

The Mirka logo is located in the top left corner. It consists of the word "MIRKA" in a bold, black, sans-serif font, set against a solid yellow rectangular background.

**MIRKA**

The background of the entire page is a photograph of several large, clear glass sheets stacked on top of each other. The sheets are slightly offset, creating a sense of depth and perspective. The lighting is soft, highlighting the edges and the transparency of the glass.

## 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](http://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 glass sanding solution covers several types of glass

**Floated glass** is flat glass produced in a float process. This is made by floating molten glass on a bed of molten metal. This method gives the sheet a uniform thickness and very flat surfaces. Modern windows are made from float glass. Most float glass is soda-lime glass.

**Annealed glass** is the basic flat glass and that is the result of the float process.

**Tempered or Toughened glass** is glass that has been thermally heat treated to be far more resistant to breakage than annealed glass. Toughened or tempered glass is used in many applications and often as safety glass in a variety of demanding applications, including passenger vehicle windows, shower cabin doors, architectural glass doors and tables, bulletproof glass, structural applications, barriers and roof glazing, facade glazing.

## End-user Recommendations

1. Sand each step long enough, this is all about giving each step its time.
2. The less steps you get the job done with the better, there is a risk for optical refraction.
3. The polish step takes longer than the sanding steps.
4. We do not recommend the process to be used on car front windshields because of the risk of optical refraction.





# 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 one 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 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. Use every disc at least 1 minute before continuing with the next grit. 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. 1 minute 15 seconds. Wipe clean before next sanding step.



**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. 1 minute 30 seconds. Wipe clean before next sanding step.



**Step 4:** Sand with Abralon 600 and Mirka PS 1437 Rotary Polisher or Mirka RP 300NV 77mm Non Vacuum Rotary Polisher. Dry or wet sanding.  
**Sanding time:** Approx. 1 minute 50 seconds. Wipe clean before polishing.



**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 77mm	
Grit	Mirka code
P80	5020305080
P120	5020305012
P150	5020305015
P180	5020305018
P240	5020305025
P320	5020305032
P400	5020305041

Abranet® SIC NS 125mm	
Grit	Mirka code
P80	5023205080
P120	5023205012
P150	5023205015
P180	5023205018
P240	5023205025
P320	5023205032
P400	5023205041

Abranet® SIC NS 150mm	
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 an even, closed 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® 77mm	
Grit	Mirka code
180	8A20302018
360	8A20302037
500	8A20302051
600	8A20302061
1000	8A20302092

Abralon® 125mm	
Grit	Mirka code
180	8A23202018
360	8A23202037
500	8A23202051
600	8A23202061
1000	8A23202092

Abralon® 150mm	
Grit	Mirka code
180	8A24182018
360	8A24182037
500	8A24182051
600	8A24102061
1000	8A24182092



## 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  
125x6mm Grip  
White, 2/Pack

Mirka code : 7996012511

A flat hard 6 mm tick white felt pad, designed for glass polishing applications. The thick felt pad construction has a good balance and provides a stable feeling 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  
330x330mm  
Yellow, 2/Pack

Mirka code : 7991200111

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



Mirka® PS 1437  
Polisher 150mm

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 bail 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.



Dust Suction Hood  
for PS 1437 Polisher

Mirka code : 9190152001

An easy keyless attachment of hood to Mirka PS 1437 Polisher suitable for demanding aggressive sanding applications and used together with Abranet HD, it supports the dust-free solution. The front segment can be removed for a better visibility and to reach edges, the springs also give a smoother operation. The brushes ensure a good suction and protect the surface.



Backing Pad 125mm  
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**  
Finland

**Brazil** Mirka Brasil Ltda.

**Canada** Mirka Abrasives Canada Inc.

**China** Mirka Trading Shanghai Co., Ltd

**Finland & Baltics** KWH Mirka Ltd

**France** Mirka Abrasifs s.a.r.l.

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**Turkey** Mirka Turkey Zımpara Ltd Şirketi

**United Kingdom** Mirka (UK) Ltd

**USA** Mirka Abrasives, Inc

For contact information,  
please visit **[www.mirka.com](http://www.mirka.com)**

Quality from start to finish

