



Glass Sanding Solution

About Mirka

KWH MIRKA LTD is a family-owned Finnish company and a world leader in abrasives technology innovation. We are offering 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. 95% of our products are exported and sold across the globe through our subsidiaries and importers.

Read more: www.mirka.com



Corporate Responsibility

CONTINUOUS IMPROVEMENT TOWARDS SUSTAINABILITY. Changing conditions inspire us to improve and grow our business. We see that our customers are as interested in sustainability as we are. This is why our product development is focused on innovating the best sustainable products and systems, while continually improving our own environmental performance.

Our business is focused on providing the best surface finishing preparation tools and systems to customers. To be the most sustainable finishing systems provider, we are digging deep down to the core of our company to figure out what it really means to be sustainable. We have accomplished a great deal already and have many more initiatives we will take on in the future.

For people working at Mirka, it has always been clear to not waste financial or material resources – of our own or those

of our customers. We find it is equally clear to preserve the planet's resources. Sustainability is a natural extension of this approach. It means taking the economy, the earth, and people into consideration when we make business decisions – now and for future generations. We are continuously looking for opportunities to reduce our environmental footprint – this aligns with our company values and also cuts costs. We have worked hard to conserve energy and raw materials, reduce waste, increase recycling, and decrease the use of persistent chemicals.

We are developing healthier, safer, and more efficient products and processes so that our customers and employees will benefit. For example, our dust-free sanding systems help protect the lungs of workers while giving a cleaner and better surface finish.



Mirka's Glass Sanding Solution

Mirka's sanding solution for refurbishment of glass can be used within many business areas, e.g.

- Architectural
- Automotive
- Marine

End-user Recommendations

1. Take sufficient time over each sanding step; it is all about giving each step the time it needs.
2. The fewer steps it takes to get the job done, the better. Otherwise there is a risk of optical refraction.
3. The polishing step takes longer than the sanding steps.
4. We do not recommend that this process is used on car front windshields because of the risk of optical refraction.
5. Always use a dust protection mask. Please check local legislation about concentrations known to be hazardous.

Mirka Glass Sanding Process - It Is All About Time

GLASS SANDING AND POLISHING ON TEMPERED OR NORMAL GLASS



Scratched glass.



Always start the process by cleaning the surface using window cleaning liquid. Start sanding with a fine grit, eg. P320, or just polish out the scratch. If the fine grit doesn't sand enough use the next coarser grit. This way you can avoid additional steps when removing the scratches. The following process starts with grit P180. If grit P320 is used, the next step is Abralon 360 followed by Abralon 600 before polishing.



Step 3: Sand with Abralon 360 and Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher. Dry or wet sanding.
Sanding time: Approx. 2–3 minutes. Wipe clean before next sanding step.



Step 4: The "pre-polish step": Sand with Abralon 600 and continue with Abralon 1000 using the Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher. Dry or wet sanding.
Sanding time: Approx. 3–4 minutes for each grit. Wipe clean before polishing.



Step 1: For removal of glass scratches sand with Abranet Sic P180 and Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher. Dry or wet sanding.

Sanding time: Never do a short sanding sequence. Wipe clean before next sanding step.



Step 2: Sand with Abralon 180 and Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher. Dry or wet sanding.

Sanding time: Approx. 2 minutes. Wipe clean before next sanding step.



Step 5: Polish with Polarshine E3 Glass Polishing Compound. Use Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher and Mirka White Polishing Felt Pad. Wipe the surface clean to check the surface. Use a soft microfiber cloth and a window cleaning liquid. Continue polishing for 4 minutes or more.



Completed process.



Mirka Abrasives for Glass Sanding

Abranet® SIC NS 77 mm

Grit	Mirka code
P80	5020305080
P120	5020305012
P150	5020305015
P180	5020305018
P240	5020305025
P320	5020305032
P400	5020305041

Abranet® SIC NS 125 mm

Grit	Mirka code
P80	5023205080
P120	5023205012
P150	5023205015
P180	5023205018
P240	5023205025
P320	5023205032
P400	5023205041

Abranet® SIC NS 150 mm

Grit	Mirka code
P80	5024105080
P120	5024105012
P150	5024105015
P180	5024105018
P240	5024105025
P320	5024105032
P400	5024105041



Abranet® SIC NS

Abranet® SIC NS is a multifunctional net abrasive without stearate, developed mainly for glass sanding, but is also suitable for sanding of other hard surfaces like primers, clear coats and composites. A combination of high performance and a longer lifespan than traditional abrasives gives a cost-effective solution. The bonding is of resin type, and Abranet SiC NS is coated with a dense, uniform layer of silicon carbide grains.



Abralon®

Abralon® is a unique, multifunctional sanding material developed for tackling both smooth and profiled surfaces. Its patented, flexible construction allows it to create a smooth sanding pattern on angled surfaces and edges while minimising the risk of pressure marks. The flexible weave also allows water and air to pass freely, making it suitable for both dry and wet sanding, by machine or by hand.

Abralon® 77 mm

Grit	Mirka code
180	8A20302018
360	8A20302037
500	8A20302051
600	8A20302061
1000	8A20302092

Abralon® 125 mm

Grit	Mirka code
180	8A23202018
360	8A23202037
500	8A23202051
600	8A23202061
1000	8A23202092

Abralon® 150 mm

Grit	Mirka code
180	8A24102018
360	8A24102037
500	8A24102051
600	8A24102061
1000	8A24102092



Mirka Polishing Compounds for Glass Sanding



Polarshine® E3
Glass Polishing
Compound
1 L

Mirka code: 7990310111.



Polarshine® E3
Glass Polishing
Compound
250 ml

Mirka code: 7990302511

Water-based, silicone-free polishing compound designed for polishing out scratches on glass surfaces. Suitable for most glass types and removes marks permanently. Polarshine E3 should be used together with the Mirka felt pad and on a rotary polisher.

Mirka Tools and Accessories for Glass Sanding



Polishing Felt
Pad White, 2/Pack
125x6 mm Grip

Mirka code: 7996012511

77x6 mm Grip

Mirka code: 7996007711

A flat hard 6 mm thick white felt pad, designed for glass polishing applications. The thick felt pad construction has a good balance and feels stable during polishing. The pad is designed to be used in combination with Polarshine E3 polishing compound and that combination provides a good glass sanding process.



Cleaning Cloth
330x330 mm
Yellow, 2/Pack

Mirka code: 7991200111

A yellow soft micro fiber cloth, with a fine texture. Absorbs residue well and is washable.



Mirka® PS 1437
Polisher 150 mm

Mirka code: 8991300111

The Mirka Polisher features a powerful, high-torque electric motor, along with a step-less switch and pre-selection of rotational speed which makes it possible to achieve the precise speed required when polishing. There's also a loop handle and a side handle for better control and a spindle lock to make pad changes easy. It's an excellent tool for polishing smaller surfaces and is designed to be used with a maximum 150 mm pad. To achieve the best results, it's recommended that Mirka polishing compounds, backing pads and polishing pads are used.



Mirka® RP 300NV Non Vacuum Rotary Polisher 77 mm

Mirka code: 8993540311

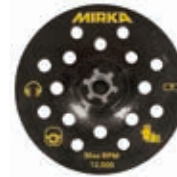
Mirka's pneumatic rotary polisher is a powerful tool that provides a fast way to a perfect finish. The shape allows operators to reach small areas and offers a quick and effective polishing process.



Dust Suction Hood for PS 1437 Polisher

Mirka code: 9190152001

A suction hood that is easily attached to Mirka PS 1437 Polisher without a key, for use in demanding sanding applications. When used with Abranet HD it provides a dust-free solution. The front segment can be removed to improve visibility and give access to edges. The springs ensure smoother operation, while the brushes ensure good suction and protect the surface.



Backing Pad 125 mm M14 Grip 17H for Suction Hood

Mirka code: 9190153001

This 125 mm (5") backing pad is equipped with robust hooks and 17 holes enabling great dust suction. This backing pad should be used together with the Dust Suction Hood (*Mirka code 9190152001*) only.

KWH MIRKA LTD
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Canada Mirka Abrasives Canada Inc.

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For contact information,
please visit **www.mirka.com**

Quality from start to finish

