka® POLAROS RP 600
Polisher, 150 mm

POLISHING



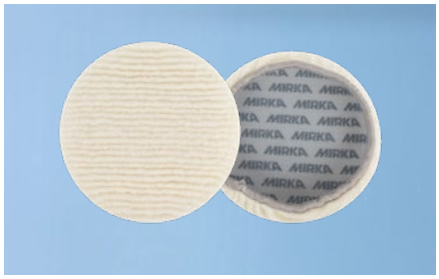
PREPARATION

- Analyse and clean the glass
- Use proper protective gear



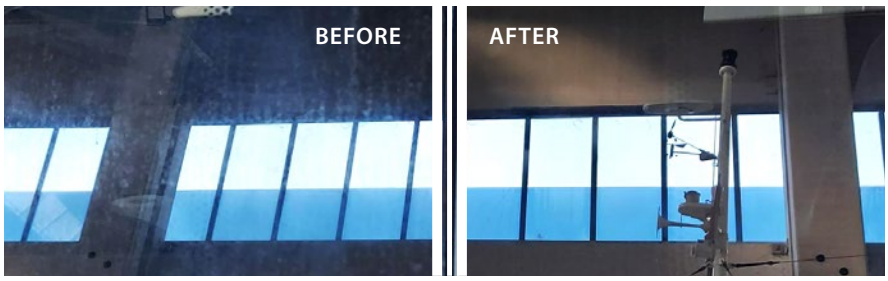
STEP 1

- Start polishing with Mirka **Felt Pad** together with **Mirka® POLAROS RP 600** and **Polarshine® E3** to get rid of the ghosting and/or light scratches. (Felt Pad = heavy cut). 1300-1500 rpm.



STEP 2

- Switch to Looped wool pad and continue polishing until wanted surface finish is achieved. (Looped wool pad = medium cut / high gloss)



RESULT

- Let your results speak for themselves.



Cleaning Cloth
Micro Fiber Yellow



Mirka felt pad
+ Polarshine E3



Polarshine E3
+ Looped wool pad, 150 mm



PREPARATION	STEP 1	STEP 2
Analyse and Clean	Buffing	Polishing

SOLID SURFACE PROCESS

Solid surfaces, such as composite, DuPont Corian and other combined materials can be sanded and polished using the Mirka process. The recommended process produces an optimal finish when carried out with the right abrasives, polishes, tools and accessories.

MATTE FINISH

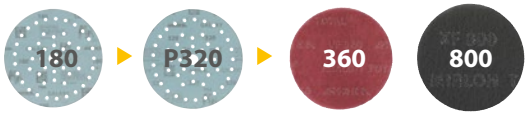
Use the following Galaxy grit sizes and finish with Mirlon® Total VF.





SATIN FINISH

Use the following Galaxy grit sizes and finish with Mirlon® Total VF and Mirlon® Total XF (use a net interface with Mirlon).





Use a net interface with Mirlon



GLOSSY FINISH

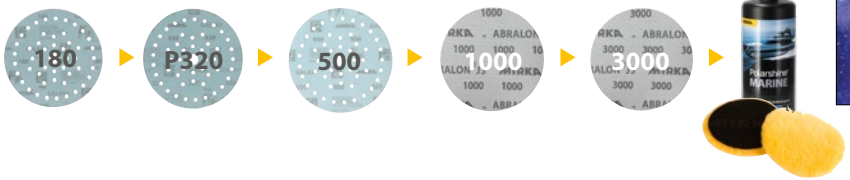
Use the following Galaxy grit sizes and finish with Abralon® J3.





HIGH GLOSS FINISH

Use the following Galaxy grit sizes and continue with Abralon® J3 discs. Finish with a polisher and Polarshine Marine Fine compound + Lambswool pad PRO.





MIRKA COMPLETE SANDING SYSTEM



Galaxy, Mirlon® Total VF & Abralon® J3 discs



Mirka® DEROS II 650



Hose with cable 4 m

Mirka® DEXOS 1217 M AFC
M-class dust extractor



MIRKA COMPLETE POLISHING SYSTEM



Mirka® POLAROS RP 600 polisher 150 mm



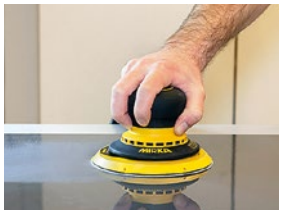
Lambswool pad PRO 150 mm

INTERIOR HIGH GLOSS PROCESS

SINGLE COMPOUND POLISHING PROCESS – POLARSHINE® MARINE FINE

Comprehensive solutions: With Mirka products you can achieve high-gloss end results in indoor spaces with a one or two compound polishing process.

Defect removal







Remove defects:
sand with Microstar® P800/P1200.
Sand with medium speed, 7,000–8,000 rpm.



Reduce scratches:
use Abralon® 3000 damp sanding. Sand with low speed, 6,000 rpm.

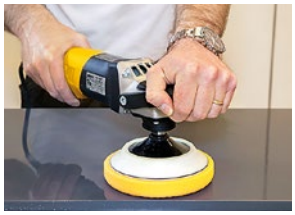
Compounding





Use Polarshine® Marine Fine compound and Mirka Lambswool PRO pad.

Polish / Finish

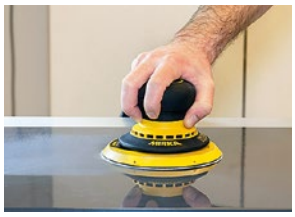




Use Polarshine® Marine Fine compound and Mirka Yellow Waffle pad. Wipe and do final cleaning with soft Mirka Cleaning Cloth Micro Fiber.

2 COMPOUND POLISHING PROCESS – POLARSHINE® MARINE MEDIUM CUT + POLARSHINE® MARINE FINE

Defect removal





Remove defects:
sand with Microstar® P800/P1200.
Sand with medium speed, 7,000–8,000 rpm.

Compounding





Use Polarshine® Marine Medium Cut compound and Twisted lambswool pad.

Polish / Finish





Use Polarshine® Marine Fine compound and Mirka Yellow waffle foam pad to remove swirls and holograms. Wipe and do final cleaning with soft Cleaning Cloth Micro Fiber.

Note. For best result, use the right combination of compound/pad and Soft edge backing pad:



Backing pad 135 mm, M14 soft

Code: 8297902011

CONDITIONING OF **GEL COAT**

Composite materials, such as fibre glass with an exterior layer of gelcoat are used in manufacturing of boats and yachts. The gelcoat surfaces are made to be long-lasting, with resistance to UV damage and hydrolysis. And it's not just about how the surface looks when it's maintained. Preventing cracks or refinishing a cracked gelcoat surface will also protect the yacht or boat from salt, filth, mould, and excessive moisture. Gel coated surfaces are easy to restore to top condition with the help of Mirka solutions.





POLISHING / CLEANING

USE:

- Polarshine® Marine Medium Cut compound + Lambswool Pad PRO

OR

- Polarshine® Marine Heavy Cut polishing compound + Twisted wool pad



HOLOGRAM REMOVAL

USE:

- Polarshine® Marine Fine compound + Waffled polishing foam pad



SURFACE PROTECTION

USE:

- Polarshine® Marine Shield



TOOLS AND ACCESSORIES



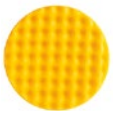
Mirka® DEROS II 650



Mirka® POLAROS RP 600 polisher



Twisted lambs-wool pad



Yellow waffle foam pad



Lambswool pad PRO



Yellow Micro Fiber Cleaning Cloth

Polarshine® Marine Medium Cut
is a polishing compound for top- and clear coats. Quick removal of oxidation and sanding scratches.

Surface protection:
Polarshine® Marine Shield



RESTORING **BOAT SURFACES**

RESTORING BOAT SURFACES, THE MIRKA WAY. FROM DEEP CLEANING TO APPLYING A COATING.

Cleaning stages





Polarshine® Marine Deep Clean

The product contains oxalic acid, which is perfect for removing organic dirt. Spray onto the surface you are going to be cleaning and leave to work for 5–10 minutes. Rub with a brush or sponge and rinse thoroughly with water. Always remember to neutralise with Polarshine Marine Wash.





Polarshine® Marine Boat Wash

Start by spreading the product from the bottom upwards and leave to work for around 1–5 minutes.

If necessary, use a sponge or brush on stubborn dirt.

Rinse



Remember to rinse thoroughly after every stage.

Sand



If surface is heavily worn, carry out wet sanding using the Mirka method.

POLISH AND COAT

Polish



Make sure the surface is dry before you start polishing.

Polarshine Marine Fine compound and a Lambswool pad PRO are recommended for light-colored & white surfaces.

For dark-colored surfaces we recommend Polarshine 12 Black and a Polishing Foam Pad Black M Waffle.

900–1100 rpm

Final Finish





Use Polarshine Marine Final Finish to remove any leftover traces of polishing compound.

Coat



The surface should also be moist from washing. Spray Polarshine Marine Shield directly onto the area to be coated or a Mirka sponge.



Go over all areas to be treated thoroughly. Rinse off the treated surface with water and finish by drying.

Note.
Avoid contact with surfaces treated with anti-fouling paint. The product may react strongly on surfaces treated with anti-fouling paint, depending on the composition used by the paint manufacturer. Never spread the coating on glass or other reflective surfaces.

Polarshine Marine Shield must not be spread on surfaces that are over +25 °C. Never allow the product to dry completely on the surface being coated – rinse thoroughly before hardening. Please note that the sun and wind will affect the drying time of the coating.

Watch the whole video on mirka.com or our youtube channel



FROM CLEANING **TO FINISHING**

Mirka's Polarshine® Marine range features everything you need to keep your boat in top condition, from cleaning compounds to finishing and long-lasting coatings. Alongside its sanding and Polarshine polishing compounds, Mirka offers a complete solution to ensure the surface of your boat stays like new from one boating season to the next.

CLEANING PRODUCTS

POLARSHINE® MARINE DEEP CLEAN



Deep cleaning solution concentrate

Polarshine Marine Deep Clean is a highly effective, oxalic-acid-based, deep cleaning concentrate for cleaning of the boat's scum line and hull. The product's gel-like consistency, and combination of surfactants and oxalic acid dissolve any yellowing and stubborn dirt highly efficiently. Excellent for use on organic dirt. After using Deep Clean, remember to always neutralise the surface with a product such as Boat Wash.

POLARSHINE® MARINE BOAT WASH



Boat shampoo

Polarshine Marine Boat Wash is a top quality boat shampoo containing brightening wax and is suitable for use on all surfaces washable with water, such as aluminium, gel coatings, varnish, paint, wood, steering top covers, canopies and metal surfaces. The product's highly efficient surfactant formulation removes stubborn dirt such as grease, oil, soot, spilt fuel, salt residue, etc. gently from all surfaces.



FINISHING AND COATING

POLARSHINE® MARINE FINAL FINISH



Cleaning and finishing compound

Polarshine Marine Final Finish is a high-quality, silicone-free cleaning and finishing compound for all boat surfaces. It works as a powerful cleaning agent to remove polishing paste, finger prints, sooty smudges and other impurities.

POLARSHINE® MARINE SHIELD



Heavy-duty ceramic coating

A heavy-duty ceramic coating containing gloss polymers and offering lasting protection for gel coat, paint, aluminium, steel, plastic and varnish surfaces. Protect your surface from UV radiation, salt water, oxidation, bird droppings, and other impurities. Polarshine Marine Shield coating powerfully repels impurities and can withstand strong detergents, making it easier to carry out a thorough clean at the end of the boating season. The product's surfactant components prevent droplets of water from adhering to the surface of the boat by creating a hydrophobic and high-gloss finish that is particularly hard-wearing.

Sustainability at Mirka

We proactively look for ways to **reduce the environmental footprint of our products**. We do not use chemicals on the List of Substances of Very High Concern (SVHC) and are in full compliance with the EU's Registration, Evaluation, Authorisation and Restriction of Chemicals legislation (REACH). Below are some of the other advancements we are making.

- **Developing new low-energy technologies.** This decreases the amount of energy needed to manufacture our coated abrasives.
- **Switching to a non-heavy metal colouring agent.** This reduces the amount of heavy metal in our products.
- **Improving the handling and processing of waste resin.** This ensures better health and safety for our workforce and decreases the chance of disposal hazards.
- **Innovating new catalyst technology.** This makes our thermal machine lines more efficient, reducing the energy consumption needed to make our products.
- **Designing efficient product transport routes.** This reduces our carbon footprint.



Read more: mirka.com/sustainability







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China Mirka Trading Shanghai Co., Ltd
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Germany Mirka GmbH, Mirka Abrasives Germany GmbH
India Mirka India Pvt Ltd
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Mexico Mirka Mexicana S.A. de C.V.
Netherlands Mirka Benelux B.V.
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