

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 smoothing 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.

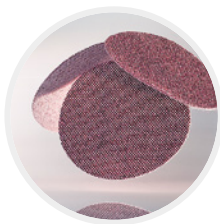
Choose the best abrasive for the job at hand: **Galaxy** film offers outstanding performance on hard gel coats, whilst **Microstar** is designed especially for matting surfaces. If you are familiar with using foam-backed abrasives, **Abralon J3** is a great choice for finishing prior to polishing. The 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

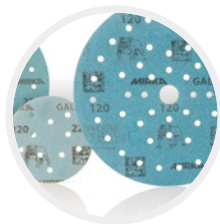
Abranet® Ace HD – resists high wear and tear and is ideal for heavy-duty applications.



Galaxy

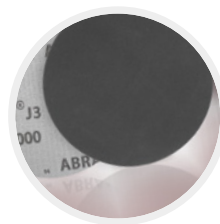
Galaxy – aggressive initial cut for heavy duty applications in coarser grits. Long lasting film-backed disc with excellent edge wear resistance and flatness.

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® 10 – 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 650CV / 680CV



Mirka® DEOS 383CV



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)

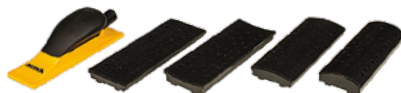


Hose 27 mm x 10 m
(10 m CE 230 V with sleeve
+ integrated cable)

HAND SANDING BLOCKS



File Board 70 x 400 mm
hard / flexible



Sanding block 70 x 198 mm

DUST EXTRACTION



Mirka® Dust Extractor 1025 L/1125 L, 1230/1242 M

Marine

Mould gel coat sanding process



Mirka® DEROS 650CV
150 mm, orbit 5 mm

SANDING



STEP 1

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

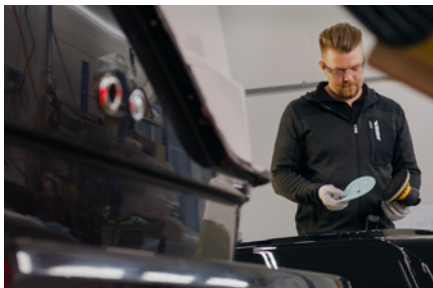


STEP 2

- 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.



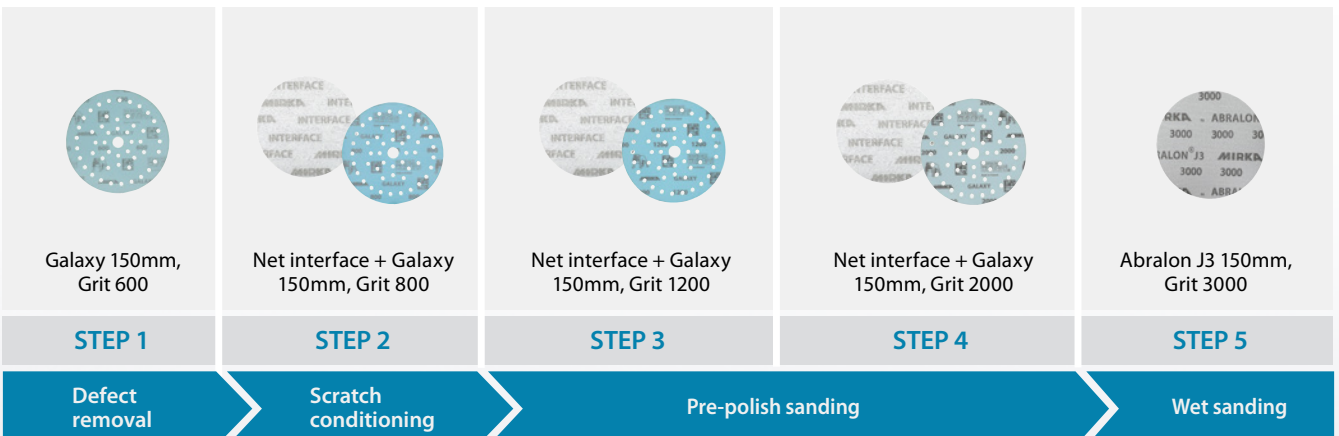
STEP 4

- Use Galaxy 2000 grit together with a Net Interface.



STEP 5

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



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



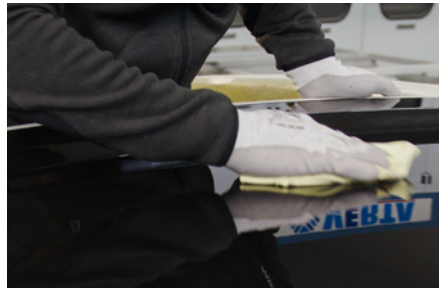
Mirka® PS1437
Polisher, 150 mm

POLISHING



STEP 1

- Use Polarshine® 45 and a Lambswool pad Pro together with Mirka® PS 1437 Polisher.
- Polish the surface to eliminate sanding scratches.
- Wipe off any excess polishing compound between the polishing steps.



STEP 2 (recommended for dark colours)

STEP 2 (recommended for light colours)

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



Polarshine® 45 Polishing compound and Lambswool pad Pro



Polarshine® 12 Black with a Black waffle M foam pad



Polarshine® 12 and a Waffled polishing foam pad



Micro Fiber Cleaning Cloth

STEP 1

Scratch removal

STEP 2

Final polishing (for dark colours)

STEP 2

Final polishing (for light colours)

STEP 3

Cleaning

MIRKA

Let our path be illuminated with

Dedicated to the Finish.

Traveling beyond limits, guided



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



PRODUCTION **GEL COAT**

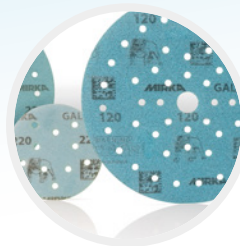
It is easy to condition a gelcoat finish with Mirka solutions. To get the perfect lustre and shine of a gelcoat surface on a newly manufactured yacht or boat, the crucial component is the exterior layer of the gelcoat. For yachts, the gelcoat surfaces are made to be long-lasting, to be able to resist 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® 45

Polarshine® 45 is a very coarse polishing compound ideal for marine and industrial gelcoats.



Polarshine® 35

Polarshine® 35 is a coarse polishing compound developed for demanding Marine applications.



Polarshine® 12

Polarshine® 12 is a medium coarse compound which leaves a high gloss finish.



Polarshine® 12 Black

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® PS 1437
polisher 150 mm



Mirka DEROS 350CV
Sander 77 mm



Mirka DEROS 650CV
Sander 150 mm

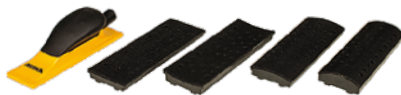


Mirka® LEROS-S 950CV
Sander 225 mm

TOOLS



File Board 70 x 400 mm
hard / flexible



Sanding block 70 x 198 mm



Mirka® Dust Extractor
1230 L AFC



Mirka® Dust Extractor
1242 M AFC

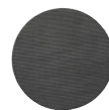
ACCESSORIES



Long file boards
3 different versions, 2 different
lengths, for One or Two Operators.
115 x 680 mm rigid
115 x 1600 mm rigid
115 x 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
Yellow Micro Fiber Cleaning Cloth
400 x 400 mm / 5-pack

Marine

Production gel coat sanding process



Mirka® DEROS 650CV
150 mm, orbit 5 mm

SANDING



STEP 1

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



STEP 2

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



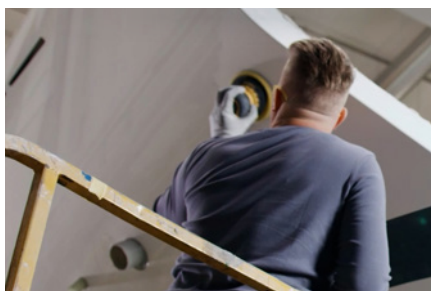
STEP 3

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



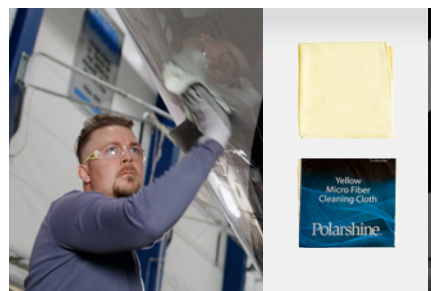
STEP 4

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



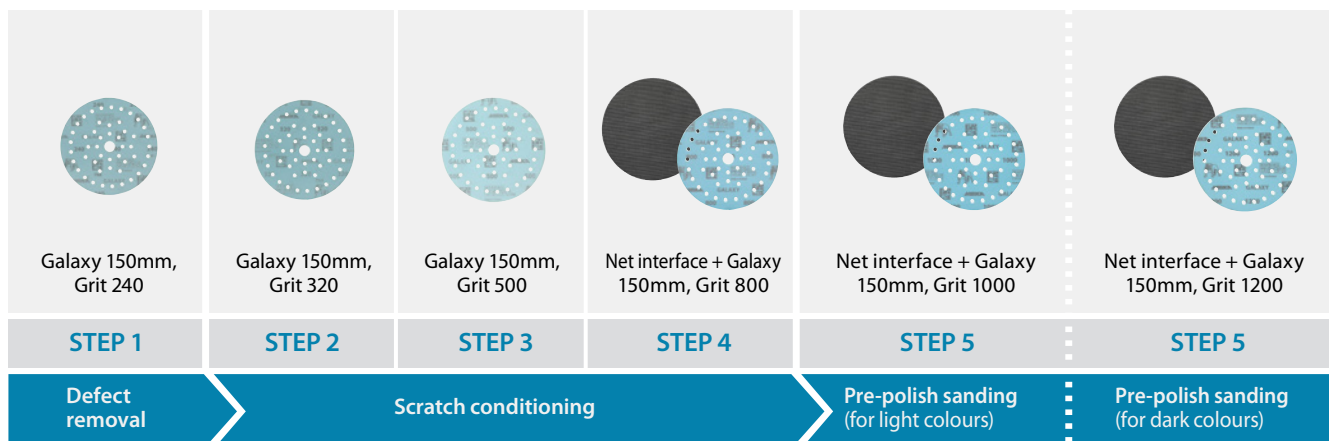
STEP 5

- Finish the sanding with Mirka® Galaxy 1000 grit together with Net interface. (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® PS1437
Polisher, 150 mm

POLISHING



STEP 1

- Start by attaching the Twisted wool pad to the Mirka® PS 1437 polisher tool.
- Apply Polarshine® 45 polishing compound to the Twisted wool pad. Start polishing.



STEP 2 (recommended for dark colours)

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

STEP 2 (recommended for light colours)

- Attach a Waffled polishing foam pad and apply *Polarshine 12* to the pad.
- Polish the surface

STEP 3

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

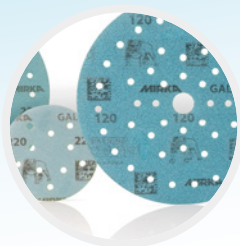




TOP- AND CLEAR COAT

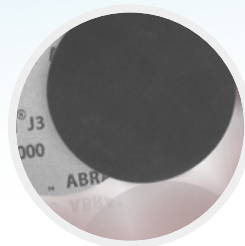
It takes time, effort, and knowledge to build and maintain the perfect yacht or boat. At the manufacturing stage, Mirka's marine solutions can make the surface finishing processes more efficient and with a better end result. The quality of the surface finish and coating can be taken to the next level 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.



Abralon® J3

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

POLISHING COMPOUNDS



Polarshine® 35

Polarshine® 35 is a coarse polishing compound developed for demanding Marine applications.



Polarshine® 12

Polarshine® 12 is a medium coarse compound which leaves a high gloss finish.



Polarshine® 12 Black

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

PADS



Lamswool pad PRO

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



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® PS 1437
polisher 150 mm



Mirka DEROS 650CV
Sander 150 mm



Mirka® LEROS-S 950CV
225 mm, orbit 5.0

DUST EXTRACTORS



Mirka® Dust Extractor
1230 L AFC



Mirka® Dust Extractor
1242 M 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



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

Marine

Top- and clear coat process

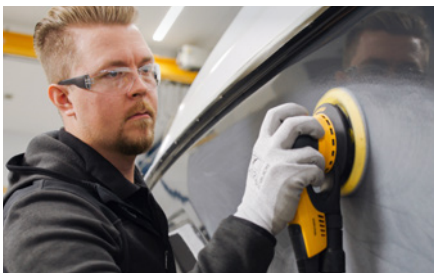


Mirka® DEROS 650CV
150 mm, orbit 5 mm



Mirka® PS1437
Polisher, 150 mm

SANDING



STEP 1

- Start sanding with Mirka® DEROS 650CV 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 sanding with Galaxy 2000 grit



STEP 3

- Continue wet sanding with Abralon® J3 3000 grit.



POLISHING



STEP 1

- Polish the surface with Polarshine® 35 and a Lambswool Pad PRO together with Mirka® PS 1437 Polisher to eliminate sanding scratches.

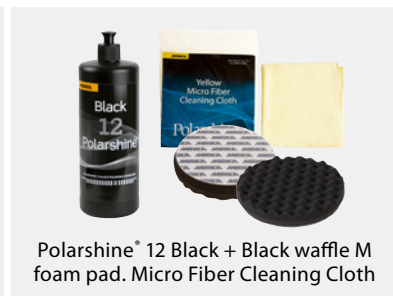
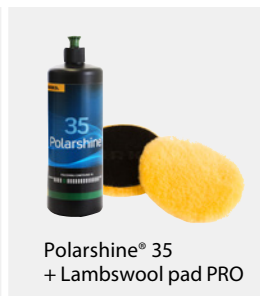
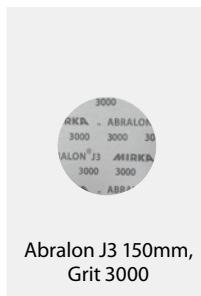
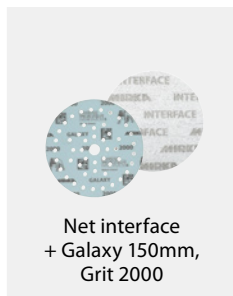
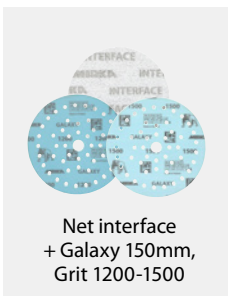


STEP 2

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



- Wipe off any excess polishing compound.



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® 12

Polarshine® 12 is a medium coarse compound which leaves a 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® PS 1437 polisher 150 mm

The Mirka® PS 1437 Polisher features a powerful, high torque electric motor. The rotational speed can be pre-selected and precision adjusted with a step-less switch. The bail handle and a side handle ensure a better grip and a spindle lock makes pad changes easy.

It's an excellent tool for polishing smaller surfaces and is designed to be used with a maximum 150 mm pad.

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



Yellow Micro Fiber Cleaning Cloth

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 Yellow Micro Fiber Cleaning Cloth.



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 Yellow Micro Fiber Cleaning Cloth.



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

<p>Mirka® AOS-B 130NV, Mirka Iridium™ SR3 & SR5 (Soft edge backing pad)</p>	<p>Mirka finessing water damper, 60 ml</p>	<p>Yellow Micro Fiber Cleaning Cloth</p>	<p>Mirka AROP-B 312NV, Lambswool pad PRO and Polarshine® 12</p>	<p>Mirka® AROP-B 312NV + Lambswool pad PRO and Polarshine® 12 + Black waffle M foam pad & Yellow Micro Fiber Cleaning Cloth</p>	
STEP 1		STEP 2		STEP 3	
STEP 1		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 680CV



Mirka® ROS2 610CV



Mirka® Dust Extractor 1242 M AFC



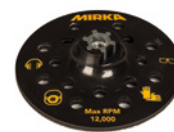
Mirka® Leros-S 950CV



Mirka® PS 1437 polisher



Dust suction hood for PS1437 polisher



With backing pad 125 mm M14 Grip 17R for dust extraction tools

Marine

Sanding below waterline process

SANDING



Mirka® LEROS-S 950CV
225 mm, orbit 5.0



STEP 1

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

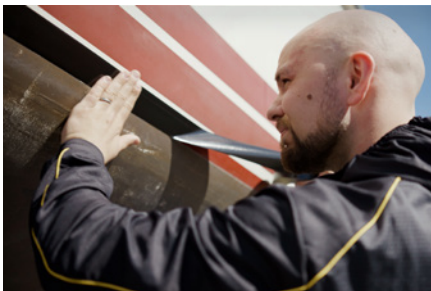


STEP 3

- 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 8mm orbit for smaller surfaces and precision, LEROS-S 950CV for larger surfaces, and DEOS 383CV for straight lines. Use a combination of all of them, for best results.



TEAK DECK MAINTENANCE



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.

Based on the condition of the teak deck and the seriousness of the damage, we recommend using Abranet Ace or Mirka Galaxy abrasives, which offer grit ranges of P80–P120–P180.



Abranet® Ace – developed for challenging applications. Thanks to the optimised net construction and ceramic grains, Abranet Ace 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.



TOOLS & ACCESSORIES



Mirka® DEROS 680CV



Dust extraction hose with integrated cable



Mirka® Dust Extractor 1230 L AFC



TEAK DECK MAINTENANCE





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



Mirka® PS 1437

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 650CV

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® PS 1437

Features a powerful, high torque electric motor. Rotational speed can be pre-selected and precision adjusted with a step-less switch. Excellent tool for polishing.

POLISHING COMPOUND



Polarshine® 10



Polarshine® 35

PADS



Lambswool pad PRO



Yellow waffle foam



Mirka® PS1437
Polisher, 150 mm

Marine

Glass maintenance – scratch conditioning

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.



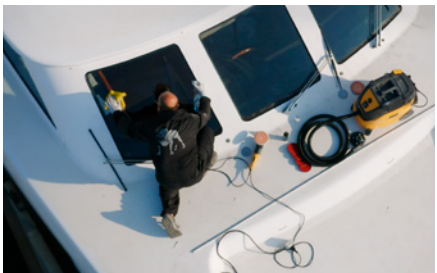
STEP 1

- Use Abralon® 360 with Mirka® PS1437 rotary polisher
- Remember to attach the dust suction hood to the PS1437 together with the hard backing pad.
- Use low RPM on polisher throughout the process



STEP 2

- Wipe the surface clean with Mirka micro fiber cleaning cloth and water
- Change to Abralon® 500 grit abrasive to reduce sanding marks



STEP 3

- Wipe the surface clean and continue with Abralon® 600 grit



STEP 4

- Finish the sanding with Abralon® 1000 grit.
- Clean sanded area with water & Micro Fiber Cleaning Cloth
- Move on to the polishing process



STEP 5

- Polish surface with Polarshine® E3 and a Looped wool pad in shorter sequences until the glass is perfect clear.

<p>Dust suction hood + Backing pad + Abralon 125 mm, Grit 360</p>	<p>Abralon 125 mm, Grit 500</p>	<p>Abralon 125 mm, Grit 600</p>	<p>Abralon 125 mm, Grit 1000</p>	<p>Polarshine E3 + Looped wool pad and Micro Fiber Cleaning Cloth</p>
<p>STEP 1</p>	<p>STEP 2</p>	<p>STEP 3</p>	<p>STEP 4</p>	<p>STEP 5</p>
<p>Scratch removal</p>		<p>Scratch conditioning</p>		<p>Polishing</p>

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

Marine

Glass cleaning – ghosting process



Mirka® PS1437
Polisher, 150 mm

POLISHING



PREPARATION

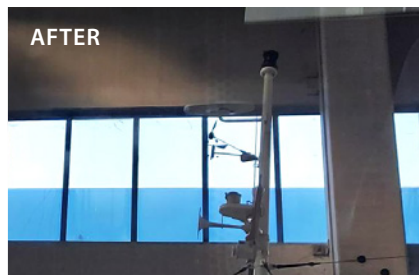
- Analyse and clean the glass
- Use proper protective gear

STEP 1

- Start polishing with Mirka felt pad together with Polarshine E3 to get rid of the ghosting and / or light scratches. (Felt pad = heavy cut)

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.

<p>Micro Fiber Cleaning Cloth</p>	<p>125mm hard backing pad, M14 + Mirka felt pad + Polarshine E3</p>	<p>Polarshine E3 + Looped wool pad, 150mm</p>	
<p>PREPARATION</p>	<p>STEP 1</p>	<p>STEP 2</p>	
<p>Analyse and Clean</p>	<p>Buffing</p>	<p>Polishing</p>	

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



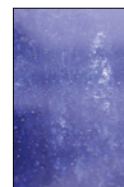
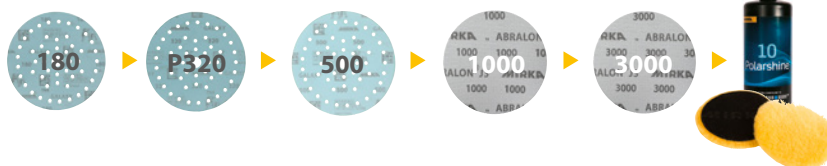
GLOSSY FINISH

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 10 + lambswool pad PRO.



Galaxy, Mirlon® Total VF & Abralon® J3 discs



Mirka® DEROS 650CV



Hose with cable 4 m

Mirka® Dust Extractor 1230 L AFC



Mirka® PS 1437 polisher 150 mm



Lambswool pad PRO 150 mm

INTERIOR HIGH GLOSS PROCESS

▾ SINGLE COMPOUND POLISHING PROCESS – POLARSHINE® 10

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		Compounding	Polish / Finish
<p>Remove defects: sand with Microstar® P800/P1200. Sand with medium speed, 7,000–8,000 rpm.</p>	<p>Reduce scratches: use Abralon® 3000 damp sanding. Sand with low speed, 6,000 rpm.</p>	<p>Use Polarshine® 10 and Mirka Lambswool Pro pad.</p>	<p>Use Polarshine® 10 and Mirka Yellow Waffle pad. Wipe and do final cleaning with soft Mirka Micro Fiber Cleaning Cloth.</p>

▾ 2 COMPOUND POLISHING PROCESS – POLARSHINE® 35 + 10

Defect removal	Compounding	Polish / Finish	
			<p>Note. For best result, use the right combination of compound/pad and Soft edge backing pad:</p> <p>Backing pad 135 mm, M14 soft Code: 8297902011</p>
<p>Remove defects: sand with Microstar® P800/P1200. Sand with medium speed, 7,000–8,000 rpm.</p>	<p>Use Polarshine® 35 and Twisted lambswool pad.</p>	<p>Use Polarshine® 10 and Mirka Yellow Waffle foam pad to remove swirls and holograms. Wipe and do final cleaning with soft Micro Fiber Cleaning Cloth.</p>	

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.



USE:

- Polarshine® 35 + Lambswool Pad PRO
- OR
- Polarshine® 45 + Twisted Wool Pad



USE:

- Polarshine® 10 + Lambswool Pad PRO



USE:

- Polarshine® Marine Shield

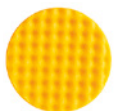
TOOLS AND ACCESSORIES



Mirka® DEROS 650CV



Mirka® PS 1437 polisher



Yellow waffle foam pad



Lambswool pad PRO



Yellow Micro Fiber Cleaning Cloth

Polarshine® 10 – medium coarse polishing compound producing a high-gloss finish.

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 10 and a Lambs-wool 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

Polarshine® MARINE

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







Mirka Ltd
Finland

Brazil Mirka Brasil Ltda.

Belgium Mirka Belgium Logistics NV

Canada Mirka Canada Inc.

China Mirka Trading Shanghai Co., Ltd

Finland & Baltics Mirka Ltd

France Mirka France Sarl

Germany Mirka GmbH

India Mirka India Pvt Ltd

Italy Mirka Italia s.r.l., Mirka Superabrasives S.p.A

Mexico Mirka Mexicana S.A. de C.V.

Netherlands Mirka Benelux B.V

Poland Mirka Poland Sp. z o.o

Singapore Mirka Asia Pacific Pte Ltd

Spain KWH Mirka Ibérica S.A.U.

Sweden Mirka Scandinavia AB

Turkey Mirka Turkey Zimpara Ltd Şirketi

United Kingdom Mirka (UK) Ltd

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