

**MIRKA**

# Mirka® Marine **Finishing Guide**

STANDARD OPERATING PROCEDURES

THE ORIGINAL DUST-FREE PIONEERS

[mirka.com](http://mirka.com)

v2.1

# Table of Contents

## Product Information

Mirka Mobile Solutions.....	3	Production + Aftermarket Gelcoat Repair.....	12
Mirka Abrasives.....	4	Production + Aftermarket Topcoat Finishing.....	13
Mirka Accessories.....	6	Polyurethane Prepare/Blend Procedure.....	14
Mirka Sanders.....	8	Solid Surface Finishing.....	15
		White Wood Finishing.....	16
		Brightwork Finishing.....	17
		Warranty Policy.....	18
		Grit Comparison Chart.....	19

## Standard Operating Procedures (SOPs)

# Safety Warnings



These symbols are found on all Mirka SOPs, as well as the product packaging for Mirka abrasives. Specific requirements for personal protective equipment (PPE) are presented in many different OSHA standards, published in 29 CFR.



### Eye and Face Protection

Wear appropriate eye and face protection and ensure that the selected form of protection is appropriate to the work being performed and properly fits each worker exposed to the hazard.



### Respiratory Protection

Selecting the right respirator requires an assessment of all the workplace operations, processes or environments that may create a respiratory hazard.



### Gloves

Use gloves specifically designed for the hazards and tasks found in the workplace. The nature of the hazard and the operation involved will affect the selection of gloves.



### Proper Instructions

Read and follow all instructions contained in Technical Data Sheets and User Manuals.



### Hearing Protection

If engineering and work practice controls do not lower employee exposure to workplace noise to acceptable levels, employees must wear appropriate hearing protection.

## User Agreement

The User is responsible for determining whether the Mirka product is fit for a particular purpose and suitable for the User's application. The User is also responsible for complying with any applicable safety and health-related regulations and taking any safety and health-related precautions when using Mirka products. This includes, but is not limited to: wearing safety glasses, face masks, gloves, and protective clothing, if necessary; following instructions and warning labels; and operating Mirka products safely including at safe operating speeds.

By User's purchase or use of Mirka products, User acknowledges, represents, and warrants that User will: (a) comply with the foregoing; (b) assume all risks in connection with the use of Mirka products; and (c) read and understand the Mirka Warranty Policy.

# Mirka Mobile Solutions

\*Abrasives not included with Trolley or Smart Cart\*

## The Mirka Trolley Cart **Part Number: 9190310111**

Specifically designed for outdoor use in marine or industrial yards. Larger back wheels keep the trolley stable on gravel or uneven flooring. The Mirka Trolley allows you to keep your dust extraction system together regardless of where your job takes you.



## The Mirka Smart Cart **Part Number: MAI-CART-912**

The Smart Cart provides a movable platform for the DE-1230-PC dust extractor with integrated storage hooks for vacuum hoses. The system incorporates a locking cabinet for inventory control and a large, 17 $\frac{3}{4}$ " x 27" work surface that is recessed 2" to hold items in place.

Additional storage is available in the two 15 $\frac{3}{4}$ " x 12" x 2 $\frac{3}{4}$ " drawers. These glide freely on roller bearing slides, and have recessed handles to prevent catching on cords or clothing.

**Available in 5" and 6" Electric and Pneumatic systems**

**Don't forget to add Electric and/ or Pneumatic tools, available in both 5" and 6" sizes. Complete your Workstation, Trolley and Smart Cart systems with a variety of abrasives and accessories.**



my Mirka 

## Download the **myMirka® App**

Experience surface finishing in a new way. Mirka's digital solutions are just a click away, thanks to myMirka app you also can measure vibrations and track your daily vibration exposure.

With the services: myTools and myWorkers you can get useful data, Mirka power tools product information as well as stay connected with the operators and their tools in your working environment.

# Experience **Mirka® Abrasives**

We are paving the way for a dust-free sanding experience, Mirka® is a leading specialists in coated and non-woven abrasives. Our extensive abrasive product range caters to both individual operations and complete sanding systems.



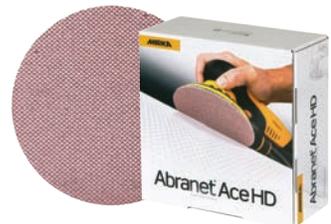
## **Abranet®** GRIT RANGE: P80-P800

- High performance and long lifespan
- Removal of dust particles eliminates loading and pilling problems
- Woven mesh backing works with hook and loop attachment
- Net abrasives are a key component for dust-free sanding



## **Abranet® ACE** GRIT RANGE: P80-P1000

- Developed to achieve outstanding results on challenging surface conditioning and repair applications
- Well designed for metal applications
- Ceramic/ceramic coated grain
- Removal of dust particles eliminates loading and pilling problems
- Improved woven mesh backing offers increased strength and edge wear
- Net abrasives are a key component for dust-free sanding



## **Abranet® ACE HD** GRIT RANGE: P80-P1000

- Ceramic grains allows for maximum cutting speed and consistent performance across a variety of surfaces and substrates
- Coarse grit range makes this ideal for aggressive stock removal
- Features exceptional resistance to edge wear and clogging
- Net abrasives are a key component for dust-free sanding



## **Iridium** GRIT RANGE: 80-600

- Fast sanding and consistent scratch pattern saves you time and money
- Consistent quality and non-stick coating repels dust and provides a long disc life
- Ceramic/aluminum oxide grain
- Effective multi-hole pattern delivers outstanding performance without clogging
- Premium paper backing offers remarkable flexibility and grain adhesion



### **Bulldog Gold** GRIT RANGE: P36-P800

- Designed for both finishing and heavy stock removal
- Aluminum oxide grain delivers a fast, and long lasting cut
- High strength resin bonding provides superior grain support
- Special stearate coating is used to maximize resistance to clogging and loading
- Semi-open coat produces an even, consistent scratch pattern



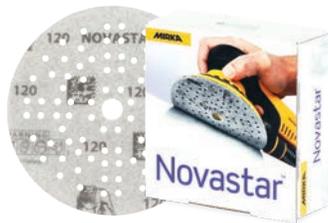
### **Gold Film** GRIT RANGE: P800-P1500

- Designed for fine finishing
- Aluminum oxide grain delivers a fast and long-lasting cut
- High strength resin bonding provides superior grain support
- Special stearate coating is used to maximize resistance to loading
- Semi-open coat produces an even, consistent scratch pattern



### **Course Cut** GRIT RANGE: P40-P150

- Aggressive and fast cutting in coarse grades and is long lasting
- Specially reinforced paper exclusive to Mirka provides superior grain support
- Semi-open coat produces a consistent scratch pattern, while resisting loading



### **Novastar®** GRIT RANGE: 80-180, P240-P600

- Aggressive initial cut in coarse grits for Heavy-Duty applications
- Long lasting disc life means excellent performance using fewer discs
- Consistent scratch pattern provides the desired finish
- Effective multi-hole pattern delivers outstanding performance without clogging
- Premium film backing offers outstanding edgewear resistance, flexibility and grain adhesion
- Ceramic/aluminum oxide grain



### **Microstar® Film-Backed Grip Discs** GRIT RANGE: P800-P2000

- Ideal for removal of runs, dust nibs and excess orange peel from topcoat finishes before repainting or buffing
- Resists loading for longer disc life
- Ideal for sanding fresh or soft clearcoat
- Leaves an even scratch pattern, which buffs out quickly on all types of automotive paints
- Film-backed discs have full resin bonded aluminum oxide grain



### **Abralon®** GRIT RANGE: 360, 500, 1000, 2000, 3000, 4000

- Combines benefits of abrasive cloth and non-woven products
- Constructed of fabric face, foam center and a grip backing
- Abrasive grains are bonded evenly to the fabric face
- Can be used for dry or wet sanding
- Open cell design holds large amounts of water or solvent for lubrication and cooling

(\*Total Only)

### **Mirlon and Mirlon Total® Non-woven** GRIT RANGE: Very, Ultra and Micro Fine\*

- Open design is thinner and more flexible than traditional non-woven pads
- Three-dimensional structure made with cut fiber strands coated with resin and abrasive
- Consistent coating of aluminum oxide (VF 360) and silicon carbide (XF 800, UF 1500, MF 2500) abrasive grains provide uniform, dense scratch pattern
- Very flexible, ideal for use on contoured surfaces



Mirka®

# Accessories

Mirka's polishing compounds will help you achieve a perfect finish in all your polishing processes after sanding with Mirka's unique products. We have the best polishing compound for all paint systems and for polishing scratch-resistant clear coats. Our polishing compounds are cost-effective, safe and easy to use.



## Accessory Tools



ARP300-B



AROP312-B



MR-30



MR-350

Part No.	Size	Orbit	RPM	Pad Face	Weight	Watts	Noise	Vib m/s 2
ARP300-B	3"	0 mm	1,500-2,000	Grip	1.8 lbs	0.28	17	
AROP312-B	3"	12 mm	4,000-7,000	Grip	1.9 lbs	0.28	17	

Part No.	Size	Orbit	RPM	Pad Face	Weight	HP	SCFM	Noise	Vib m/s 2
MR-30	3"	0 mm	3,000	Grip	1.5 lbs	0.28	17	81 dB	1.4
MR-350	3"	5 mm	12,000	PSA	1.12 lbs	0.28	17	80 dB	2

## Accessories



5723-BP

3" dia. x 1/2" Black Foam Pad (Finesse)

MPADBF-8

8" dia. x 1/4" CCS Black Foam (Finesse)



MPADTW-3

3" dia. 1" Twisted Wool (Cutting)

MPADTW-7.5-1.25

7 1/2" dia. 1 1/4" Twisted Wool



M-9915G

MicroFiber Cloth



**1055F**  
Grip Firm Faced 5-Hole  
5" dia. 3/8" thick



**1066F**  
Grip Firm Faced  
6" dia. 3/8" thick



**915GV28\***  
Medium, Multi-Hole  
Vacuum Backup Pad  
5/16- 24 thread



**916GV48\***  
Medium, 48-Hole  
Vacuum Backup Pad  
5/16- 24 thread



**102GG**  
2 7/8" Grip Faced  
Medium, Backup Pad  
3/16- 24 thread



**913G**  
Medium, Grip Faced  
Backup Pad  
1/4 - 20 thread



**913GV**  
Medium, Grip Faced  
Multi-Hole Vacuum  
Backup Pad  
1/4 - 20 thread



**9193500111** (Black)  
**9193600111** (White)  
■ Dry guide coat

## Compounds



PART NUMBER:	SIZE:
PC45-025L	250 ml
PC45-1L	1 Liter
PC45-2.8L	2.8 Liter
PC45-17L	17 Liters

### POLARSHINE® 45

- Coarse polishing compound for production or restoration processes
- Suitable for hard surfaces and coatings; ideal for gel coat and high gloss lacquers
- Quickly and permanently removes scratches from P600
- Removes heavy oxidation and restores color and shine - Leaves a deep gloss finish - one step polishing for light colors!



PART NUMBER:	SIZE:
PC35-025L	250 ml
PC35-1L	1 Liter
PC35-5L	5 Liters
PC35-17L	17 Liters

### POLARSHINE® 35

- An aggressive polishing compound for removal of P800 and finer sanding scratches, or for heavily oxidized surfaces.
- Can also be used for removal of fine orange peel
- Ideal for gelcoats, refinish coatings and composites
- Silicone-free



PART NUMBER:	SIZE:
PC20-1L	1 Liter

### POLARSHINE® 20

- Suitable for removal and leveling of fine orange peel
- Perfect balance for high gloss and speed
- Silicone-free



PART NUMBER:	SIZE:
PC10-1L	1 Liter
PC10-025L	0.25 Liter
PC10-5L	5 Liters

### POLARSHINE® 10

- Medium duty compound can buff and polish by simply changing pads
- Removes sanding scratches without fillers
- Suitable for all paint systems including scratch resistant clear coats
- Silicone-free



PART NUMBER:	SIZE:
FC5-1L	1 Liter

### POLARSHINE® VF5

- Polarshine® 5 leaves a high gloss finish without swirl marks
- Removes compound swirls and fine sanding marks
- A medium-fine polish for cleaning and refreshing surfaces
- Suitable for hologram removal
- Silicone-free

# Mirka® Sanders

Mirka's sanding and polishing tools portfolio consists of electric and pneumatic sanders, polishing machines, dust extractors, equipment, and tools for sanding walls and ceilings. Our power tools are backed by a complete range of spare parts, backing pads and other accessories to help you get the most from Mirka's sanding solution.



## Mirka® DEROS



Direct Electric Random Orbital Sander (DEROS) is the first ever electric sanding machine with a brushless DC motor and no external power supply. The main voltage is 100V - 120V and plugs into a standard 110V outlet.

The Mirka® DEROS has a soft start function, a built in electronic motor brake and a smooth, easy to operate lever to control motor speed. (Vacuum Ready)

### FEATURES AND BENEFITS:

- Electric Random Orbital Sander with 5mm orbit
- Comparable power of pneumatic tools - but lighter
- Low profile allows for easy maneuverability
- Ideal for small and large repairs
- Optimized ergonomics for a comfortable grip
- Fast, efficient and dust-free sanding performance

Available in 3", 5" and 6" for more information visit [mirkaderos.com](http://mirkaderos.com)



## Mirka® DEOS



Mirka® DEOS is naturally equipped with a brushless motor. The optimized ergonomics enable a comfortable grip. The machine has an easy to operate lever to control motor speed. It possesses also a separate on/off switch for easy and safe handling.

### FEATURES AND BENEFITS:

- Electric Orbital Sander with 3mm orbit
- Comparable power of pneumatic tools - but lighter
- Low profile allows for easy maneuverability
- Ideal for tight and low profile spaces
- Optimized ergonomics for a comfortable grip
- Fast, efficient and dust-free sanding performance

Available in 2.75" x 7.75" and 3" x 5"



## Mirka® DEOS DELTA



Mirka® DEOS Delta is ideal for precise and efficient sanding of corners, profiles, vertical and hard-to-reach areas at any angle. An easy to operate lever enables instant speed adjustment, and a separate on/off switch ensures easy and safe handling.

### FEATURES AND BENEFITS:

- Electric Orbital Sander with 3mm orbit
- Low profile allows for easy maneuverability
- Ideal for corners, tight and low profile spaces
- Optimized ergonomics for a comfortable grip
- Lightweight, fast, efficient and dust-free sanding performance

Available in 4" x 4" x 6"

## Pneumatic Random Orbital Sanders

Mirka pneumatic random orbital sanding machines are effective and durable tools for professional sanding. They feature ergonomic design and lightweight, hi-tech materials to create tools with optimal strength and user comfort. These machines are built for maximum dust extraction even at low suction power and have a low noise level even when operating at their 12,000 rpm maximum.



### Mirka® PROS SGV-SERIES (Self-Generated Vacuum)

#### FEATURES AND BENEFITS:

- 1¼" hose threaded vacuum fitting
- Unique shroud system with brake seal allows minimal internal air leakage for improved dust extraction, even at low suction power
- Quick connect fitting for the dust extraction hose
- Optimized ergonomics that make it user-friendly and comfortable to grip for long operating period



### Mirka® PROS CV-SERIES (Vacuum Ready)

Mirka® PROS was specially developed to produce maximum dust extraction, even at low vacuum power, thanks to a wider dust collection port in the machine housing which substantially improves efficiency. The ergonomics of this tool makes it stand above the rest.

#### FEATURES AND BENEFITS:

- 1¼" hose threaded vacuum fitting
- Unique shroud system with brake seal allows minimal internal air leakage for improved dust extraction, even at low suction power
- Quick connect fitting for the dust extraction hose
- Optimized ergonomics that make it user-friendly and comfortable to grip for long operating period

Available in 5" and 6".



### Mirka® MR-38CV (Vacuum Ready, and Self-Generated Vacuum)

This tool is ideal for sanding small to medium size areas. The 10,000 rpm motor features a composite rotor and blades for long-lasting performance with increased resistance to moisture in air supply. The 3mm orbit action sands quickly, and provides a uniform surface finish.

Available in 2¾" x 7¾"



### Mirka® MR CV-SERIES (Vacuum Ready)

Hi-tech materials were used to create these tools with optimal strength and user comfort. These machines are lightweight and have a low noise level even when operating at their max 12,000 rpm.

Available in 3", 5" and 6"



### Mirka® MR SGV-SERIES (Self-Generated Vacuum)

These machines create a self-generated vacuum, allowing excellent dust extraction without limiting user mobility. The MR SGV series provides another option for dust extraction while getting great sander performance.

Available in 3", 5" and 6"



### Mirka® Two-Handed Sanders (Vacuum Ready)

Heavy duty sanders can be configured for one or two-handed operation for aggressive sanding applications. Each two-handed model counter-balanced for its specific size backup pad for high speed performance with minimal vibration - for maximum productivity.

Available in 5" and 6"

# Mirka® Marine Standard Operating Procedures

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.



## SOP | Seasonal Bottom Sanding Preparation

### 1 - Sand



#### ABRASIVES

**AH-241-080** 6" Abranet® Ace HD P80

**AC-241-080** 6" Abranet® Ace P80

#### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Based on the amount of paint layers to be removed, for heavier paint applications, we recommend the **Abranet® ACE HD**

For scuff sanding we recommend the **Abranet® ACE** using an electric **DEROS** sander or pneumatic **PROS** sander.

### 2 - Paint

After solvent wipe down, follow painting procedure via paint manufacturer's instructions.

## SOP | New Boat Sanding Preparation

### 1 - Sand



#### ABRASIVES

**18-241-447** 6" Mirlon Scuff Disc

**AC-241-080** 6" Abranet® Ace P80

#### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

If necessary, in conjunction with paint manufacture's de-waxing products use **Mirlon Scuff Disc** to remove release wax on surface.

Prior to paint or primer application, sand surface thoroughly with **Abranet® Ace** using an electric **DEROS** sander or pneumatic **PROS** sander to dull hull finish.

### 2 - Paint

After solvent wipe down, follow painting procedure via paint manufacturer's instructions.

# SOP | Surface Restoration

For removal of light scratches and oxidation from gelcoat finishes

## 1 - Clean



### ACCESSORIES

**M-9915G** Microfiber Cloth

Using a suitable cleaner, properly clean the surface to remove dirt, wax, grease or any other contaminants from the gelcoat using a microfiber cloth (**M-9915G**).

## 2 - Sand



### ABRASIVES

**8A-241-1000** 6" Abralon® 1000

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Sand using an electric **DEROS** sander or pneumatic **PROS** sander to remove oxidation with **Abralon® 1000** grit with a 50% overlap pattern (damp).

Lightly spray the pad and surface with clean water.

If too much is used, the abrasive will float over the surface with reduced cutting action.

## 3 - Buff



### ABRASIVES

**PC45-1L** Polarshine® 45

### TOOLS + ACCESSORIES

**MPADTW-7.5** Twisted Wool Pad  
(7" Rotary Buffer)

Buff using Polarshine® 45 (**PC45**) compound in conjunction with a twisted wool pad (**MPADTW-7.5**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

Keep the pad clean from compound build-up.

## 4 - Polish



### ABRASIVES

**PC10-1L** Polarshine® 10

### TOOLS + ACCESSORIES

**MPADBF-8** Black Foam Pad  
(7" Rotary Buffer)

Polish using Polarshine® 10 (**PC10**) with a black foam pad (**MPADBF-8**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

# SOP | Production + Aftermarket **Gelcoat Repair**

For removing mold marks, scratches and blending/polishing sprayed-on gelcoat repairs

## 1 - Highlight



### DRY GUIDE COAT

**9193500111** (black)

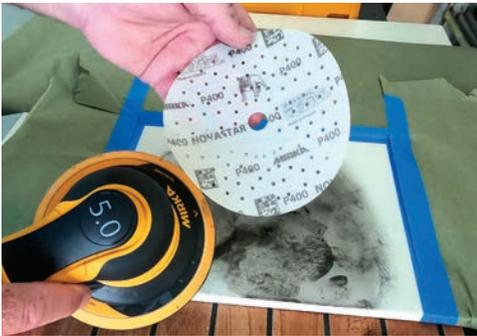
**9193600111** (white)

Clean the surface to remove dust, dirt or other surface contamination. Never sand a dirty part.

Use a highlighter such as Mirka® Guide Coat (**9193500111**) to show high spots when sanding.

The highlighter will be removed during the sanding process and show any surface defects that need to be repaired or removed.

## 2 - Sand



### ABRASIVES

**FM-6MH-400, -600** 6" Novastar® Multi-Hole P400, P600

**FM-611-800** 6" Microstar® P800

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DERSO Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

**M-9915G** Microfiber Cloth

Sand surface using an electric **DERSO** sander or pneumatic **PROS** sander with **P400** grit abrasive and wipe surface clean using a microfiber cloth (**M-9915G**).

Re-apply highlighter.

Sand using **P600** grit abrasive, then **P800** grit abrasive and wipe clean using a microfiber cloth (**M-9915G**).

## 3 - Buff



### ABRASIVES

**PC45-1L** Polarshine® 45

### TOOLS + ACCESSORIES

**MPADTW-7.5** Twisted Wool Pad (7" Rotary Buffer)

Buff using Polarshine® 45 (**PC45**) compound in conjunction with a twisted wool pad (**MPADTW-7.5**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

Keep the pad clean from compound build-up.

## 4 - Polish



### ABRASIVES

**PC10-1L** Polarshine® 10

### TOOLS + ACCESSORIES

**MPADBF-8** Black Foam Pad (7" Rotary Buffer)

Polish using Polarshine® 10 (**PC10**) with a black foam pad (**MPADBF-8**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

# SOP | Production + Aftermarket **Topcoat Finishing**

To remove dirt nibs, runs or sags in topcoat finishes (color or base/clear coat).

## 1 - Sand



### ABRASIVES

**FM-611-1500** 6" Microstar® P1500

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** 6" Backup

**1066F** Interface Pad

Sand using an electric **DEROS** sander or pneumatic **PROS** sander with **Microstar® 1500** grit (dry) using moderate speed, and an interface pad.

The topcoat should "powder" when sanding. Sanding too early risks producing "pills" which will damage the surface.

## 2 - Sand



### ABRASIVES

**8A-241-3000** 6" Abralon® 3000

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Refine sand scratches using **Abralon® 3000** grit with a 50% overlap pattern (damp).

Spray the pad and surface with clean water.

If too much is used, it will be evident by water "slinging" from the pad, and the abrasive will float over the surface with reduced cutting action.

## 3 - Buff



### ABRASIVES

**PC45-1L** Polarshine® 45

### TOOLS + ACCESSORIES

**MPADTW-7.5** Twisted Wool Pad (7" Rotary Buffer)

Buff using Polarshine® 45 (**PC45**) compound in conjunction with a twisted wool pad (**MPADTW-7.5**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

Keep the pad clean from compound build-up.

## 4 - Polish



### ABRASIVES

**PC10-1L** Polarshine® 10

### TOOLS + ACCESSORIES

**MPADBF-8** Black Foam Pad (7" Rotary Buffer)

Polish using Polarshine® 10 (**PC10**) with a black foam pad (**MPADBF-8**).

Use a slow speed (1,200 - 1,500 rpm) to prevent "burning" the finish.

# SOP | Polyurethane **Prepare/Blend Procedure**

## 1 - Prep



Follow manufacturers recommendations for application of repair putty, filler, etc., followed by primer and topcoat.

## 2 - Sand



### ABRASIVES

**9A-241-400, -600** 6" Abranet® P400 , P600

**FG-6MH-400, -600** 6" Novastar® P400, P600

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

Sand surface using an electric **DEROS** or pneumatic **PROS** sander with either **Abranet® P400** or **P600** grit or **Novastar® P400** or **P600** grit abrasives.

## 3 - Sand/ Finish



### ABRASIVES

**FM-622-800, -1500** 6" Microstar® P800, P1500

**8A-241-2000** 6" Abralon® 2000

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

Refine the surface with **Microstar® P800** and/or **P1500** grit abrasives.

Finish the surface using **Abralon® 2000** grit abrasive (damp).

Lightly spray the pad and surface with clean water.

## 4 - Polish



### COMPOUNDS

**PC10-1L** Polarshine® 10

**FC5-1L** Polarshine® VF5

### TOOLS + ACCESSORIES

**MPADTW-7.5-1.25** Twisted Wool Pad

**MPADBF-8** Black Foam Pad

Buff with Polarshine® 10 (**PC10**) with a twisted wool pad (**MPADTW-7.5-1.25**) for an extra glossy finish on darker colors.

Complete with Polarshine® VF5 (**FC5-1L**) using the black foam pad (**MPADBF-8**).

# SOP | Solid Surface **Finishing**

Designed as a starting point when finishing solid surfaces.

Actual grit selection may be changed to meet customer specifications for surface appearance.

## 1 - Level



### ABRASIVES

**9A-241-120** 6" Abranet® P120

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Finish seams or level repair areas using an electric **DEROS** sander or pneumatic **PROS** sander with **Abranet® P120** grit abrasive.

To remove surface defects on repair areas, use a **P120** grit (125 micron) abrasive (dry).

## 2 - Surface Prep



### ABRASIVES

**9A-241-180, -240** 6" Abranet® P180 , P240

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Use **Abranet® P180** grit (82 micron) to **P240** grit (60 micron) abrasive (dry) to remove scratches and prepare for final surface finishing.

## 3 - Finish



### ABRASIVES

**8A-241-360** 6" Abralon® P360

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Use **Abralon® 360** grit for matte finish.

For a *satın finish*, continue with 1000 grit. For a *gloss finish*, continue with 2000 grit.

Remember to wipe the surface clean between steps to prevent contamination scratches.

Abralon® may be used dry, or with a water mist for lubrication.

Best results for high gloss finishes are achieved when Abralon® is used damp.

## 4 - Clean



### ACCESSORIES

**M-9915G** Microfiber Cloth

Wipe dry using a microfiber cloth (**M-9915G**) and inspect surface.

# SOP | White Wood **Finishing**

Ensures the finish being applied will have good adhesion, uniform stain color and desired look intended for the finished part.

## 1 - Identify



Identify the type of wood you will be sanding. Harder species of wood require a more aggressive (coarse) grit. Softer ones, a less aggressive grit to achieve the same result.



**Mirka® DEOS and DEOSDELTA may also be used.**

## 2 - Sand



### ABRASIVES

**9A-241-120** 6" Abranet® P120

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Using an electric **DEROS** sander or pneumatic **PROS** sander with **Abranet® P120** grit abrasive to remove saw marks or other surface defects.

## 3 - Refine



### ABRASIVES

**9A-241-150, -180** 6" Abranet® P150, P180

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Refine the scratches using the next finer grit of the abrasive. Always graduate one grit step at a time (**P120-P150-P180**).

If hand sanding, always sand in the direction of the grain using even pressure and uniform stroke length.

## 4 - Finish



### ABRASIVES

**9A-241-240** 6" Abranet® P240

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Complete the sanding steps until the surface has a smooth, uniform finish with **Abranet® P240** grit abrasive.

Lightly sand the edges of the part. The sanding process has created sharp edges. Smoothing or "easing" these edges will allow the finish to maintain a uniform film thickness for proper adhesion and appearance.

# SOP | Brightwork **Finishing**

Remove dirt nibs, runs or sags in clear topcoat and produce level, high gloss finish

## 1 - Sand



### ABRASIVES

**FM-611-800, -1500** Microstar® P800, P1500

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

**1066F** Interface Pad

Level orange peel and any defects using an electric **DEROS** or pneumatic **PROS** sander with **Microstar® P800**. Follow with **P1500** grit (dry) using moderate speed.

The coating should "powder" when sanding. If you can not produce dust, then it is not dry enough to sand. Sanding too early risks producing "pills" which will damage the surface.

## 2 - Finesse



### ABRASIVES

**8A-241-3000** 6" Abralon® 3000

### TOOLS + ACCESSORIES

**MID65020CAUS** 6" DEROS Sander

**MRP-650CV** 6" PROS Sander

**916GV48** Backup Pad

Refine sand scratches with **Abralon® 3000** grit with a 50% overlap pattern (damp).

Spray the pad and surface with clean water. If too much is used, it will be evident by water "slinging" from the pad, and the abrasive will float over the surface with reduced cutting action.

## 3 - Buff



### ABRASIVES

**PC10-1L** Polarshine® 10

### TOOLS + ACCESSORIES

**MPADTW-3** 3" Twisted Wool Pad

**MPADTW-7.5-1.25** Twisted Wool Pad (7" Rotary Buffer)

**MR-30** 3" Palm Buffer

**ARP300-B** 3" Cordless Polisher

Buff using either a **MR-30** Palm Buffer or **ARP300-B** Cordless Polisher and **PC10** compound in conjunction with a twisted wool pad (**MPADTW-7.5-1.25**)

Use a slow speed (1,500 rpm) to prevent "burning" the finish.

Keep the pad clean from compound build-up.

(If unable to use twisted wool, you can substitute a lambs wool pad **MPADLW-7.5**)

## 4 - Polish



### ABRASIVES

**FC5-1L** Polarshine® VF5

### TOOLS + ACCESSORIES

**MR-30** 3" Palm Buffer

**ARP300-B** 3" Cordless Polisher

**MPADBF-3.25** 3" Black Foam Pad

**MPADBF-8** Black Foam Pad (7" Rotary Buffer)

**M-9915G** Microfiber Cloth

Polish using either a **MR-30** Palm Buffer or **ARP300-B** Cordless Polisher and Polarshine® VF5 (**FC5-1L**) compound with a black foam pad (**MPADBF-8**).

Use a slow speed (1,500 rpm) to prevent "burning" the finish.

Wipe surface clean using a lint-free microfiber cloth (**M-9915G**).

# Warranty Policy

## WARRANTY

Mirka USA Inc. ("Mirka") warrants that the following Mirka products will be free from defects in material or workmanship from the date of purchase for the time period indicated:

- a. Electric tools (DEROS, DEOS except dust extractors): 2+1 years \*
- b. All other tools (MR, PROS, Two- Handed Sander, Pneumatic, and Dust Extractor): 2+1 years \*
- c. Tools used in a continuous industrial environment are excluded from the 2+1 warranty, and will be covered for 1 year only.

\* By registering an electric tool within 30 days of purchase at [http://www.mirka.com/warranty\\_registration/](http://www.mirka.com/warranty_registration/).

Mirka will warrant the product for an additional one year.

## TERMS AND CONDITIONS

The purchase of any Mirka product will constitute and be deemed to be acceptance of and agreement to the Mirka Warranty Policy ("Policy") by the purchaser and/or user (collectively "User") of any Mirka product. The Policy shall not apply to:

- Normal wear and tear; or
- Product failure or damages caused by:
  - Subsequent modification of the Mirka product;
  - Repairs attempted or made on the Mirka product other than by Mirka;
  - Misuse, abuse or neglect;
- Careless or unsafe handling;
- Inadequate or improper maintenance;
- Failure to follow any applicable instructions for the Mirka product; or
- Anything other than defects in material or workmanship.

Mirka's sole obligation under this Policy shall be, at Mirka's option, to: (1) repair or replace any Mirka product that is defective in material or workmanship; or (2) refund the purchase price of the Mirka product that is defective in material or workmanship.

The User is responsible for determining whether the Mirka product is fit for a particular purpose and suitable for the User's application. The User is also responsible for complying with any applicable safety and health-related regulations and taking any safety and health-related precautions when using Mirka products. This includes, but is not limited to: wearing safety glasses, face masks, gloves, and protective clothing, if necessary; following instructions and warning labels; and operating Mirka products safely including at safe operating speeds. By User's purchase or use of Mirka products, User acknowledges, represents, and warrants that User will: (a) comply with the foregoing; and (b) assume all risks in connection with the use of Mirka products.

No agent, representative, employee, distributor or dealer of Mirka is authorized to modify this Policy or to issue any warranty regarding any Mirka products.

Any civil action against Mirka relating to or arising out of the sale of Mirka products shall be commenced within one (1) year of the date the cause of action accrued or otherwise the cause of action shall be barred.

## DISCLAIMER

Except for the provisions of this "WARRANTY," Mirka expressly disclaims all guarantees and/or warranties, expressed or implied, including the warranties of merchantability and fitness for a particular purpose and any implied warranty arising out of a course of dealing, custom or usage of trade.

## LIMITATION ON LIABILITY

Mirka's liability for any loss or damage arising out of or resulting from any breach or default by Mirka in connection with the sale of Mirka products hereunder shall not exceed the purchase price thereof, regardless of whether such liability arises in contract, tort (including, without limitation, strict liability) or otherwise.

In no event shall Mirka be liable for loss or damage arising from the Mirka product, whether direct, indirect, special, incidental, or consequential damages of any kind regardless of the legal theory asserted, including, without limitation, warranty, contract, negligence or strict liability.

## SUBMITTING A WARRANTY CLAIM

To submit a warranty repair claim, Users must contact their Mirka dealer or Mirka Customer Support. Tools returned for warranty repair must be accompanied by a valid purchase receipt or invoice.

# GRIT COMPARISON CHART

MICRON	US CAMI	FEPA 'P'	JAPAN JIS
500	36	36	36
430	40		
425		40	
350	50		40
336		50	
300			50
270	60	60	
260			
250			60
210			70
200		80	
192	80		
177			80
162		100	
149			90
140	100		
125		120	100
116	120		
100		150	120
93	150		
82	180	180	150
68	220	220	180
60		240	240
52	240	280	280
46		320	320
42	280		
40		360	360
35	320	400	400
30		500	
28	360		500
26		600	600
22	400	800	700
18	500	1000	800
15	600	1200	1000
13		1500	1200
10		2000	1500
8		2500	2000
7		3000	2500
6			
5		5000	3000
3			4000



**Mirka USA Inc.**

**Tel.** 330-963-6421

**Fax** 330-963-6427

**E.** [sales.us@mirka.com](mailto:sales.us@mirka.com)

**Mirka Canada Inc.**

**Tel.** +1 855 234 NET5 (6385)

**Tel Direct.** +1 514 400 3783

**E.** [sales.ca@mirka.com](mailto:sales.ca@mirka.com)

[mirka.com](http://mirka.com)

[mirkamarine.us](http://mirkamarine.us)

