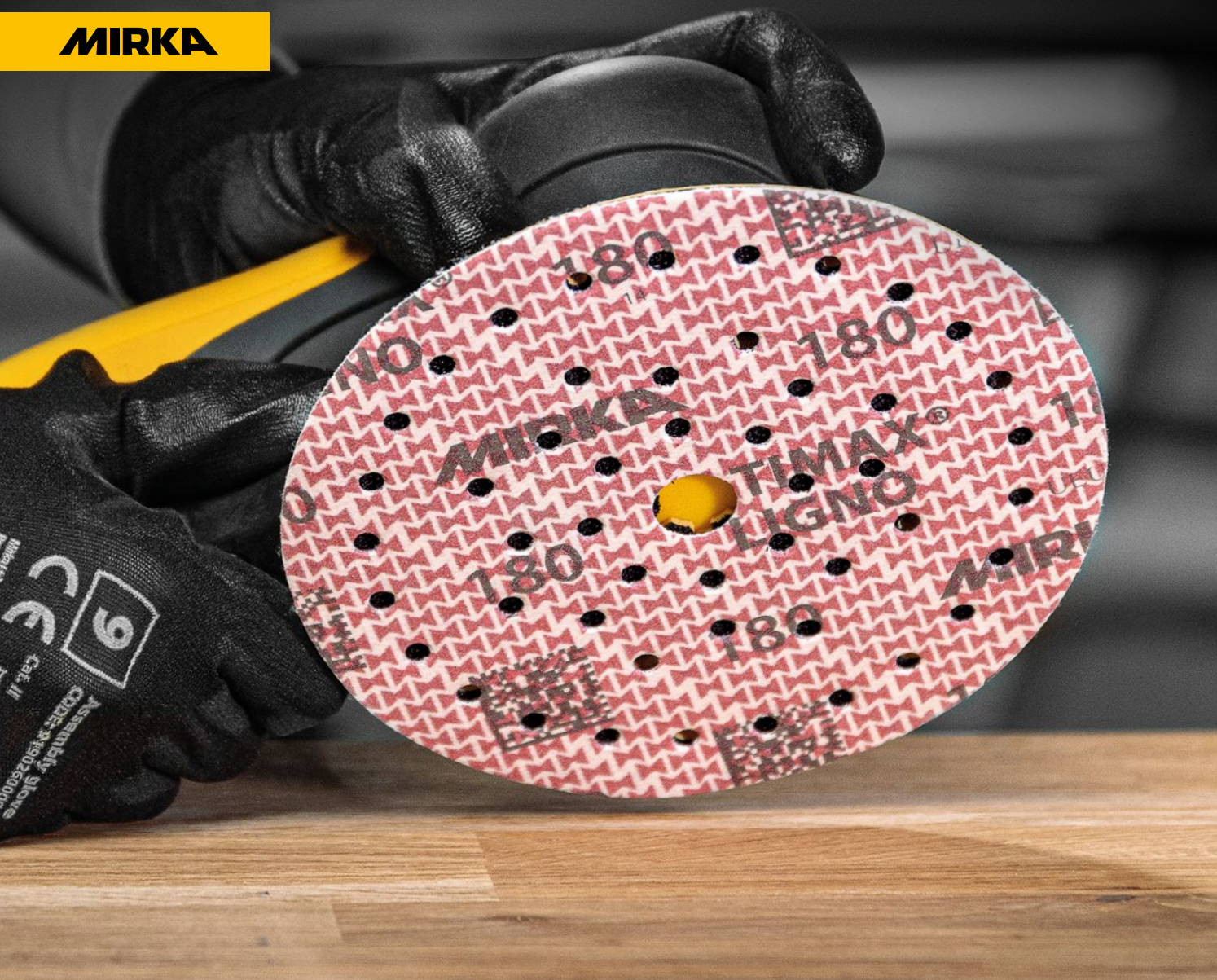
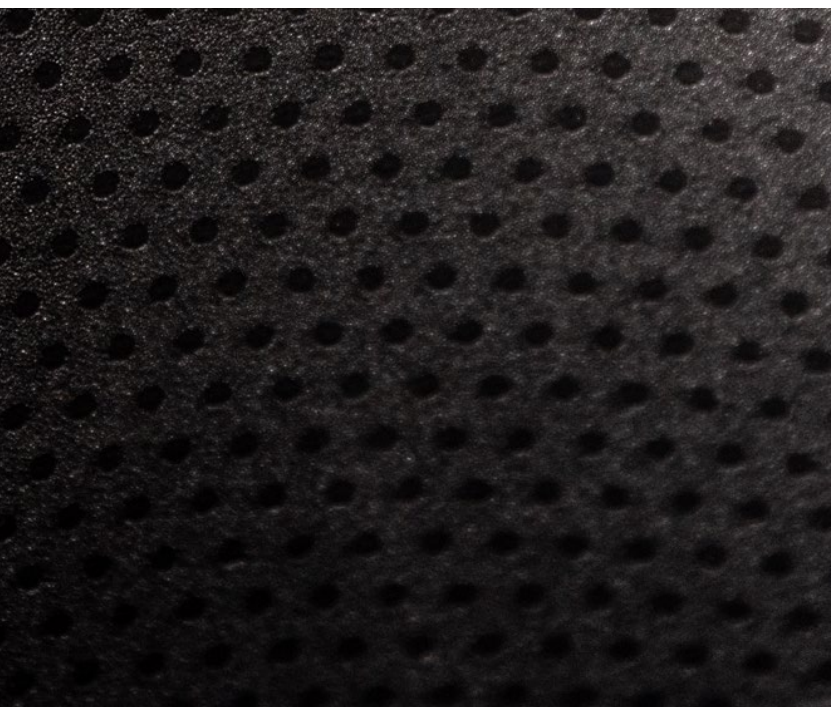


MIRKA



Mirka Wood Sanding



About Mirka

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.

97 percent 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.



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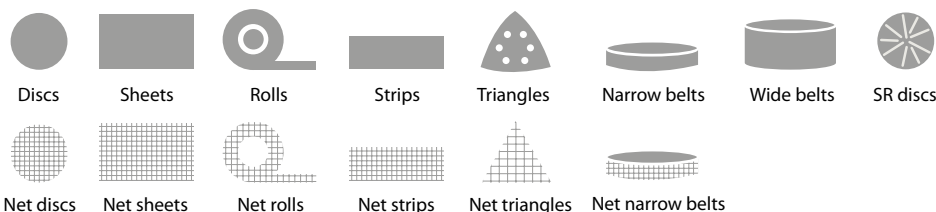
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MIRKA BELT RANGE

86

SYMBOLS



ABRANET SANDING VS PAPER BACKED SANDING

Tests have shown that net sanding produces a minuscule amount of dust compared to conventional dry sanding technology with extraction. As the entire surface of the abrasive removes dust, the Mirka net products are extremely effective in minimizing dust contamination in the workplace, creating a far healthier working environment than with conventional sanding.



Ultimax® Ligno

The new Mirka Ultimax® Ligno is tailored for wood sanding applications. It **combines a fast cut with long life**, thanks to especially good resistance to clogging when sanding substrates. Using new generation technology, abrasive grains are grouped into optimized hourglass patterns, into shapes that are proven to perform the best. Mirka's precise, energy saving production process also has a significant effect in creating less material waste.

The instantly recognisable hourglass pattern ensures optimal cutting performance with consistent results. The segmented surface increases sanding pressure on each abrasive grain. Each segment has four sharp corners and two angled surfaces, constantly creating additional cutting edges during sanding.

With Ultimax Ligno, Mirka uses a specially developed latex impregnated paper to improve flexibility and adhesion and to control edgewear, providing each abrasive with a longer service life. It is available in a wide range of grits from 40 to 400.

To resist clogging and speed up the cutting process, Ultimax Ligno utilizes Mirka's groundbreaking Multifit® hole pattern. Its dust channels leading to extraction holes take control of dust, keeping the abrasive grains cutting, and as air circulates under the abrasive it reduces heat during sanding. Even larger wood dust particles are not an issue thanks to different width dust channels. Exposure to wood dust is a significant occupational health risk, meaning Ultimax Ligno is designed from the start with Mirka's dust free sanding technology.

WOODWORKING MASTERPIECE



Using new generation technology, abrasive grains are grouped into **optimised hourglass patterns**, into shapes that are proven to perform the best.

MULTIFIT TECHNOLOGY

HOURGLASS PATTERN

SUSTAINABLE ABRASIVE

Fast cut and long lasting. The Multifit hole pattern controls the dust, reducing heat during sanding.



Enhanced edgewear. Cracking without releasing.

Technical specifications

Ultimax Ligno

Backing	Latex paper, D-paper/C-paper
Bonding	Low VOC resin system
Coating	Semi-open with Selective Coating®
Colour	Red
Grain	Ceramic/Aluminium oxide
Package size	Grit 40–60 = 50 pcs/pack. Grit 80–400 = 100 pcs/pack. Perf.roll = 150/roll



Mirka® Galaxy

Every aspect of the Mirka Galaxy serves together to turn it into a real multi-purpose abrasive. It is suitable for sanding both soft and hard materials as well as various substrates, thanks to its excellent clogging resistance, edge wear resistance and dust repellence. The Mirka Galaxy benefits from Mirka’s new multihole Multifit pattern, which means the abrasive is always correctly placed on any machine, with no need to make it match the holes on the backing pad.

For Mirka Galaxy, we have chosen a special clogging resistant coating, which improves dust repellence. As the dust doesn't stick onto the abrasive, it is more effectively removed from the working surface and extracted via the Multifit holes, making the Galaxy an integral part of Mirka's dustless sanding approach. With dust removed from the picture, the abrasive can continue to cut for a longer time.



Technical specifications	Galaxy
Grain	Ceramic/Aluminium oxide
Colour	Blueish
Backing	Polyester film
Bonding	Low VOC resin system
Grit range	40–2000
Coating	Semi-open

Self-sharpening Grain Technology



Advantages of using a Net Interface with Mirka® Galaxy:

- Makes following surface shapes and contours easier
- Preserves the dust extraction properties thanks to the net structure
- Increases the flexibility of the abrasive and provides a more even finish



Mirka Iridium™

Our premium sandpaper Iridium is perfected for speed and efficiency in universal sanding applications. It cuts faster with fewer steps needed from rough to a smooth surface finish.

Thanks to its precision coating, the paper-backed abrasive does not wear out easily: it practically repels dust, so the grains stay sharp longer. Dust extraction is efficient and convenient.

From coarse to fine grits, Iridium works well on both soft and hard surfaces. We recommend Mirka Iridium for intermediate sanding of paint coats on wood, in restoration or manufacturing alike.



Cuts fast.
Stays sharp.
Repels dust.

Technical specifications

Grain	Ceramic/Alumimium Oxide
Colour	Grey
Backing	Latex C-paper
Bonding	Low VOC resin system
Grit range	40–1000
Attachment	Grip
Coating	Semi-open

NEXTGEN WOOD



SANDING TOOLS



Mirka® DEROS II



Mirka® DEROS II

325/350/550/5650/625/650/680/750

Operator comfort is at its highest standard, as the long-life brushless electric motor of the new DEROS II now has up to 20 % more sanding power for getting effortlessly through demanding jobs and heavy applications.

Features:

- 20 % more powerful brushless electrical motor – longer lifetime
- Low noise level and Integrated vibration sensor
- New accessories (Edge protector/more sustainable sleeve)
- RPM led indication on speed selector + on/off/lockable speed
- Bluetooth features (connect to myMirka for monitoring vibration) + Bluetooth low energy technology
- Ergonomic & symmetrical design – Low-profile, lightweight
- Connect DEROS II to Mirkas dust extractor and use dust-free abrasives for a healthier and safer working environment

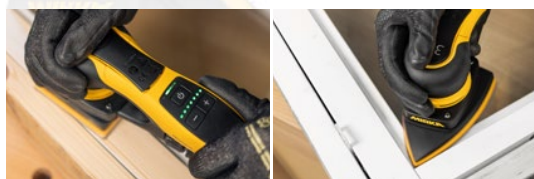
NextGen Tools

New DEROS II 750 with larger pad size

MODEL	DEROS II 325 / 350	DEROS II 550	DEROS II 5650	DEROS II 625	DEROS II 650	DEROS II 680	DEROS II 750
Product code (with case)	MID3254044 / MID3504044	MID5504044	MID5650404CA	MID6254044	MID6504044	MID6804044	MID7504044
Pad diameter	77 mm	125 mm	125 mm/150 mm	150 mm	150 mm	150 mm	175 mm
Power	300 W	400 W	400 W	400 W	400 W	400 W	400 W
Input voltage	220–240 V ~	220–240 V ~	220–240 V ~	220–240 V ~	220–240 V ~	220–240 V ~	220–240 V ~
Speed (rpm)	4,000-10,000	4,000-10,000	4,000-10,000	4,000-10,000	4,000-10,000	4,000-10,000	6,000-9,000
Orbit	2.5 mm/5.0 mm	5.0 mm	5.0 mm	2.5 mm	5.0 mm	8.0 mm	5.0 mm
Weight	0.8 kg	1.0 kg	1.0 kg	1.0 kg	1.1 kg	1.1 kg	1.1 kg
Noise level	67 dB	71 dB	71 dB	71 dB	71 dB	71 dB	71 dB
Vibration	3.1 m/s ² and 3.3 m/s ²	3.2 m/s ²	3.4 m/s ²	2.4 m/s ²	3.4 m/s ²	3.5 m/s ²	2.8 m/s ²
Usage*	1, 3, 4	1, 2, 3, 4	1, 2, 3, 4, 5	2, 3, 4, 5	1, 2, 3, 4, 5	1, 3, 4, 5	1, 3, 4, 5

*Sectors where the tool is best suited: CD (1), wood (2), ART (3), transport (4) and marine (5). Mirka DEROS II 350: smaller repairs and hard-to-reach sanding. DEROS II 650: powerhouse with brushless motor maintains speed under heavy load. DEROS II 750: for large surface sanding in marine, ART, transport and CD-sector.

Mirka® DEOS II



Mirka® DEOS II

343/353

The long-life brushless electric motors of the new **Mirka® DEOS II** models have 20% more sanding power for getting effortlessly through demanding sanding jobs. Operator comfort continues at a high standard with a low noise level, reducing stress when sanding for longer periods. **Well-known for leading ergonomics and balanced feel**, the award-winning design of the Mirka DEOS is made even more user-friendly.

Features:

- 20% more powerful brushless electrical motor – longer lifetime
- Integrated vibration sensor
- RPM led indication on speed selector
+ on/off switch and lockable speed
- Bluetooth features (connect to myMirka for monitoring vibration)
- Connect DEOS II to Mirkas dust extractor and use dust-free abrasives for a healthier and safer working environment

NextGen Tools

MODEL	DEOS II 343	DEOS II 353
Product code (with case)	MID3434044	MID3534044 (MID3534044CA)
Pad size	75 x 100 mm	81 x 133 mm
Power	300 W	300 W
Input voltage	220–240 V ~	220–240 V ~
Speed (rpm)	5,000-10,000	5,000-10,000
Orbit	3 mm	3 mm
Weight	0.97 kg	0.97 kg
Noise level	70 dB	69 dB
Vibration	3.3 m/s ²	2.6 m/s ²
Usage*	1, 2	1, 2

*Sectors where the tool is best suited: CD (1), wood (2). Compact DEOS II 343CV for window frames. Mirka DEOS II 353 for wood applications.

Mirka® DEROS RS



Mirka® DEROS RS

Silently aggressive. Light and effective. Rotary sander.

Mirka® DEROS RS 600 is designed for heavy-duty, coarse grinding sanding applications. Despite its robust attributes, this tool maintains a surprising level of smoothness during operation, offering a silent and easily manoeuvrable solution for tackling rough materials. DEROS RS is a powerful, lightweight and silent heavy-duty rotary sander. The long-life brushless motor produces 750 W of power.

Features:

- The long-life brushless motor produces 750 W of power
- Lightweight for its size at 1.80 kg and with a low 11.5 cm profile
- Adjustable speed: 700 to 2,500 rpm on clearly visible LED indicator
- A special slow start function can be selected
- Bluetooth features (connect to myMirka for monitoring vibration)
- Momentary switch function
- A shroud (incl.) guides dust in right direction when sanding with a pad saver (Mirka code: 8295610111, 150 mm 67H, 5/Pack)

NextGen Tools

MODEL	DEROS RS 600	DEROS RS 600 +CASE
Product code	MRS6002100	MRS6002100CA
Pad diameter	150 mm	150 mm
Power	750 W	750 W
Input voltage	220–240 V ~	220–240 V ~
Speed (rpm)	700–2,500	700–2,500
Weight	1.8 kg	1.8 kg
Noise level	61 dB	61 dB
Vibration	1.6 m/s ²	1.6 m/s ²
Usage*	1, 2, 3, 4, 5	1, 2, 3, 4, 5

*The tool is best suited for the following sectors: CD (1), wood (2), collision repair (3), automotive (4), and marine (5). Specifically, the DEROS RS is highly effective for microcement work and stair sanding (construction & decoration), paint stripping (collision repair & wood), body in white applications (automotive), and teak deck sanding (marine).



Mirka® DEXOS 1217/1230 M AFC



DEXOS 1217/1230 M AFC

M-Class dust extractor with brushless motor

The new Mirka® DEXOS 1217 and 1230 M AFC is designed to be part of Mirka's next generation of power tools. The DEXOS features numerous clever touches making sanding easier and efficient for the operator. DEXOS 1217 and the larger 1230 M are available as M-class dust extractors. A HEPA filter can be fitted to both. Automatic filter cleaning and a push-to-clean function can be triggered. An airflow sensor indicates when the flow rate is below optimal. In addition, a wearable remote control bracelet can toggle functions and relay information.

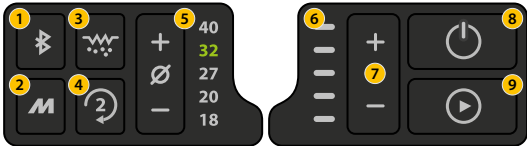
Features:

- Brushless motor for increased efficiency, reduced energy consumption, and longer service life
- Automatic filter cleaning and dust class M (retains 99,9% of dust)
- Cable, hose and sleeve storage inside top lid
- Compact and ergonomic – easy to carry and clean
- Simplified change of dust bag and easy replacement of filters
- Auto-start functionality on 2 sockets and a foot-operated brake pedal

NextGen Tools

MODEL	DEXOS 1217 M AFC	DEXOS 1230 M AFC
Mains voltage	220–240 VAC	220–240 VAC
Power/Total mains load	1200 W/3600 W	1200 W/3600 W
Max. airflow (l/s)	* 42 l/s	* 42 l/s
Max. Vacuum (kPa)	25 kPa	25 kPa
Sound pressure level LPA	77.7 dB(A)	77.7 dB(A)
Weight	13 kg (28.7 lbs)	14 kg (30.9 lbs)
L x W x H	481 x 332 x 480 mm (19 x 13 x 19 in)	529 x 372 x 567 mm (21 x 15 x 22 in)
Container capacity	17 l	30 l

Product codes (1217 M AFC/+ 4 m hose/+ hose, sleeve and cable): MIX12171220/MIX12171221/MIX12171222. (1230 M AFC/+ 4 m hose/+ hose, sleeve and cable): MIX12301220/MIX12301221/MIX12301222. *Maximum airflow model range may vary between markets.



1. Bluetooth pairing

2. Multifunction

3. Auto-Filter cleaning

4. Autostart (from socket 2)

5. Hose setting (+diameter)
6. Power-level indicator

7. Power adjust

8. On/Standby (Autostart)

9. Start button

AUTOMATED SANDING AND POLISHING OF WOOD



Robotic sanding of wood

Mirka's experience in creating sanding solutions has expanded to automated sanding. Integrated with sanding robots, Mirka power tools enable a consistent finish in industrial wood applications.

The combination of Mirka abrasives and Mirka Automation robotic sanding heads is the way to flawless finish in industrial production. Repetitive tasks are turned into consistent finish without equal, saving time and money on a yearly basis with minimized downtime. Automated sanding solutions minimize the scrap rate and the need for reworking or corrections. The convenience of two robots working at the same time can halve the time required for completing wooden furniture such as cabinet doors.

As an IP66 classified 48V electric sander, Mirka® AIROS is suitable for all sanding applications.

The compact design and brushless motor combined with a robust aluminium housing ensure a long lifetime and safer operations. Built for industrial use, Mirka AIROS requires very little maintenance and has been rigorously tested.

It can last up to 18 months in industrial operations without maintenance.

Differently sized & shaped sanding heads are available to suit different tasks. The Mirka Automation range comprises the Mirka AIROS, AIOS & AIROP sanding and polishing heads.





Belt sanding

The Mirka Abranet® MAX net abrasive is available for drum sander applications. The net abrasive roll offers a fast and consistent cut with good resistance to clogging.





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.

Glass Sanding

Mirka offers an efficient and safe process for sanding glass surfaces to remove scratches and damage. Instead of having to replace the glass, you can simply refurbish it.

The complete range of Mirka glass refurbishing products includes power tools, abrasives, polishing compounds and accessories which work together for a flawless finish, saving you time and money.



Mirka® DEROS RS

Rotary sander 150 mm

Mirka code:

Mirka® DEROS RS – a perfect blend of power, precision, and user-friendly design, tackling a wide range of materials and applications with ease. Whether you are working in the woodshop, refurbishing or performing heavy-duty industrial tasks, this sander is up to the challenge. Equipped with a powerful 750 W brushless electric motor. Low noise level.

The DEROS® RS 600 sander has been honoured with the prestigious Red Dot Award: Product Design 2025.



Mirka® POLAROS

Polisher 150 mm

Mirka code: MRP6002100

The POLAROS® RP 600 is a 150 mm rotary polisher that elevates all aspects of polishing. Its ergonomic design and patent-pending Ramp Up and Ramp Down functions come together to make the POLAROS RP 600 the preferred choice for professionals. Despite its powerful 750 W motor, the POLAROS keeps the noise level under 60 dB. It delivers high performance without compromising operator comfort or safety.

Achieve the best results, by using Mirka polishing compounds, backing pads and polishing pads.



Mirka® AROP-B 312

Cordless Polisher 77 mm

Mirka code: 8991012311

AROP-B is ideal for professionals; light, ergonomic and optimised for spot repair polishing. Incredibly nimble, easy to move around – with no cord to get tangled or air supply that can get contaminated. Quiet, small and very low maintenance.

The random orbital polisher is brushless with a 77 mm backing pad and it has a 12 mm orbit and Bluetooth connectivity.

Download the myMirka® app to make use of advanced features such as auto-stop and RPM range management.

Backing Pad Hard

For POLAROS Ø 135 mm

Mirka code: 8292557021

Ø 135 mm backing pad for POLAROS® RP 600 rotary polisher. Fastened with four M4 bolts. Max RPM 6,000. Available in hard and soft versions.



Glass Maintenance – Scratch Conditioning



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

- If the scratches are very deep start with Abranet® SIC NS 360 grit, otherwise use Abralon® 360 with Mirka® DEROS RS 600.
- Use a low RPM throughout the process



STEP 2

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



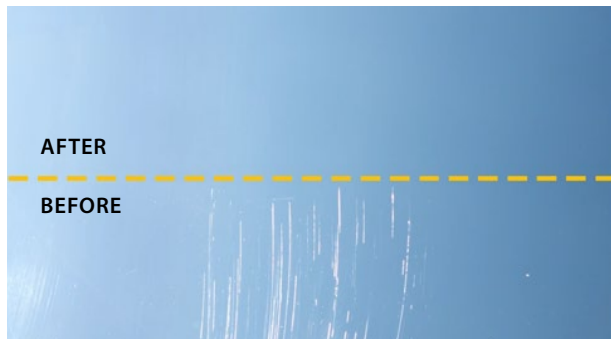
STEP 3

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



STEP 4

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



THE RESULT

- Clean the area with water and Mirka® Cleaning Cloth Micro Fiber

WOOD SANDING SOLUTIONS



FURNITURE

CALIBRATION/ ROUGH SANDING

Sanding of coarse and uneven wood. Removal of marks from planer and other defects.



WIDE BELT SANDING

» Calibration and heavy stock removal requires a tough PES cloth or T-paper backing to resist wear and tear.

ABRASIVE RECOMMENDATIONS

P40 – P80

HARD WOOD



» Ultimax® Black



» Hiolit XO

SOFT WOOD



» Hiolit XO



» Avomax® Antistatic

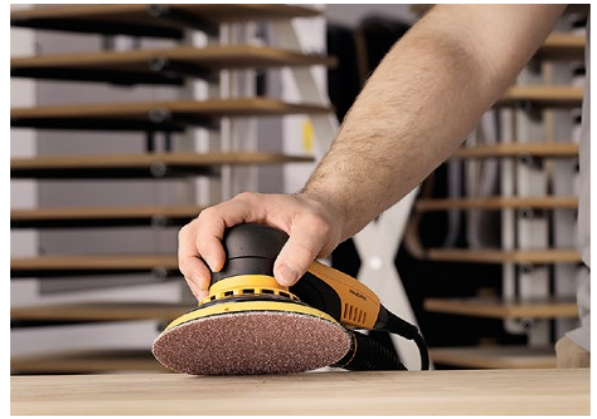
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» Ultimax®



» Jepuflex® Antistatic



DISC SANDING

» Abranet Ace HD is a strong PA net in combination with ceramic grains that is optimal for coarse sanding applications. Ultimax Lignos hourglass pattern ensures optimal cutting performance with consistent results.

ABRASIVE RECOMMENDATIONS

P40 – P80



» Abranet® Ace HD



» Ultimax® Ligno



» Abranet® Ace HD



» Ultimax® Ligno



» Abranet® Ace HD



» Ultimax® Ligno

FURNITURE – SOLID WOOD SANDING



When using wood in construction and decoration projects, one aspect is impossible to overlook, regardless of what type of wood you are using. We're talking about sanding. A piece of wooden furniture, such as a cupboard, needs to look its best, and this is where a high quality sanding process is crucial.

A good sanding result is especially important for products where wood grain remains visible in the finished product, but also if you are planning on applying paint or lacquer. The better the preparation, the better the result. Mirka offers abrasives and tools to help you achieve a flawless end result, together with our dust-free solutions which make it possible for you to sand with virtually no dust.

TOOLS

The first step to sanding wooden surfaces is choosing the right tool for the job. Mirka offers a wide range of electric sanders: the orbital Mirka® DEOS II sanders, and random orbital sanders in the Mirka® DEROS II product range.

No matter which one you prefer, both sander ranges are similarly well-engineered, featuring a low and lightweight ergonomic design to ensure you can sand for long periods without fatigue, with high manoeuvrability and precision.

ABRASIVES

The choice of abrasive to use for the job depends on what type of wood you are sanding. Mirka offers excellent all-round alternatives whether working with softer woods such as pine or a hard wood such as oak. Our recommendations are Ultimax® Ligno, for when you want a premium paper abrasive that is both fast and efficient, or the Abranet® family of abrasives, if you are looking for high material removal performance together with cost-effective sanding.

DUST EXTRACTION

Dust is a natural side product of sanding, but it is a negative one. Not only does dust make your workspace look dirty, it can also have a hazardous effect on your health: the most dangerous dust is airborne, as by the time it settles on the working surface it has been in the air for long, for you to breathe. Long term exposure to dust from certain hard woods can be especially harmful.

Mirka's dust extractors can help you minimize the amount of airborne dust created from sanding. Combining the extractor with our tools and abrasives you will get a dust-free solution that is not only good for your health, it also reduces time spent on cleaning up after you have finished your work.

FURNITURE

SOLID WOOD SANDING

Sanding of solid wood prior to applying primer or sealer.



WIDE BELT SANDING

» For solid wood sanding it is important to choose the correct product to get the ultimate life time of the abrasive and desired surface finish. The Selective Coating® technology by Ultimac offers an extra long life time to the belt.

ABRASIVE RECOMMENDATIONS

P80 – P180

HARD WOOD

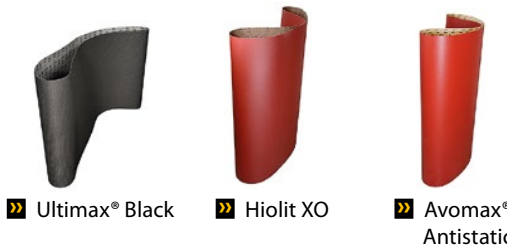


» Ultimac® Black

» Ultimac®

» Hiolit XO

SOFT WOOD



» Ultimac® Black

» Hiolit XO

» Avomax® Antistatic

MDF



» Ultimac® Black

» Ultimac®

» Hiolit XO



DISC SANDING

» Net abrasives enables a virtually dust free sanding experience. Abranet Ace offers high cut rate on especially harder wood types. Ultimac Ligno combines fast cut & long life. The hourglass pattern ensures optimal cutting performance with consistent results.

ABRASIVE RECOMMENDATIONS

P80 – P180



» Abranet® Ace

» Ultimac® Ligno



» Abranet® Ace

» Ultimac® Ligno



» Abranet® Ace

» Ultimac® Ligno

FURNITURE – INTERMEDIATE SANDING



When painting wooden surfaces such as cabinet doors, dining tables or similar, you want to have a smooth finish when it is time to apply that final coat of paint. To ensure this, every layer of paint must be flawless. No matter how careful you are, there is always a risk for bubbles in the surface, or particles such as dust sticking to the wet paint. The solution is to sand the surface between applying coats of primer and paint. With Mirka's solutions, intermediate sanding can be fast, easy, and dust-free.

SAND THE SURFACE

After each coat has dried, sand the entire surface with a Mirka® DEOS II or Mirka® DEROS II orbital electric sander. For best results, we recommend using Mirka abrasives such as Abranet®, Ultimax® Ligno or Galaxy. To avoid too aggressive material removal, with a risk of sanding through the paint layer, it is best to use medium grit abrasives (240-400). Using a dust extractor when sanding helps minimize dust particles in the air. Your health and the paint layers will thank you later.

FURNITURE

INTERMEDIATE SANDING

Fine sanding/denibbing of primer or sealer before applying the top coat.



WIDE BELT SANDING

» A stearate coated product minimizes the risk of clogging and increases the life time of the product.

ABRASIVE RECOMMENDATIONS

P240 – P600

HARD PRIMER / SEALER



» Ultimax®
Black



» Ultimax®



» Gold Max

SOFT PRIMER / SEALER



» Ultimax®
Black



» Gold Max



DISC SANDING

» Using Mirka Net abrasives reduces the risk of dust contamination in the process and increases the life time of the product.

ABRASIVE RECOMMENDATIONS

P240 – P600



» Abranet® Ace



» Ultimax® Ligno



» Abranet®



» Ultimax® Ligno

FURNITURE – TOP COAT/HIGH GLOSS SANDING

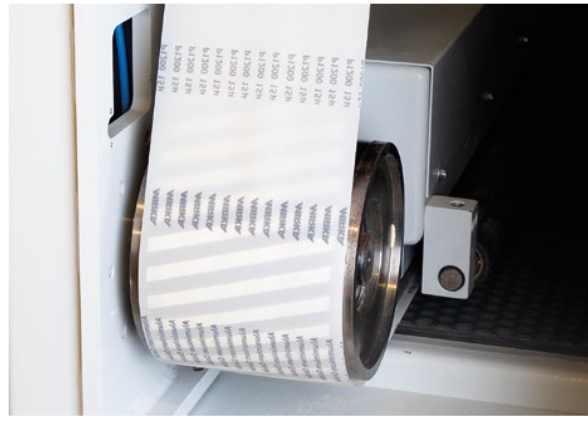


With Mirka's solution for high gloss polishing of wooden surfaces, you can remove imperfections, such as scratches and orange peel, and achieve a deep, glossy shine. With the right combination of abrasives, polishes, and tools the job will be quick, easy and virtually dust-free, meaning you can save money as well as time spent on sanding and cleaning up.

FURNITURE

TOP COAT/ HIGH GLOSS SANDING

Fine sanding and defect removal of high gloss top coats prior to polishing.



BELT SANDING

» A film belt creates an uniform and smooth finish which is critical prior to polishing.

ABRASIVE RECOMMENDATIONS

P800 – P1500

HARD PAINTS / LACQUERS



» Ultimax® Black



» MI231A

MEDIUM HARD PAINTS /
LACQUERS



» MI231A



DISC SANDING

» A film product levels the surface and creates a uniform finish. By using the fine and smooth Abralon soft product as a last step the process time is reduced.

ABRASIVE RECOMMENDATIONS

P800 – P3000

Dry sanding
(up to 2000)

Damp
sanding



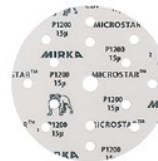
» Mirka® Galaxy

» Iridium Soft

» Abralon®

Dry sanding
(up to 2000)

Damp
sanding



» Microstar®

» Iridium Soft

» Abralon®

Wood Sanding Solution

Top coat/High gloss sanding and polishing process

ACHIEVE A HIGH-GLOSS SHINE

SANDING



STEP 1

To remove scratches and imperfections, sand the surface with a Mirka® DEROS II electric sander and Microstar® P1200 abrasive until surface is completely matte.



STEP 2

If there is heavy orange peel, sand the surface with Abranet® Ace P1000. Before switching to next step make sure both abrasive and surface are wet.

DAMP SANDING



STEP 3

Start damp sanding with Abralon® P3000. To protect the sander and dust extraction system from moisture, turn off the dust extractor or use a Mirka Vacuum Block Disc.

POLISHING



STEP 4

Make sure the surface is completely sanded, then wipe it off with a micro-fiber cloth. Polish the surface with the Mirka® POLAROS RP 600 polisher, Polarshine® 10 and a Yellow Lambswool pad.



STEP 5

Optional step: For an even deeper gloss, polish a second time using Polarshine 10 and Yellow or black waffle pad.

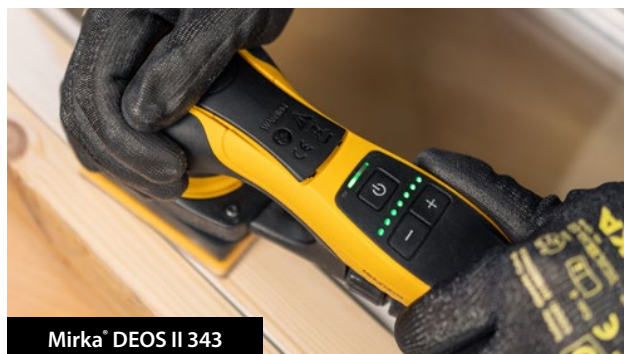


FURNITURE FRAME SANDING

FURNITURE – FRAME SANDING



Mirka® DEOS II 353



Mirka® DEOS II 343

Door and window frames can be a challenge to sand, due to the difficult shapes and working positions. With Mirka tools, sanding even trickier parts can be effortless and efficient. Mirka offers a variety of power tools that suit the delicate and careful process of frame sanding.



Mirka® DEOS II 353
81 x 133 mm, orbit 3 mm



Mirka® DEOS II 343
75 x 100 mm, orbit 3 mm

Mirka® DEOS II 353

Mirka® DEOS II 353 is a direct electric orbital sander ideal for use in woodworking and decorative painting. Perfect for doors and windows but also for corners, edges, hard-to-reach work surfaces and tight spaces.

At only 10 cm high, the tool's compact and very low profile gives a high manoeuvrability and helps deliver a precise and efficient sanding performance. The ergonomic design, low vibrations and low noise level ensures that the sander can be used comfortably for long periods without fatigue.

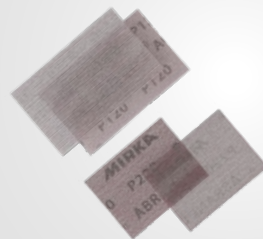
The long-life and high efficiency brushless motor of the Mirka DEOS II maintains a consistent speed and can effortlessly tackle also demanding sanding jobs. As part of the Mirka dust-free sanding solution, the Mirka DEOS in combination with a Mirka dust extractor enables efficient dust-free sanding. Bluetooth connectivity allows seamless integration with the myMirka app for vibration exposure monitoring, as well as other additional sander settings and features.

Mirka® DEOS II 343

The Mirka® DEOS II 343 is the most compact sander in the Mirka® DEOS II range of electric orbital sanders. It is designed for sanding windows, doors and frames and performing correction work on wood filler, especially in hard-to-reach places or performing detail work.

The tool's compact size, light weight and optimized ergonomics give it high maneuverability and help deliver a comfortable, precise and efficient sanding performance, providing clean dust-free sanding when combined with a Mirka® dust extraction system.

When sanding door and window frames, we recommend choosing the Mirka Abranet range of products. Ground-breaking **Abranet®** abrasive is fully formed out of mesh, meaning the entire surface area can be used for dust extraction.





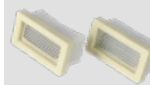
For a complete **dust-free sanding process**, simply connect a powerful Mirka sander to the dust extractor with the supplied hose and begin sanding with Mirka's effective abrasives.



1 MIX9990011



2 MIX1214071



3 MIX1212131

Mirka® DEXOS Accessories (1217/1230)

- DEXOS Remote Control
- Filter for DEXOS
- Cooling Air Filter kit for DEXOS
- Mirka Sleeve + Cable CE 230 V + Hose 4 m
- Mirka Sleeve + Cable CE 230 V + Hose 6 m
- Mirka Sleeve + Cable CE 230 V + Hose 10 m

DEXOS 1217 M AFC

- Dust Bag Fleece, five-pack

DEXOS 1230 M AFC

- Dust Bag Fleece, five-pack
- Workstation (for DEXOS 1230)



4 MIE6515511



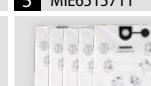
5 MIE6515711



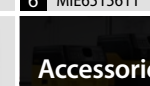
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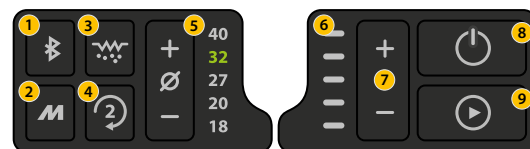
Accessories

Mirka® DEXOS AFC DUST EXTRACTOR

With a powerful **brushless electric motor** and numerous clever features, the Mirka® DEXOS is quiet, impressive, and designed to facilitate your work. It offers a lot of options, but without compromising user-friendliness.

Handling the DEXOS could not be easier. The dust extractors are easy to manoeuvre and clean, and they are compatible with Mirka's cases, toolboxes, and hoses. When transporting your DEXOS, you can secure it in place with the **built-in brake pedal**. Additionally, you can store the included 4-metre hose and cables in the compartment under the top lid.

Power level is easily selected from the backlit **control panel** on the front of the dust extractor, together with hose diameter adjustment, **auto-start** functionality on two sockets and Bluetooth pairing. A configurable **multi-function button** can be customised via the myMirka app.



- Bluetooth pairing
- Multifunction button
- Automatic filter cleaning
- Autostart from socket 2
- Hose size setting (+ diam.)
- Power level indicator
- Power level adjustment
- On/Standby (Autostart)
- Start button



MODEL	DEXOS 1217 M AFC	DEXOS 1230 M AFC
Mains voltage	220–240 VAC	220–240 VAC
Power/Total mains load	1200 W/3600 W	1200 W/3600 W
Max. airflow (l/s)	* 42 l/s	* 42 l/s
Max. Vacuum (kPa)	25 kPa	25 kPa
Sound pressure level LpA	77.7 dB(A)	77.7 dB(A)
Weight	13 kg (28.7 lbs)	14 kg (30.9 lbs)
L x W x H	481 × 332 × 480 mm (19 × 13 × 19 in)	529 × 372 × 567 mm (21 × 15 × 22 in)
Container capacity	17 l	30 l

Product codes (1217 M AFC/+ 4 m hose/+ hose, sleeve and cable): MIX12171220/MIX12171221/MIX12171222. **(1230 M AFC/+ 4 m hose/+ hose, sleeve and cable):** MIX12301220/MIX12301221/MIX12301222. *Maximum airflow model range may vary between markets.

The dust extractors are suitable for both wet and dry use and include **two power outlets** for tools. The dust bag can be changed or removed without the need to unclip storage boxes fastened on top of the dust extractor. The Mirka DEXOS features **automatic filter cleaning** and a **push-to-clean** function can be triggered. In addition, a wearable remote-control bracelet can toggle functions and relay information to the operator about hot motor/PCB alarm and shut-down causes.

FURNITURE – PROFILE SANDING



Sanding complex parts can be done more efficiently and effortlessly by choosing Mirka abrasives. When sanding profiles, corners, and curved surfaces, for example, ceiling mouldings, door mouldings and floor mouldings, we recommend using either Goldflex Soft or Mirlon Total®, depending on the type of surface and depth of contours you are going to sand. All concave, convex or the most complex shapes take shape with ease.

MIRLON TOTAL®

Mirlon Total® is a Total Coating™ Technology fibre abrasive that is easy to use on profiled surfaces and produces an excellent finish, thanks to its special structure. It produces a dense scratch pattern and features an open and flexible structure. It has strengthened fibres which make it strong and long-lasting. Mirlon Total is ideal for matting of surfaces and creates an excellent base for the next lacquer layer.

We recommend using Mirlon Total for intermediate sanding of painted surfaces since it is more flexible and compliant. The more profiles, the greater benefit you will have by using Mirlon Total. The most coarse grit available in 360 grit.

the surface. The special stearate coating prevents clogging.

Goldflex Soft offers a wider grit range compared to Mirlon Total. It can be used for intermediate sanding of painted surfaces when using finer grits than P240. More coarse grits than P180 can be used, if you want to remove paint, larger irregularities, and putty. Goldflex Soft has a flattening effect, which means that it removes surface unevenness better and more efficiently. Use Goldflex Soft on round/curved surfaces and Ultimax Ligno on flat surfaces.

GOLDFLEX SOFT

The soft and flexible Goldflex Soft has been developed for sanding profiled surfaces and irregular, difficult-to-reach details by hand. The foam base is grip friendly and applies pressure evenly, which reduces the risk of sanding through

FURNITURE

PROFILE SANDING

Sanding of profiles and hard to reach areas.



NARROW BELT SANDING

» A stiff cloth product, PES or X-type is recommended for sanding flat profiles while a soft cloth product, J-type is recommended for contoured surfaces. The Abranet Max net backed product will increase the life time of the belt due to its cool cut and long life.

ABRASIVE RECOMMENDATIONS

STIFF



» Abranet® Max



» Hiolit XO

FLEXIBLE



» Alox



MACHINE/HAND SANDING

» Mirka orbital sanders in combination with net products enables an efficient and dust free sanding experience. A nonwoven product is easy and effective to use for denibbing applications.

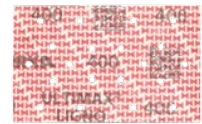
ABRASIVE RECOMMENDATIONS

MACHINE SANDING

For flat surfaces



» Abranet® Ace



» Ultimax® Ligno

HAND SANDING

For round surfaces



» Goldflex Soft



» Mirlon Total® VF

Wood Sanding Solution

Profile sanding process

HAND SANDING



STEP 1

Start hand sanding with either Goldflex Soft P150–P320 grit or Mirlon Total® VF 360 strips to remove imperfections in the surface.



STEP 2

The worse the surface, the coarser the abrasive grit starting point must be. If the surface is in better shape, we recommend you start with a finer grit.



STEP 3

Apply pressure into the profiles: Press Mirlon Total VF 360 into the profiles until you have reached the desired result.



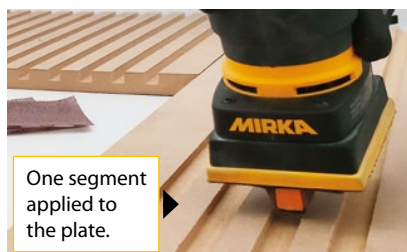
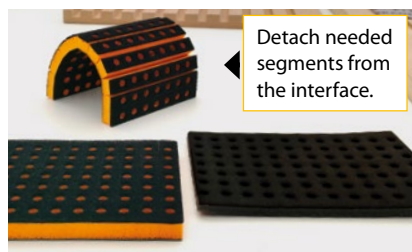
STEP 4

If you choose Goldflex Soft you can start sanding with P150, continue applying the base coat and intermediate sand with P320.

..AND...

If you are using a coarser grit than P240, we recommend applying a base coat and sanding between the steps.

MACHINE SANDING WITH GROOVE INTERFACE



Sanding of door and window mouldings

The Groove Interface is the ideal solution for sanding door and window mouldings. Groove **Medium** and **Soft** interfaces have 12 pre-cut segments of 12.5 mm.

Depending on the width of the mouldings for sanding, users can simply **detach** the segments required from the interface, **apply** them to the plate of the

Mirka® DEOS 343 CV 75 x 100 mm electric sander and **add** Abranet® or Abranet® Ace net abrasive strips.

The Profile Foam Interface

MACHINE SANDING

Process for Removing Old Paint and Preparing the Surface

This process ensures a smooth, consistent surface with minimal effort, delivering professional results every time.



Set Up the Mirka® DEOS II 353 Electric Orbital Sander

Designed with great ergonomics, a low weight, and a low-profile design, the DEOS 353 is easy to handle and minimizes user fatigue during sanding.



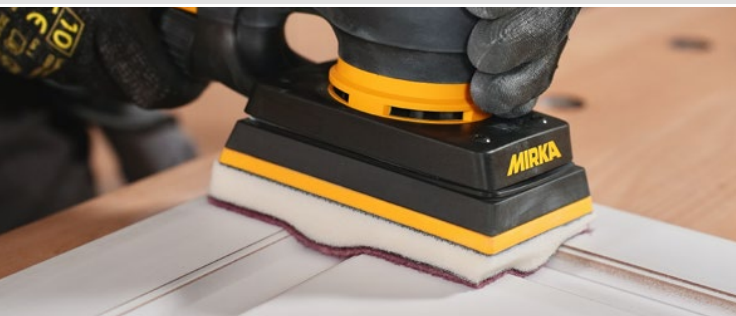
Attach the Profile Foam Interface

Secure the foam sanding pad directly to the sander's grip pad for a reliable fit. The unique Mirlon Total surface ensures consistent sanding and optimal performance.



Sand Evenly Across the Surface

The foam pad adapts to grooves, profiles, and contours, reaching depths of up to 18 mm. Move the sander evenly across the surface to clean, roughen, and level it effectively.



Achieve Fast, Efficient, and Dust-Free Results

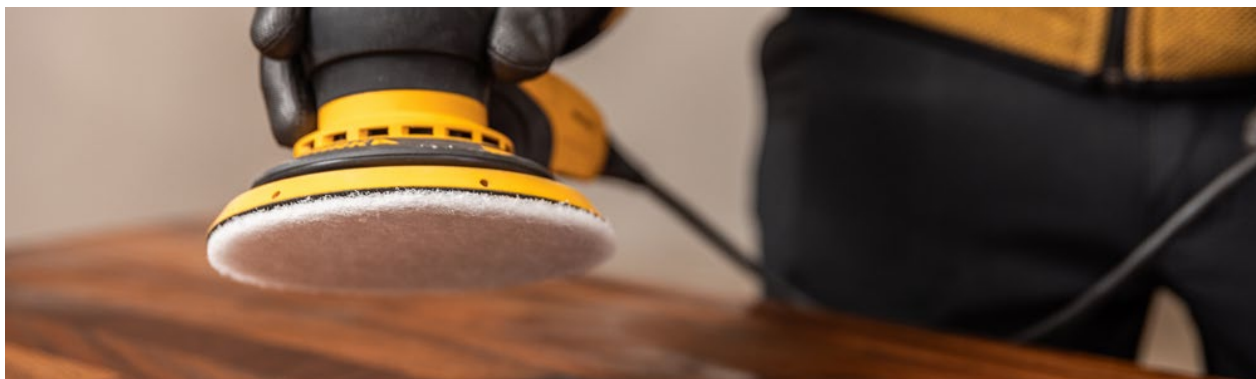
The sander and pad combination delivers a quick and efficient process while maintaining a dust-free workspace, thanks to superior dust extraction capabilities.



Prepare for the Next Layer

Once the old paint is removed and the surface is even, it's clean and ready for the next layer of paint or lacquer.

FURNITURE – WOOD OILING



When painting wooden surfaces such as cabinet doors, dining tables or similar, you want to have a smooth finish when it is time to apply that final coat of paint. To ensure this, every layer of paint must be flawless. No matter how careful you are, there is always a risk for bubbles in the surface, or particles such as dust sticking to the wet paint. The solution is to sand the surface between applying coats of primer and paint. With Mirka's solutions, intermediate sanding can be fast, easy, and dust-free.

HOW TO PREPARE A WOODEN SURFACE BEFORE OILING

Oiling woodwork is for protecting the wood and for enhancing the natural grain of the surface. It gives the wooden surfaces a natural sheen and texture and makes the grains stand out. Wood oiling is widely used for a variety of high-end finish applications, such as maintenance of countertops, oiling furniture, refinishing kitchen countertops and recoating old surfaces. Prior to oiling, the wood is sanded with a correct grit abrasive, which enables an excellent and consistent finish.

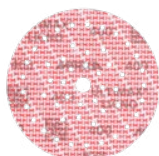
MIRKA OILING PADS

For wood oiling with a high-end finish, Mirka offers the Mirka Oiling Pads. They ensure a clean and easy application of oil on the wooden surface.



Abranet®
Sanding abrasive

Abranet features a net structure instead of the conventional paper backing. This results in extremely efficient on-tool dust removal that improves both the work quality and the working environment.



Ultimax® Ligno
Sanding abrasive

The new Mirka Ultimax® Ligno is tailored for wood sanding applications. Fast and even cut thanks to special hourglass abrasive pattern. Good resistance to clogging. Specially developed latex impregnated paper for flexibility and edgewear resistance.



Mirka oiling pads
for wood oiling

Use vacuum block disc or turn of the dust extractor, when using oiling pads.



Mirka® DEROS II
150 mm

Oiling pads for wood oiling



FURNITURE POLISHING



MACHINE POLISHING

» The mirka polishing system is very efficient and user friendly. The correct combination of compound and pad ensures an efficient process and superior gloss.

POLISHING COMPOUND RECOMMENDATIONS

STEP 1 – BUFFING

MEDIUM HARD
PAINTS /
LACQUERS



» Polarshine® 10 + Lambswool pad pro, yellow

STEP 2 – FINAL GLOSS



» Polarshine® 10 + Foam pad, yellow waffle

HARD PAINTS
OR LACQUERS



» Polarshine® 35 + Twisted wool pad



» Polarshine® 10 + Foam pad, yellow waffle

FLOORING

NEW PRODUCTION

Industrial belt sanding process for new parquet production.



SURFACE SANDING

» A product with selective coating enables a longer life due to less clogging and burning compared to a conventional product.

ABRASIVE RECOMMENDATIONS

P80 – P180



» Ultimax®



» Jepuflex® Antistatic



INTERMEDIATE SANDING

» A stearated product resists clogging and ensures a longer life time of the abrasive belt. Less down time in production.

ABRASIVE RECOMMENDATIONS

P240 – P320



» Ultimax® Black



» Gold Max

FLOORING

FLOOR REFURBISHMENT

Sanding process for refurbishing wooden floors.



REMOVAL OF LACQUER/OIL

BELT SANDING

» Heavy stock removal requires a tough cloth or paper backing to resist tearing.

ABRASIVE RECOMMENDATIONS

P36 – P80



» Hiolit XO

DISC SANDING

» A net backed abrasive enables a longer life due to less clogging and burning to a conventional product. The Abranet Ace HD net backed product is efficient for removing old lacquer or oil and the product has a good tear resistance.

ABRASIVE RECOMMENDATIONS

P40 – P80



» Abranet® Ace HD



» Mirka® Galaxy

FLOORING

FLOOR REFURBISHMENT

Sanding process for refurbishing wooden floors.



SANDING PRIOR TO COATING

» The selective coating technology of Ultimax ensures a good cut and long life time of the disc.

ABRASIVE RECOMMENDATIONS

P80 – P180



» Ultimax®



» Jepuflex® Antistatic

INTERMEDIATE SANDING

» Net backed abrasives ensures a long life time of the discs. Abranet Ace offers a long life time to the product when sanding between coats.

ABRASIVE RECOMMENDATIONS

P180 – P320



» Abranet® Ace



» Ultimax®



» Mirka® Galaxy

SOLID SURFACE – SANDING AND FINISHING



MIRKA SOLUTIONS FOR SOLID SURFACE

Solid surface materials are widely used in interior and architectural design in both homes, public and commercial spaces, for a variety of different applications, such as kitchen countertops, reception desks, washbasins and shower walls. Solid surfaces often combine a resin base with fillers and pigments.

With Mirka's solutions for solid surfaces, you can achieve the desired result without hassle, whether it is a deep matte, a satin or a shiny high gloss finish. By pairing our award-winning tools with our dust extractors and innovative abrasives, you get a solution that is dust-free, reducing time spent on cleaning up. Depending on the size of the surface, we recommend using either the Mirka® DEROS II random orbital sander or the Mirka® LEROS-S sander for large surfaces.



Mirka® DEROS II 750
175 mm, orbit 5 mm



Mirka® LEROS-S 950CV
225 mm, orbit 5 mm



Mirka® DEXOS 1217 M AFC and 1230 M AFC



Mirka® AROS-B 150NV (Cordless)
32 mm, orbit 5 mm

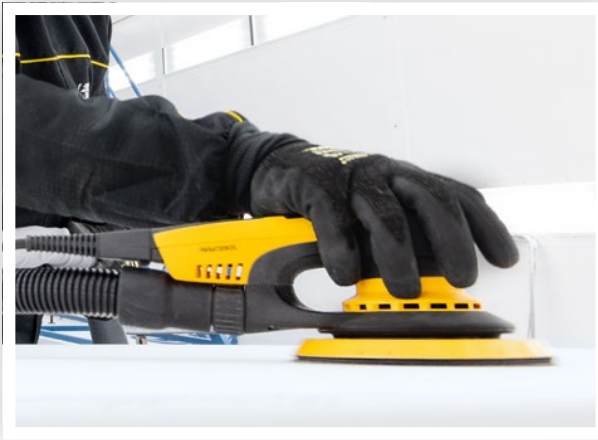


Mirka® POLAROS RP 600
Polisher 150 mm

SOLID SURFACE

SANDING AND FINISHING PROCESS

Sanding and finish process for solid surface materials.



LARGE AREAS

SANDING OF LARGE SURFACES

» Ceramic grains of Abranet Ace and Mirka Galaxy gives a long lifetime and great cut. Abralon is ideal to be used as a last step to achieve a smooth finish.

ABRASIVE RECOMMENDATIONS

P80 – P4000



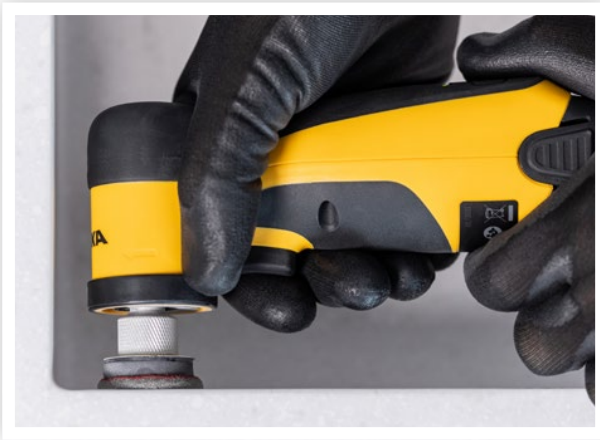
» Abranet® Ace



» Mirka® Galaxy



» Abralon®



SMALL AREAS

SANDING OF HARD TO REACH PLACES

» 34 mm discs + battery sander AROS-B for hard to reach places to create an even finish. Ultimax for sanding away glue residue from joints or removing defects left from the casting process.

ABRASIVE RECOMMENDATIONS

P40 – P4000



» Abranet®



» Ultimax®



» Abralon®

Wood Sanding Solution

Sanding and finishing process



Mirka® DEROS II 650
150 mm, orbit 5 mm

MATT FINISH



STEP 1

- Use Mirka® Galaxy, 180 grit with Mirka® DEROS II 650.
- Speed 8000 rpm



STEP 2

- Sand in both directions
- Clean the surface



STEP 3

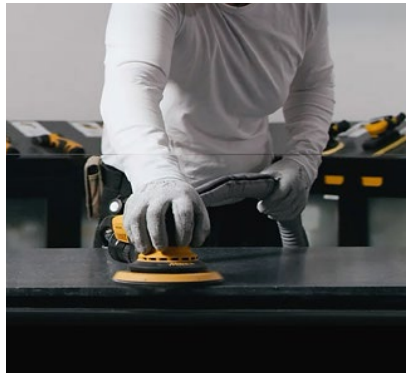
- Use Galaxy 320 grit
- Clean the surface

SATIN FINISH



STEP 4

- Use Mirlon® Total VF 360 with a net interface
- Clean the surface



CONTINUE AFTER MATT FINISH

- For a satin finish add Mirlon® Total XF 800 with a net interface
- Clean the surface

Wood Sanding Solution

Sanding and finishing process



Mirka® DEROS II 650
150 mm, orbit 5 mm

HIGH GLOSS FINISH



STEP 1

- Use Mirka® Galaxy 180 with Mirka® DEROS II 650.
- Speed 8000 rpm



STEP 2

- Sand in both directions
- Clean the surface



STEP 3

- Use Galaxy 320 grit
- Continue with Galaxy 500 grit
- Clean the surface



STEP 4

- Start with Abralon® J3 1000
- Continue with Abralon® J3 3000



STEP 5

- When damp sanding with Abralon, turn off the dust extractor
- Clean the surface



STEP 6

- For a high gloss finish use Polarshine® 10, with a Lambswool Pad PRO and Mirka® POLAROS RP 600.

Wood Sanding Solution

Large solid surface process



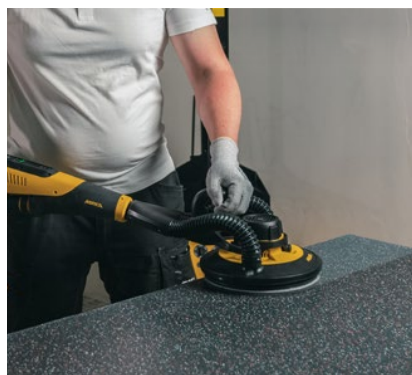
Mirka® LEROS-S 950CV
225 mm, orbit 5 mm

When sanding a large solid surface, we recommend using the Mirka® LEROS-S 950CV. It is a unique brushless sander with a highly flexible sanding head, designed for effortless sanding of large wood and composite surfaces in manufacturing.

Easily controlled, the LEROS-S is light (only 3,2 kg), balanced

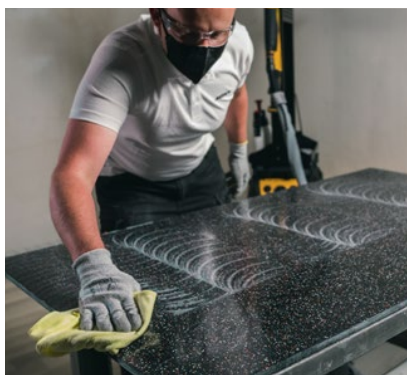
and easy to handle, and its large 225 mm sanding pad with a 5 mm random orbit makes it possible to work faster with a more even result for a high surface finish quality. With two dedicated grip points, you have secure control of the sanding process – and when you need more reach, the LEROS-S can also be fitted with an extension.

MATT/SATIN/GLOSSY FINISH



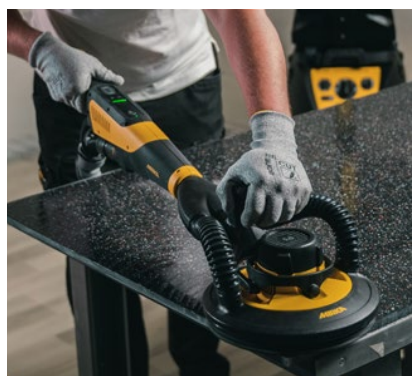
STEP 1

- Use the Mirka® LEROS-S 950CV and start sanding with Abranet or Abranet Ace® 120 grit to level out the surface.
- Continue up to 320 grit to eliminate any imperfections.



STEP 2

- Make sure to sand the entire surface and to wipe the surface between different grits.
- Switch to damp sanding with Abralon® J3
- Make sure both abrasive and surface are wet.



STEP 3 (MATT/SATIN FINISH)

- For a matt or satin finish sand once with 360 grit (matt) or 500 grit (satin).



STEP 4 (GLOSSY FINISH)

- If you want a glossy finish, damp sand with Abralon® up to 4000 grit.



SOLID SURFACE PROCESS FOR ABRANET

MATT FINISH

Use following grits of net abrasives. Finish with Abralon® (damp).



SATIN FINISH

Use following grits of net abrasives. Finish with Abralon® (damp).



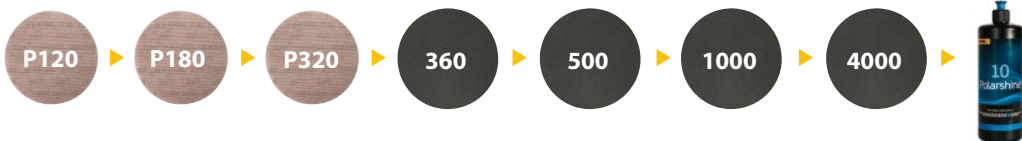
GLOSSY FINISH

Use following grits of net abrasives. Finish with Abralon® (damp).



HIGH GLOSS FINISH

Use following grits of net abrasives. Continue with Abralon® (damp) and finish with Polarshine® 10 and Lambswool pad.



FOR GALAXY

MATT FINISH

Use following grits of Galaxy. Finish with Mirlon VF.



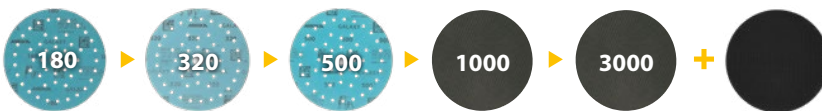
SATIN FINISH

Use following grits of Galaxy. Finish with Mirlon VF and Mirlon Total XF, together with Net interface and backing pad.



GLOSSY FINISH

Use following grits of Galaxy. Finish with Abralon (damp) together with vacuum block disc.



HIGH GLOSS FINISH

Use following grits of Galaxy. Continue with Abralon together with vacuum block disc. Finish with Polarshine 10 and Lambswool pro pad.



Backing pad (8292607011/Backing Pad MF) and **pad saver** (8295600011/Pad Saver MF) to be used with the Mirka® Galaxy abrasive.





POLARSHINE® POLISHING COMPOUND

Mirka offers a range of **HIGH-QUALITY POLISHING PRODUCTS** that are designed to remove imperfections and enhance the surface finish of various materials.

The polishing products are efficiently removing defects like scratches, swirl marks, oxidation, and other imperfections from the surface. They strike a balance between cutting power and fine polishing, enabling users to achieve a smooth and glossy finish.

The polishing products are easy to wipe off, minimizing cleanup time. Mirka's polishing products are best used together with Mirka's collection of polishing tools.

With the multiple grit options, Mirka allows users to select the appropriate polishing product for their desired level of cutting and polishing. Finer grits are used for light polishing and achieving a high-gloss finish, while coarser grits are more aggressive and suitable for heavy-duty polishing. The polishing products are engineered to deliver consistent performance, ensuring high-quality and reliable results.

Polarshine products are known for their exceptional polishing performance, ease of use, and versatility. These compounds are commonly used in automotive, marine, and industrial applications to restore and enhance the appearance of surfaces.



POLARSHINE® grade

POLARSHINE® 45	COARSE		FINE
POLARSHINE® 35	COARSE		FINE
POLARSHINE® 25	COARSE		FINE
POLARSHINE® 20	COARSE		FINE
POLARSHINE® 15	COARSE		FINE
POLARSHINE® 12 BLACK	COARSE		FINE
POLARSHINE® 12	COARSE		FINE
POLARSHINE® 10	COARSE		FINE
POLARSHINE® 8	COARSE		FINE
POLARSHINE® 5	COARSE		FINE
POLARSHINE® 3 FINISHING, ANTISTATIC WAX	COARSE		FINE
POLARSHINE® LIQUID WAX	COARSE		FINE

GUIDE FOR EFFECTIVE WOOD SANDING





EFFECTIVE WOOD SANDING

ACHIEVING the desired final result with any surface treatment is affected by a wide variety of factors. For example, the choice of sanding material plays a vital part in the overall process.

By choosing the correct type of sanding material and handling it correctly, you can ensure that you achieve an optimal sanding result, as well as the best possible lifespan for the sanding material itself.

The aim of this guide is to outline the construction of various sanding materials and to highlight the differences between products in an effort to help you achieve the

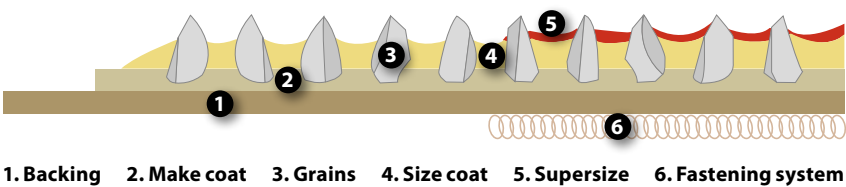
easiest and most effective sanding procedure for each application.

WHEN SANDING IS PERFORMED CORRECTLY, IT WILL ENSURE:

- an even, smooth surface finish
- an accurate thickness and flatness
- minimal problems due to fibre rising
- a better result due to less dust on the surface
- cost savings, both on sanding products, as well as coatings and lacquers



SANDING MATERIAL CONSTRUCTION



Backing material

➤ The backing material not only carries the abrasive layers, it must also transfer the sanding power through to the surface. This means that larger abrasive grains demand more power and, therefore, also need a stronger backing material. For example, a backing material made of cloth-woven thread is often stronger and more stable than a backing material made of paper. Cloth can be either rigid or flexible depending on the construction and, nowadays, there are also strong paper backings specially developed for challenging sanding applications.

Cloth backings

Type	Weight	Application	Example product
F	Flexible cotton cloth	Profile sanding	Alox
J	Soft cotton cloth	Profile sanding	Hiolit JCA2A0
X	Stiff cotton cloth	Coarse sanding	Hiolit XO (P100–P240)
PES	Polyester cloth	Extra coarse sanding	Hiolit XO (P36–P80)

When sanding between coats or around profiles, it is important to use a material that is both light and has a flexible backing. Flexibility enables the sanding material to follow edges and profiles, while the light paper provides a smooth surface for the abrasive grains which, in turn, results in a finer surface finish. For paper, the weight of the backing material is in direct proportion to its strength and stiffness.

Paper backings

Type	Weight	Application	Example product
A-paper	90 g/m ²	Manual profile sanding	Goldflex
B-paper	110 g/m ²	Manual or light machine sanding	Gold Proflex
C-paper	125 g/m ²	Machine sanding	Gold
D-paper	150–180 g/m ²	Coarse disc sanding	Deflex
E-paper	220–250 g/m ²	Fine belt sanding	Gold Max
F-paper	270 g/m ²	Belt sanding, coarse disc sanding	Jepuflex® Antistatic
T-paper	300 g/m ²	Coarse belt sanding	Jepuflex® Antistatic

An anti-static backing paper is used for wide belt sanding applications where it helps to keep the machine and the sanding units clean of dust.

Unique/Special backings

Type	Special features	Application	Example product
Net-backing	Dust-free	Suitable for most wood applications	Abranet® Ace
Non-woven backing	Three-dimensional structure	Sanding of profiles, fine sanding	Mirlon®, Mirlon Total®
Knitted fabric on foam	Foam layer for damp sanding	Superior finish sanding	Abralon®
Paper on foam	Ergonomic structure	Manual profile sanding	Goldflex Soft
Fiber reinforced paper	Strong and durable	Coarse sanding, edge sanding	Coarse Cut
Film backing	Even construction	Superior finish sanding	Microstar®

When a superior surface finish is demanded, film backing can provide a good alternative. The advantage of a film backing is the same as for premium light paper backings – it provides a very even surface for the abrasive grains.

For non-conventional products there are unique backing materials. For example, the revolutionary material found on Mirka's family of Net Sanding products which enables dust-free sanding and features integrated loops for easy fastening. For other products a combination of backing materials is used, such as for Abralon and Goldflex Soft. Coarse Cut is another example – it is made of a special paper backing reinforced with non-woven fibres.

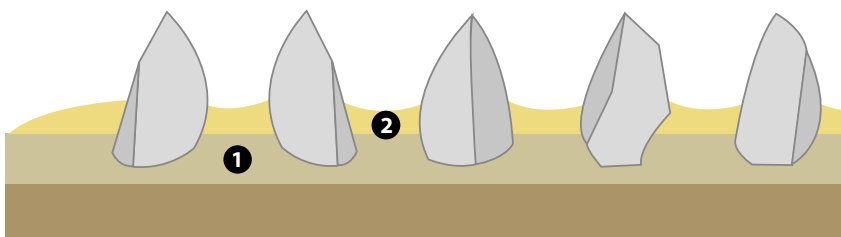
Make coat and size coat



The 'make coat' and 'size coat' are layers of resin. The make coat is the first layer on which the abrasive grains are applied, while the size coat is added to keep the grains firmly in place. All products in the wood sanding range are made with synthetic resins (R/R, resin over resin). The benefits of using synthetic resins, instead of natural glue, include greater product durability and more consistent quality.

A key factor in producing flexible abrasives is the amount of resin that is applied. A low amount of resin results in an aggressive product but with restricted working lifespan. Increasing the amount of resin increases the products working lifespan.

A constant research and development program has enabled Mirka to continually enhance the performance of its products. By optimising the construction of our products we have been able to provide innovative and cost effective solutions that meet the demanding requirements of modern customers.



1. Make coat 2. Size coat

Grains and coatings



When it comes to sanding wood the choice of abrasive grain is vital, both for the final result and to achieve the best possible lifespan from the product.

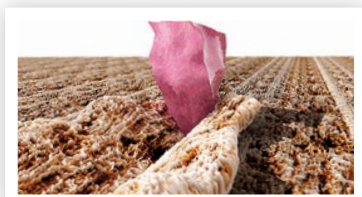
Choosing a sharp grain will achieve a good cut, however if a finer surface finish is essential then another type of grain may be chosen. The grain selection process is also affected by the strength required.

Aluminium oxide

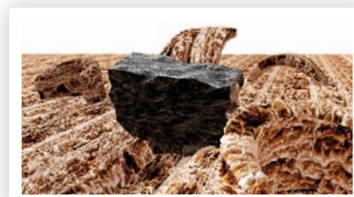
The most common abrasive grain for sanding wood is aluminium oxide – the grains are sharp and tough enough for most applications.

Silicon carbide

Compared to aluminium oxide, silicon carbide is more regular in shape and is not as brittle. The strength of these grains makes it perform well on hard surfaces. It would typically be used to sand materials such as oak and MDF, since fibre boards usually contain hard impurities. In addition, the shape of the silicon carbide grains produces a better surface finish compared to aluminium oxide, which makes them more suitable for intermediate sanding.



» Aluminium oxide grains plough into soft wood types.



» Silicon carbide grains cut through hard wood.



» Wooden surface after sanding with aluminium oxide.



» Wooden surface after sanding with silicon carbide.



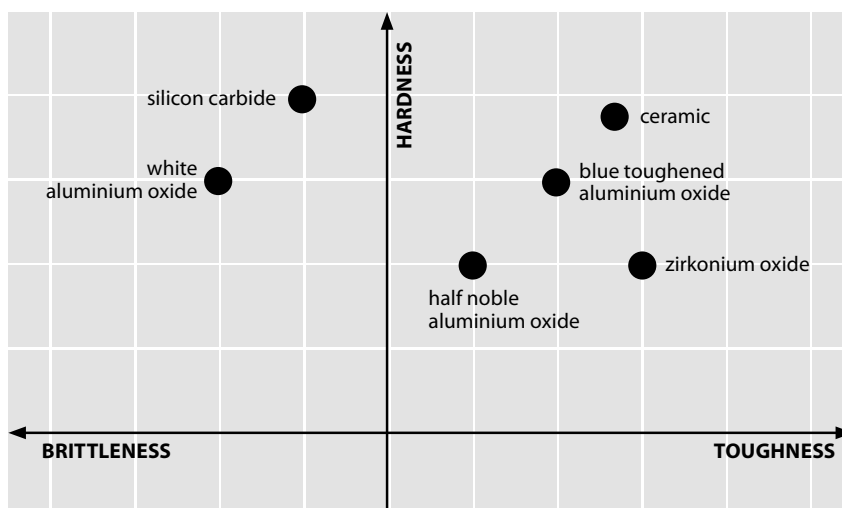
» Aluminium oxide grains.



» Silicon carbide grains.

Standard grain: Qualities and use

Grain	Use
Aluminium oxide	
• White	Paint, lacquer, wood
• Semi-friable	Allround (wood, light metals, all types of sanding machines)
• Blufired	Metal, hard wood and hard coatings
Ceramic	Hard materials and coatings
Silicon carbide	Paint, lacquer, polishing, MDF, veneer, hard wood
Zirkonium oxide	Demanding/aggressive metal sanding



It is important to note that both the surface structure and surface finish is affected by the choice of grains. This means that the colour of the treated surface might vary. The minerals used for Mirka products are synthetic, making them harder and more durable compared to natural sand.

Amount of grains

The performance is greatly affected by the amount of abrasive grains used. For example, less grains results in an open coating which is highly resistant to clogging, whereas more grains produce a closed coating with good stock removal and a smooth surface finish.



» Closed coating



» Semi-open coating



» Open coating



Jepuflex® Antistatic
(closed coating)



Unimax®
(semi-open coating)



Avomax® Antistatic
(open coating)

Grit sizes

Different grit sizes are used for different purposes. Therefore, grit sizes are sorted during manufacture. Abrasive products can be made with different grit size standards such as FEPA, ANSI and GOST. Mirka uses grains according to the FEPA standards – Federation of European Producers of Abrasives. Products produced according to this standard are recognised by the 'P' mark – for example P80. Grain size is determined by passing them through sieves that are measured in 'threads-per-inch'. When it comes to micro-grains, the threads-per-inch measurement is a theoretical amount.

Grit standards

FEPA		ANSI	GOST
FEPA P	Grain size (microns)		
Macro grain sizes			
P12	1815	12	160
P16	1324	16	125
P20	1000	20	100
P24	764	24	80
P30	642	30	63
P36	538	36	50
P40	425	40	40
P50	336	50	32
P60	269	60	25
P80	201	80	16
P100	162	100	12
P120	125	120	10
P150	100	150	8
P180	82	180	6
P220	68	220	5
Micro grain sizes			
P240	58,5 ± 2,0		M63
P280	52,2 ± 2,0	240	M50
P320	46,2 ± 1,5		M40
P360	40,5 ± 1,5	280	
P400	35,0 ± 1,5	320	M28
P500	30,2 ± 1,5		M20
P600	25,8 ± 1,0	360	M10
P800	21,8 ± 1,0	400	M7
P1000	18,3 ± 1,0	500	M5
P1200	15,3 ± 1,0	600	
P1500	12,6 ± 1,0	800	
P2000	10,3 ± 0,8	1000	
P2500	8,4 ± 0,5	1200	

Standards are not directly comparable to each other.

Additional treatments

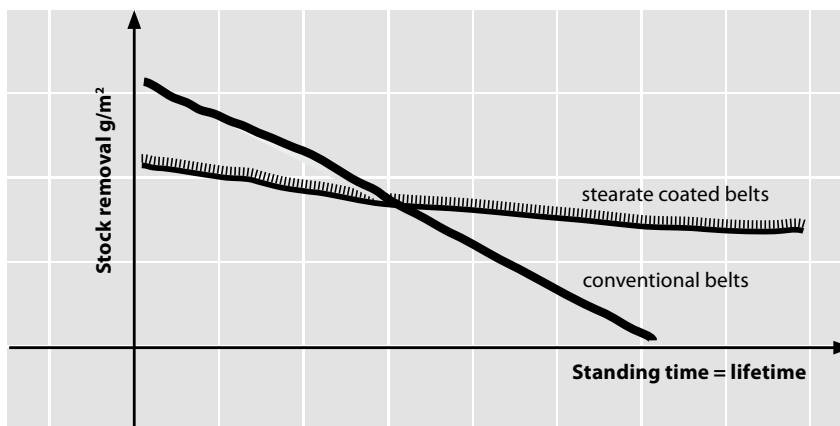
Stearate coating

Some products receive a special stearate coating treatment which is designed to prolong lifespan. Usually the stearate is based on zinc or calcium and is like small flakes applied on top of the abrasive.

BENEFITS:

- As the stearate coating is worn off during use it prevents clogging and gives the product a longer lifespan.
- The stearate reduces the initial cut and, therefore, produces a more consistant surface finish over the lifetime of the product.

Typical Mirka stearated products include Gold, Q.Silver, Abranet and Sica Fine Stearate. Stearated products achieve best results when sanding paint, lacquer and similar surfaces. For coarse sanding with high sanding pressure (for example, wood sanding with wide belts), stearate provides no advantage because it is very quickly worn off.



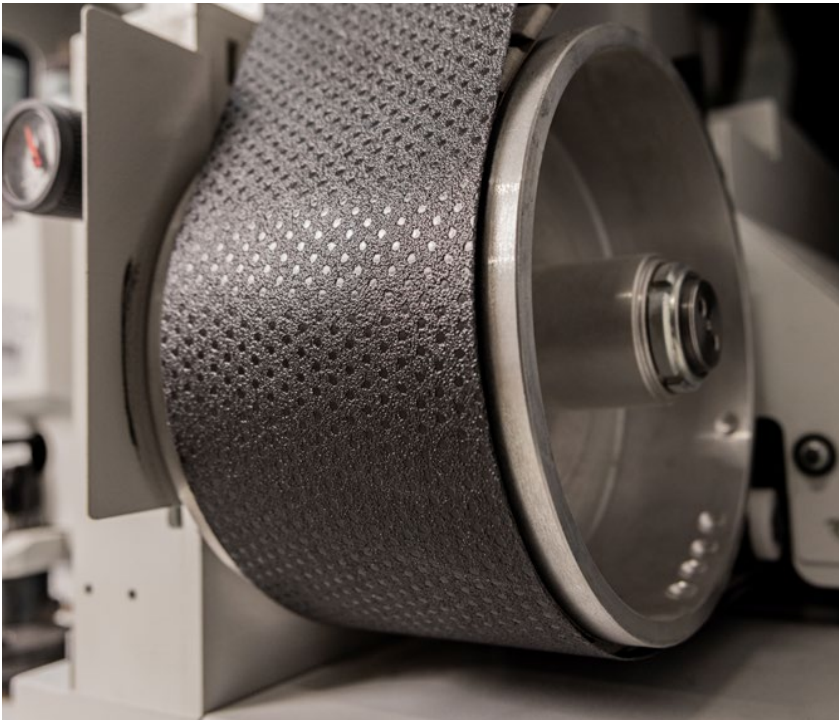
Anti-static treatment

Static electricity load can cause significant dust problems when sanding with a wide belt. However, using anti-static belts prevents dust problems and provides a better work environment. Indeed, reducing the static load of sanding machine belts brings a variety of positive benefits.

BENEFITS:

- A clean, dust-free sanding surface provides a better surface treatment result.
- The machine stays cleaner which makes maintenance easier.
- A low dust load ensures a better work environment.

It is also worth noting that abrasives can have various degrees of antistatic effect. Some products only have an antistatic backing material, while others also include an antistatic bonding system. Dust problems can also be further prevented through the use of an efficient dust extraction system.



Fastening systems



Generally there are two types of fastening systems – ‘PSA’ (Pressure Sensitive Adhesives) and ‘Grip’.

PSA uses an adhesive that is permanently tacky in dry form. With only light contact or hand pressure, PSA’s adhere firmly to a variety of different surfaces which makes them ideally suited for fastening of discs and similar products to an even backing pad.

The Grip fastening system is a Velcro material attached to the backing of the abrasive. The Velcro loops on the abrasive backing joins with the Velcro hooks on the backing pad to fasten the two together. For example, Mirka’s Net Sanding products are constructed with loops integrated into the backing material.





BELT SANDING

IN ORDER TO achieve the desired result and the best possible efficiency when sanding with a wide belt, many factors need to be taken into consideration. For example, the choice of sanding material is very important but other factors, such as the adjustment of sanding units, the choice of sanding speed and the handling, are also essential.

Optimising belt lifespan



The abrasive qualities of any sanding belt are reduced as it becomes slowly clogged while in use. After a sanding belt has been used for a certain period of time, clogging becomes so severe that the risk of causing geometric faults in the sanded material rapidly increases. Further clogging will make the sanded material overheated due to the high friction that occurs when greater pressure is applied to a clogged belt in order to continue achieving stock removal.

Overall sanding costs can be minimised simply by choosing the most suitable product for each sanding operation. That means:

- choosing the right type of grit
- choosing the right type of coating
- using the optimal grit sequence
- avoiding sanding with finer grits than necessary

The lifespan of the belt can be further increased by ensuring that the sanding equipment is correct and used properly:

- choose the right type of sanding machine for each sanding operation
- adjust the sanding machine correctly
- ensure the machine is properly maintained
- check that the dust extraction is adequate

Grit size and sequence

➡ In general, the first sanding belt is used for stock removal, while the following belts are only used for creating an even surface finish. Typically, the first sanding unit consists of a drum made of materials such as steel or hard rubber. The drum, in combination with coarse grit (P36–P100) belts, is ideal for efficient stock removal.

When it comes to producing an even surface finish, sanding units that incorporate soft rubber drums or sanding pads are normally used. In these units the grit range varies from P120–P320.

For sanding between coats or intermediate sanding, grits P320–P800 are most commonly used along with a very soft rubber drum or a soft sanding pad.

When choosing a grit size the recommendation is to select belts that are only one step from each other in grit sizes. For example, P80–P120–P180 are appropriate steps, whereas P60–P120–P220 often results in problems with the surface finish and product lifespan.

Recommended grit size use

Grit size	Use
P24–P80	Coarse sanding, calibration
P100–P320	Medium sanding, wood sanding
P320–P1200	Fine sanding, intermediate sanding

Stock removal per unit

» With a **three belt machine**, the starting point for stock removal per unit can be divided according to the following:

- Station 1 ~ 60%
- Station 2 ~ 30%
- Station 3 ~ 10%

» With a **two belt machine**, the division can be as follows:

- Station 1 ~ 75%
- Station 2 ~ 25%



A good way of controlling whether the adjustments are correct is to check how the belts are used in comparison to each other. If adjustments are made according to the requirements given by the grit sequence and machine, then the belts are used at the same rate.

Maximum removal

 Contact drum unit			 Sanding pad unit		
Grit	Removal (mm / inches)		Grit	Removal (mm / inches)	
P36	Steel/hard rubber roller	< 1.00 / 0.04	P36	–	
P40	Steel/hard rubber roller	< 0.80 / 0.03	P40	–	
P60	Steel/hard rubber roller	< 0.60 / 0.02	P60	–	
P80	Medium rubber roller	< 0.50 / 0.019	P80	< 0.30 / 0.012	
P100	Medium rubber roller	< 0.30 / 0.012	P100	< 0.20 / 0.008	
P120	Soft rubber roller	< 0.20 / 0.008	P120	< 0.15 / 0.006	
P150	Soft rubber roller	< 0.10 / 0.004	P150	< 0.08 / 0.003	
P180		–	P180	< 0.05 / 0.002	
P220		–	P220	< 0.03 / 0.001	
finer		–	finer	< 0.03 / 0.001	

Belt sanding speed

 The general rule is that higher belt speeds result in larger stock removal. A higher belt speed means that both friction heat and load increase on the belt which, in turn, reduces its lifespan. Different types of material require different sanding speeds.

Material and recommendation for sanding belt speed

Material	Lowest sanding speed	Highest sanding speed
Hard wood	15 m/s	24 m/s
MDF	15 m/s	21 m/s
Soft, resinous wood	12 m/s	18 m/s
High gloss lacquer	2 m/s	8 m/s
Synthetic material	9 m/s	21 m/s
Veneer	18 m/s	27 m/s

The values indicate the sanding speed.

Belt joints

 Belt joint performance is a key factor for sanding belts. The joints must be as strong as the actual sanding material and should not be too thick or too thin compared to the sanding material. The belt should also have the right shape and dimension.

Types of belt joints



A-JOINT

 Mostly used for sanding belts made from paper, an A-joint is an overlapping joint without compensation on the sand side, e.g. without interruption in the coating. It produces a uniform sanding belt thickness, even across the joint, and results in an even sanding finish without chatter marks.



B-JOINT

 The most common joint for sanding belts with cloth backing, the B-joint is an overlapping joint with compensation on the sand side. This means that the joint area is free of abrasive material which allows the cloth to overlap without the joint having to be thicker than the rest of the belt. The B-joint is also suitable for special paper products, such as Mirka's Ultimex.



T-JOINT

 Typically used for small cloth belts that require strength and flexibility, a T-joint is cut through the sanding belt without an overlap and the joint is attached with tape on the backing side.



TS-JOINT

 A TS-joint is similar to a T-joint but is different in the way the connecting ends are cut. By using a TS-joint the hinge effect can be avoided. This joint type is most suitable for belts in medium grit sizes and it is most common on cloth-backed belts, although TS-joints can also be found on paper-backed belts.



TT-JOINT

 This is a special joint where the tape is applied on the sanding side making it suited to profile sanding with a sanding pad.



PROBLEM SOLVING

Sanding with hand tools or by hand

POTENTIAL PROBLEMS Here we look at common problems in the sanding process when using hand tools or sanding by hand. It is essential to understand where a problem originates from in order to correct the process.

THE PRODUCT IS CLOGGING

- Check that the paint, lacquer or putty is properly cured.
- A stearated product is usually the best choice for paint or lacquer.
- Use machines with dust extraction and ensure the hole combination on the backing pad is compatible with the sanding product.
- Avoid sanding with grits that are too fine.

VISIBLE FINGER MARKS AFTER HAND SANDING

- Use a hand sanding tool when sanding plain surfaces.
- Use specialty products, such as Goldflex-Soft, for sanding profiled surfaces as they distribute the sanding pressure evenly.

VISIBLE SCRATCHES

- Avoid too big a step between grits.
- Silicon carbide products will usually give a better surface finish.
- Use a random orbital sander.

NOT ENOUGH STOCK REMOVAL

- Aluminium oxide products tend to have a better cut.
- Start with coarse grits and work towards finer grits.

DUST PROBLEMS

- Use Net Sanding products with suitable machines and accessories.

THE PRODUCT IS BREAKING UP

- Use a product with rigid backing material (e.g. Coarse Cut).
- Ensure the machine and sanding material match.
- A worn sanding pad often causes problems.

PROBLEMS WITH PROFILE SANDING

- Use a flexible sanding product (e.g. Carat Flex).
- Use a product specially designed for sanding of profiles (e.g. Mirlon or Goldflex-Soft).
- Try an orbital sander instead of a random orbital sander.



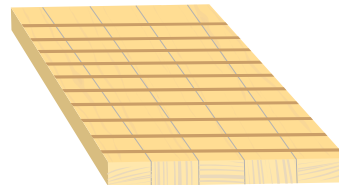
Belt sanding

POTENTIAL PROBLEMS

This section describes typical problems that might occur when using wide belts. It is essential to understand where a problem originates from in order to correct the process.

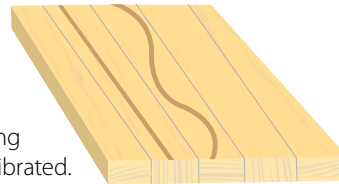
CHATTER MARKS IN CROSS DIRECTION

- Check the condition of the belt joint.
- Is the machine working as it should? In particular, a malfunctioning drum can cause chatter marks.
- Wrong type of sanding unit? A hard drum with a short sanding contact patch is more likely to result in chatter marks, compared to a soft sanding pad.



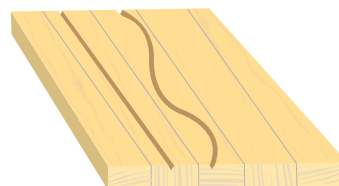
POSITIVE STRIPES (stripes coming out of the wood piece)

- Narrow stripes in a pattern following the belt oscillation? These are normally caused by sharp objects in the work piece which destroy the abrasive. Change the belt and examine the work pieces for sharp objects.
- Wide straight stripes? Typically a problem with sanding drums or pads. Clean the pad and have the drum calibrated.



NEGATIVE STRIPES

- Wide straight stripes? The most common problem is dust on the sanding pad. Clean the pad or, if necessary, change the graphite cloth.
- Narrow straight stripes? It is possible that small wood pieces or dust are stuck to the pressure shoe. Clean the machine.



BELT BREAKAGES: The belt is broken?

- Check the oscillation of the machine and clean inside the machine.
- Check the storage of the belts (see page 'Wide belt storage').
- Avoid too much stock removal. Avoid using clogged belts.
- Check the condition of the belt joint.

UNEVEN SURFACE: The surface feels uneven?

- Steps too big in grit sequence.
- Stock removal with sanding unit which has a sanding contact that is too soft.

SHORT BELT LIFESPAN: Is the belt clogging?

- Avoid too much stock removal per sanding unit – check machine adjustments.
- Make sure you are using the correct product and grit sequence.
- Make sure the cleaning system and the dust extraction is operating correctly.
- Use the whole belt width when sanding.

WIDE BELT STORAGE

BY SIMPLY following some basic recommendations on wide belt storage, you can ensure that the belts remain undamaged and maintain their full working potential.

- Store belts in their unopened packages until they are to be used.
- The belts can be hung horizontally prior to use in order to make handling easier.
- The correct storage temperature is 15–25°C.
- The relative humidity is recommended to be 35–60 per cent in order for the belts to maintain their shape.
- Wide belts should have even moisture over the whole width. Avoid keeping belts hanging close to a cold wall or a heating source. Do not expose the belts to direct sunlight



PRODUCTS FOR WOOD SANDING

Net-backed products	
Film-backed products	
Paper-backed products	
Foam-laminated product	
Non-woven products	
Cloth-backed products	

ABRANET®

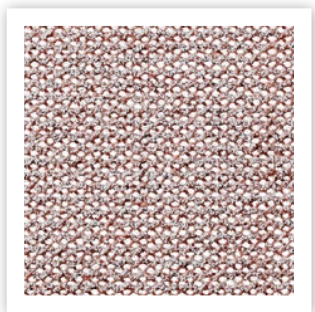
The multifunctional and classic Abranet is especially developed for sanding putty, primers, lacquers, composite materials and a wide range of other materials for industrial use. Abranet combines high performance and a longer lifespan than traditional abrasives, making it a cost-effective solution. Designed for dry sanding by machine or by hand, its true dust-free sanding characteristics result in a cleaner work environment, as well as a better surface finish.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Closed
Colour	Brownish
Grit range	P80–P180, P240, P320–P1000
Backing	PA net
Available as	
READ MORE 	

ABRANET® ACE

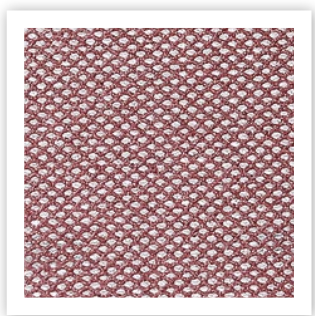
Abranet Ace is developed for tougher and more demanding sanding applications. Because of its optimised net construction and ceramic grains, Abranet Ace offers superior cut and performance for hardwoods (such as beech and oak) and fast cutting on various solid surface materials as well as for cleaning of different industrial rollers. Abranet Ace also works excellent on primer sanding applications, creating an optimal performance and lifetime.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Ceramic (P80–P240)/Ceramic coated (P320–P1000)
Coating	Closed
Colour	Light maroon
Grit range	P80–P240, P320–P1000
Backing	PA net / PES net
Available as	
READ MORE 	

ABRANET® ACE HD

Abranet Ace HD is durable and tough with ceramic grains. The strong net structure resists high wear and tear and the ceramic grain offers superior cutting performance on various surfaces. The improved woven mesh backing increases the lifetime of the abrasive and makes the sanding process faster. The open net construction in combination with a dust extractor enables a dust-free sanding experience.



TECHNICAL SPECIFICATIONS

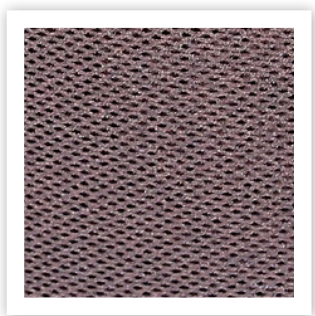
Bonding	Resin over resin
Grain	Ceramic
Coating	Closed
Colour	Brownish
Grit range	P40, P60, P80
Backing	PA net
Available as	 

READ MORE



ABRANET® MAX

Abranet Max is a universal net abrasive suited for a broad variety of sanding applications and is especially developed for wooden surfaces and the wood industry. Due to the net structure it does not easily clog up on resinous wood types or soft materials and the sanded surface stays cooler and avoids burning. The tough aluminium oxide grain gives a high cut rate on harder wood types and materials. The symmetric net structure enables an efficient cut and stock removal. Lower pressure is needed and a more consistent surface finish means minimal quality variations in the process when sanding with Abranet Max. The product offers an extreme long lifetime compared to conventional abrasive belts, which results in fewer belts being needed to complete the job and also cost savings and time efficiency because of less downtime in production due to changing of belts. The product is also well suited for applications where water is used as cooling agent.



TECHNICAL SPECIFICATIONS

Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Closed
Colour	Brownish
Grit range	P80-P240
Backing	PA net
Available as	 

READ MORE



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.



TECHNICAL SPECIFICATIONS		
Bonding	Special resin	
Grain	Silicon carbide	
Coating	Special Abralon® method	
Colour	Grey	READ MORE
Grit range	180, 360, 500, 600, 1000, 2000, 3000, 4000	
Backing	Knitted fabric on foam	
Available as	 	

ALOX

Combining durability with flexibility. An all-round abrasive with excellent cutting qualities, that gives a high quality surface finish.



TECHNICAL SPECIFICATIONS		
Bonding	Resin over resin	
Grain	Aluminium oxide	
Coating	Close	
Colour	Maroon	READ MORE
Grit range	P60 – P240 (400)	
Backing	Cotton cloth	
Available as	 	

AVOMAX® ANTISTATIC

Avomax Antistatic is developed as an all-round product for various wood sanding applications. The open coating makes the product especially efficient for sanding materials that clog easily. The product works well for sanding soft materials and resinous wood types such as pine wood, while ensuring a long life time of the product and smooth surface finish. The strong antistatic paper provides dimensionally accurate and reliable wide belts. Full resin bonding and aluminium oxide grain guarantee a very durable product.



TECHNICAL SPECIFICATIONS

Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Open
Colour	Maroon
Grit range	P40, P60–P240, P320
Backing	Antistatic T-paper/F-paper
Available as	

READ MORE



CARATFLEX

A stearate-coated abrasive for dry sanding applications, Caratflex features fine stock removal, a uniform scratch pattern, a long lifespan and extremely good grain adherence. The backing consists of a flexible, latex-impregnated paper which is ideal for profile sanding.

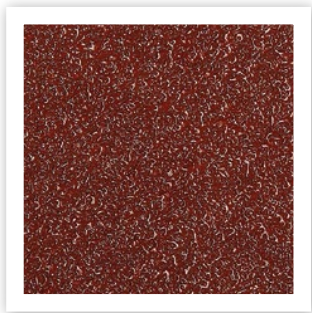


TECHNICAL SPECIFICATIONS

Bonding	Resin over resin/Progressive Bond™
Grain	Silicon carbide
Coating	Semi-open
Colour	Grey
Grit range	P80–P320, P400
Backing	B-paper/A-paper
Available as	

COARSE CUT

A specially reinforced backing material and Mirka's Progressive Bond™ dust-binding technology, make Coarse Cut ideal for all kinds of coarse sanding work. Features include, flexibility on rounded surfaces, excellent edge wear resistance and minimal clogging.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin/Progressive Bond™
Grain	Aluminium oxide
Coating	Semi-open
Colour	Maroon
Grit range	P36–P40, P60–P150
Backing	Specially reinforced F–paper
Available as	
READ MORE 	

Galaxy

The ceramic grains of Mirka® Galaxy are engineered to stay sharp, as new abrasive edges are formed when they break down during the sanding process, enabling Galaxy to continue cutting – from edge to edge. The blue ceramic grains retain sharpness exceptionally well, giving Galaxy a long life and a fast cut. The scratch pattern of finer grits is especially easy to polish out. Galaxy is a multipurpose product, ideal for sanding both soft and hard materials as well as various sub-strates thanks to its excellent clogging resistance and Multifit™ hole configuration.



TECHNICAL SPECIFICATIONS	
Bonding	Low VOC resin system
Grain	Ceramic/Aluminium oxide
Coating	Semi-open
Colour	Blueish
Grit range	40 – 2000
Backing	Polyester film
Available as	
READ MORE 	

GOLD

This durable, all-round sanding material is very well suited for high speed sanding in a multitude of applications. Gold features semi-open and special stearate coatings designed to prevent clogging and pill forming which helps achieve an optimal sanding result.



TECHNICAL SPECIFICATIONS

Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Semi-open
Colour	Gold
Grit range	P80-P800
Backing	D-paper/C-paper
Available as	

READ MORE



GOLD MAX

Gold Max is a stearate coated paper abrasive for intermediate and fine sanding applications. The antistatic E-paper gives good strength and stability to the product. The heat treated aluminium oxide enables a high cut rate even on harder paints. The semi-open special coating minimises clogging and increases the sanding lifetime. The backing ensures a good stability and offers a smooth surface finish. Gold Max is suitable for paint and lacquer sanding.



TECHNICAL SPECIFICATIONS

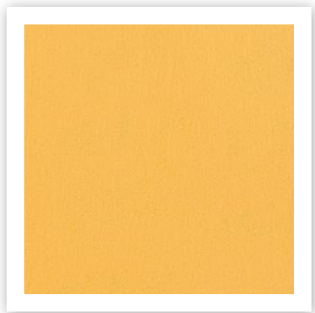
Bonding	Resin over resin
Grain	Blue fired aluminium oxide
Coating	Semi-open
Colour	Gold
Grit range	P240-P800
Backing	Antistatic E-paper
Available as	

READ MORE



GOLD PROFLEX

Gold Proflex is a stearate-coated abrasive paper for dry hand sanding of wood, fillers, paints and lacquers. The backing consists of a flexible, latex-impregnated paper that provides the desired flexibility and conformity in profile sanding operations as well as on flat surfaces. The paper has an anti-slip coating on the back side in order to provide good grip and feel during sanding. Gold Proflex has aluminium oxide grain, which provides a good cut and an excellent scratch pattern.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Semi-open
Colour	Gold
Grit range	P80–P800
Backing	C-paper/B-paper
Available as	 

READ MORE



GOLDFLEX SOFT

The soft and flexible Goldflex Soft has been developed for sanding profiled surfaces and irregular, difficult-to-reach details by hand. Goldflex Soft is especially useful within the automotive industry and the car repair branch. The foam base is grip-friendly and applies pressure evenly, which reduces the risk of sanding through the surface. The special stearate coating prevents clogging. Suitable for dry sanding.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Semi-open
Colour	Gold
Grit range	P150–P320, P400–P1000
Backing	A-latex paper, PE foam
Available as	 

READ MORE



HIOLIT JCA2A0

The flexible cloth backing makes it highly adaptable to contoured workpieces and radiuses, thus optimal for profile sanding, seams, edges and other applications where a flexible abrasive with high edge wear is needed. The semi-open coating, fast cut, long lifespan and high stock removal makes Hiolit JCA2A0 a truly universal abrasive. Hiolit JCA2A0 is especially well suited for soft and hard woods, MDF and soft metals such as brass and aluminium.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Semi-open
Colour	Brown
Grit range	P80–P150
Backing	J-weight cotton cloth
Available as	

READ MORE



HIOLIT XO

Hiolit XO is a semi-open stiff universal abrasive for belt sanding and other machine sanding where it has excellent edge wear resistance and durability. In particular, it produces high quality results on challenging materials – for example, grits 36–80 are suitable for aggressive sanding, such as severe rust damage, as well as other sanding operations where large amounts of material need to be removed.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Blue fired aluminium oxide
Coating	Semi-open
Colour	Maroon
Grit range	P36–P240
Backing	Polyester cloth P36–P80 X-weight cotton cloth P100–P240
Available as	

READ MORE



JEPUFLEX® ANTISTATIC

Jepuflex Antistatic is a high class abrasive product with a wide application area. The focus of the optimisation work has been the sanding of hard wood such as beech, birch and oak. The strong antistatic paper provides dimensionally accurate and reliable wide belts. Full resin bonding and aluminium oxide grain guarantee a very durable product. Silicon carbide grain used in the coarsest grit gives extra strength to the product. These qualities together with a well adjusted coating density make Jepuflex Antistatic a genuine all round product that works well also on metal, plastic and lacquer.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Silicon carbide (P36)/Aluminium oxide (P40–P400)
Coating	Closed
Colour	Maroon
Grit range	P36–P400
Backing	Antistatic T-paper / F-paper
Available as	

READ MORE



MICROSTAR®

A general-purpose abrasive film product, designed for matting and paint rectification of top- and clear coat applications. Microstar has a special stearate layer and a smooth film backing. This product has a high quality finish and lasts longer as it doesn't clog as easily as traditional products. Microstar produces a fine scratch pattern that is easy to polish out. For a perfect result, it is recommended to use Microstar with a 5 mm interface pad. Microstar is intended for dry sanding only.



TECHNICAL SPECIFICATIONS	
Bonding	Low VOC resin system
Grain	Aluminium oxide
Coating	Semi-open
Colour	White
Grit range	P800–P2500
Backing	Polyester film
Available as	

READ MORE



MI231A

This micro-finishing film is designed for matting and paint rectification of top- and clear coat applications. MI231A is manufactured to the highest standard using the most technically advanced materials and processes, capable of producing a consistently high quality film product. MI231A has a semi-open grain distribution that will resist surface loading and produce consistently fine surface scratch patterns during use.



TECHNICAL SPECIFICATIONS	
Bonding	Low VOC resin system
Grain	Aluminium oxide
Coating	Semi-open
Colour	White
Grit range	P360–P2500
Backing	Polyester film
Available as	

READ MORE



MIRLON®

Thanks to its special structure, Mirlon is a flexible, three-dimensional fibre sanding material that's easy to use on profiled surfaces and produces an excellent finish. It's ideal for matting of surfaces and creates an excellent base for the next lacquer layer.



TECHNICAL SPECIFICATIONS	
Bonding	Resin
Grain	Aluminium oxide (GP,VF)/Silicon carbide (UF,MF)
Coating	Three-dimensional
Colour	Green (GP)/Red (VF)/Dark grey (UF)/Brownish (MF)
Grit range	General Purpose – 320, Very Fine – 360, Ultra Fine – 1500, Micro Fine – 2000
Backing	Non-woven
Available as	  

READ MORE



MIRLON TOTAL®

Developed using Mirka's innovative Total Coating™ Technology, Mirlon Total is more aggressive than Mirlon and produces a dense scratch pattern and rapid result. Suitable for use in wet and dry modes, it features an open and flexible structure and strengthened fibres which make it strong and long-lasting.



TECHNICAL SPECIFICATIONS	
Bonding	Resin
Grain	Aluminium oxide (VF)/Silicon carbide (UF,MF)
Coating	Three-dimensional Total Coating™
Colour	Red (VF)/Grey UF)/Beige (MF)
Grit range	Very Fine – 360, Ultra Fine – 1500, Micro Fine – 2500
Backing	Non-woven
Available as	 

READ MORE



Q.SILVER®

With a backing consisting of a flexible and strong latex-impregnated paper, Q.Silver features optimal aggressivity, resulting in fast and efficient stock removal. The high heat endurance of this fully resin-bonded abrasive makes it ideal for tough tasks. For sanding of soft and hard wood, filler, paints and lacquers.



TECHNICAL SPECIFICATIONS	
Bonding	Resin over resin
Grain	Aluminium oxide (P80–P500)/Silicon carbide(600–1500)
Coating	Semi-open
Colour	Blueish
Grit range	P80–P320, P400– P500, 600–1500
Backing	D-paper/C-paper/B-paper
Available as	   

READ MORE



SICA CLOSED

Designed for belt sanding and sanding of MDF and other materials containing mineral debris, Sica Closed is a fully antistatic product that's suitable for materials covered with water-based surface treatment coatings. It maintains its shape well and the silicon carbide grains produce less fibre rising and a finer scratch pattern than products using aluminium oxide grains. The result is a smoother sanded surface and a better final finish after surface treatment.



TECHNICAL SPECIFICATIONS

Bonding	Resin over resin/Antistatic
Grain	Silicon carbide
Coating	Closed
Colour	Black
Grit range	P80–P220
Backing	Antistatic F-paper
Available as	

READ MORE



SICA FINE STEARATE

Sica Fine Stearate is a fully antistatic, 'stearate' product which produces minimal dust load and a high-quality surface finish. For example, you can expect a perfect result after surface treatment with a top lacquer – it even minimises lacquer usage. Also available as Sica Fine without stearate.



TECHNICAL SPECIFICATIONS

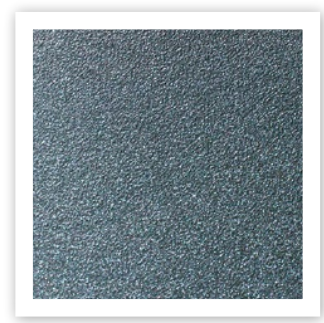
Bonding	Stearate-coated resin over resin/Antistatic
Grain	Silicon carbide
Coating	Semi-open
Colour	Grey
Grit range	P240–P320, P400–P1500
Backing	Antistatic E-paper
Available as	

READ MORE



SICA OPEN

Sica Open is the recommended solution for sanding soft, resin-rich wood types. The open coating and completely antistatic backing material and layers limit dust loading and prevent clogging which improves product lifespan. In addition, silicon carbide grains produce a smoother scratch pattern and a higher surface gloss level than aluminium oxide-based sanding materials.



TECHNICAL SPECIFICATIONS		
Bonding	Resin over resin/Antistatic	
Grain	Silicon carbide	
Coating	Open	
Colour	Black	READ MORE
Grit range	P80–P180	
Backing	Antistatic F-paper	
Available as		

UNIMAX®

An all-round wood sanding product, Unimax maintains its shape and is completely antistatic. This reduces the belt dust load and minimises clogging which helps the machine stay cleaner and improves work safety while increasing belt lifespan.



TECHNICAL SPECIFICATIONS		
Bonding	Resin over resin/Antistatic	
Grain	Aluminium oxide	
Coating	Semi-open	
Colour	Black	READ MORE
Grit range	P80–P220	
Backing	Antistatic F-paper	
Available as		

ULTIMAX®

Manufactured using a unique production process called ‘Selective Coating® Technology’ Ultimax features a series of tiny cavities designed into the abrasive material which work to efficiently prevent clogging. This innovative new technology, along with special abrasive grains, produces aggressive performance and excellent edge wear resistance while keeping the sanding surface cool. Together these features ensure a longer lifespan and reduced material usage per job. Ultimax is a thick and sturdy abrasive.



TECHNICAL SPECIFICATIONS

Bonding	Resin over resin
Grain	Aluminium oxide
Coating	Closed with Selective Coating®
Colour	Brown
Grit range	P40–P320
Backing	Antistatic T-paper/F-paper
Available as	

READ MORE



ULTIMAX® LIGNO

Ultimax Ligno is tailored for wood sanding applications. Developing the Ultimax Ligno, Mirka chose a special latex impregnated paper to prevent edgewear and tearing when sanding edges of wood surfaces. This gives the Ultimax Ligno the desired flexibility and adhesion, resulting in a longer life for each abrasive. It combines a fast cut with long life, thanks to especially good resistance to clogging when sanding substrates. The hourglass pattern ensures optimal cutting performance with consistent results. The segmented surface increases sanding pressure on each abrasive grain. To resist clogging and speed up the cutting process, Ultimax Ligno utilizes Mirka’s groundbreaking Multifit® hole pattern. Its dust channels leading to extraction holes take control of dust, keeping the abrasive grains cutting, and as air circulates under the abrasive it reduces heat during sanding.



TECHNICAL SPECIFICATIONS

Bonding	Low VOC resin system
Grain	Ceramic/Aluminium oxide
Coating	Semi-open with Selective Coating®
Colour	Red
Grit range	40–400
Backing	Latex paper, D-paper/C-paper
Available as	

READ MORE





Strong and stable performance
without breaking, twisting
or clogging.



Ultimax Black

ULTIMAX® BLACK

Premium long-life sanding belt combining a thick, high quality backing paper with new silicon carbide grain & patented selective coating technology – gives better, more consistent finishing quality even in the coarser grits. Highly resistant to breakage, folding and twisting. Antistatic, exceptional sanding quality from start to finish with reduced material waste. Surface cavities prevent clogging and reduce temperature of the sanding process while increasing surface pressure on each single sanding grain, helping the abrasive stay sharp for longer, contributing to a high removal rate and a lower scratch pattern.

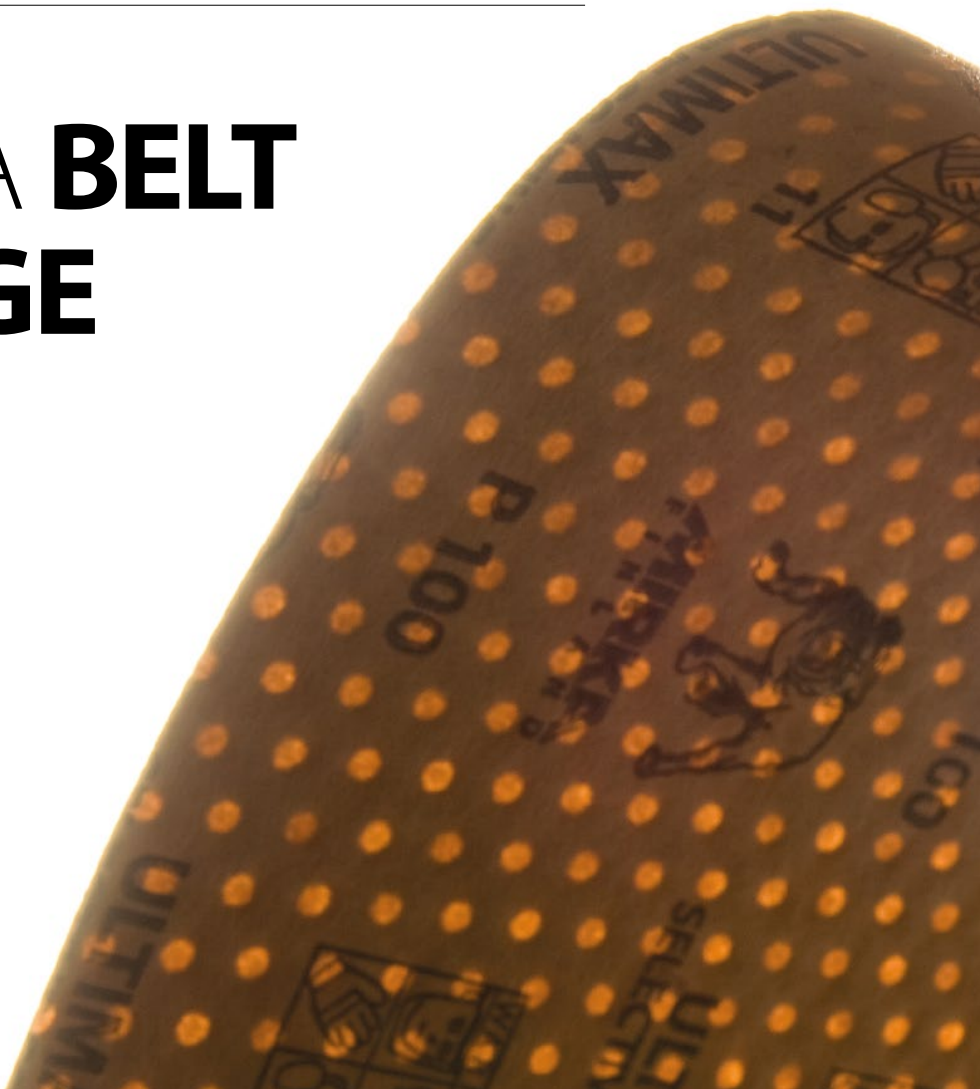


RECOMMENDED FOR:

sanding, intermediate sanding and pre-polish sanding of materials ranging from hard wood to soft wood, MDF, HDF and melamine surfaces. The strong and stable Ultimax Black delivers consistently without need to adjust machine pressure over time.

TECHNICALS	COARSE GRITS	FINE GRITS
Bonding	Resin over resin/Antistatic	Stearate-coated resin over resin
Grain	Silicon carbide	Silicon carbide
Coating	Closed with selective coating	Semi-open with selective coating
Colour	Black/Black	Grey/Black
Grit range	P80-P220	240-1000
Backing	Antistatic T-paper	Antistatic E-paper
Available as		

MIRKA BELT RANGE



HEAVY SANDING/ CALIBRA- TION	SURFACE SANDING						
	HARD WOOD (also MELAMINE)		SOFT WOOD		SOFT AND HARD WOOD	MDF / HDF	
	Hiolit XO P36–P80 Polyester cloth backing P100–P240 X-weight cotton cloth backing Aluminium oxide Semi open	Jepuflex Antistatic P36–P400 Antistatic T- and F-paper backing Aluminium oxide / Silicon carbide Closed	Ultimax® P40–P320 Antistatic T- and F-paper backing Aluminium oxide Closed with Selective coating® technology	Avomax® Antistatic P40, P60–P240, P320 Antistatic T- and F-paper backing Aluminium oxide Open	Sica Open P80–P180 Fully antistatic F-paper backing Silicon carbide Open	Unimax® P80–P220 Fully antistatic F-paper backing Aluminium oxide Semi open	Sica Closed P80–P220 Fully antistatic F-paper backing Silicon carbide Closed
Ultimax® Black: Coarse grits (80–220), antistatic T-paper backing, silicon carbide, closed with selective coating / Fine grits (240–1000), stearate							



Scan the QR Code to calculate the price of belts on the basis of your requirements.



INTERMEDIATE AND TOP COAT SANDING					PROFILE SANDING		
INTERMEDIATE SANDING			TOP COAT SANDING (PRIOR TO POLISHING)		FLAT PROFILES	CONTOURED PROFILES	
			Normal coating	Very hard coating			
00 static backing	Gold Max P240–P800 Antistatic E-paper backing Stearate Aluminium oxide Semi open	MI231A P360–P2500 Polyester film backing Aluminium oxide Semi open Narrow belt	MI231A P360–P2500 Polyester film backing Aluminium oxide Semi open Narrow belt	MI231B P180–1200 Polyester film backing Blue-fired aluminium oxide Semi open Narrow belt	Abranet® Max P80–P240 PA net backing Aluminium oxide Closed Narrow belt	Hiolit JCA2A0 P60–P400 J-weight cotton cloth backing Aluminium oxide Semi open Narrow belt	Alox P60–P400 Cotton cloth Aluminium oxide Closed Narrow belt
coating, antistatic E-paper backing, silicon carbide, semi-open with selective coating							



Mirka Ltd
Finland

Australia Mirka Australia Pty Ltd

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, Mirka Abrasives Germany 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

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