

Deburring - Rounding - Grinding - Smoothing - Polishing



Abrasives, Additives and Compound
for processing in vibratory finishing equipment

Grinding Media

Ceramic (KE)- and plastic bonded (KS) media are defined by their shape, grinding effect, grinding pattern and size.

Material/Form

Ceramic:

D	Triangle
DS	Triangle Angle Cut
DSE	Triangle Angle Cut extreme
KU	Ball
DZ	Dreizack
DZS	Dreizack Schrägschnitt
Z	Tristar
ZS	Tristar Angle Cut



Plastic:

KE	Cone
P	Pyramid
TS	Tristar
PA	Paraboloid

Grinding Effect

00	polishing
02-04	smoothing
05-18	finest grinding
20-32	fine grinding
34-55	grinding
60-75	strong grinding
76-89	ultra strong grinding
ab 90	extremely strong grinding

Grinding Pattern

smooth 0	
rough 9	

Order example: KE-D-46-5-25/25

(KE = material; D = shape; 46 = grinding effect; 5 = grinding pattern; 25/25 = size in mm)

Ceramic Media

<p>D Triangle a/b in sizes 2/2 to 25/25</p> 	<p>DS Triangle Angle Cut* a/b in sizes 4/4 to 25/25</p> 	<p>DSE Triangle Angle Cut extreme** a/b in sizes 2/2 to 6/6</p> 	<p>KU Ball a in sizes 1 to 25</p> 
<p>DZ Tristar a/b in sizes 2/2 to 10/10</p> 	<p>DZS Tristar Angle Cut* a/b in sizes 4/4 to 15/18</p> 	<p>Z Cylinder a/b in sizes 1,5/5 bis 15/30</p> 	<p>ZS Cylinder Angle Cut* a/b in sizes 1,5/5 bis 15/30</p> 

Further dimensions and qualities on request

*Angle Cut 30-40° **Angle Cut 50-70°

Plastic Media

KE
Cone
a
in sizes
6 to 50



P
Pyramid
a
in sizes
5 to 50



TS
Tristar
a
in sizes
20 to 50



PA
Paraboloid
a
in sizes
20 to 50



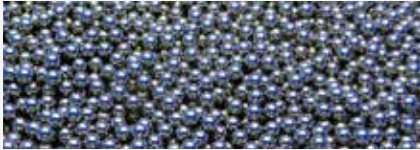
Further dimensions and qualities on request

Stainless Steel Media (wet process)

- polishing and smoothing effect
- various shapes

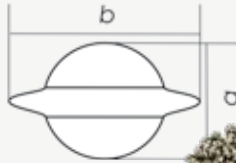
MS-KU

Ball
a
in sizes
2 bis 5



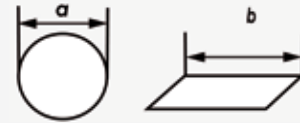
MS-SAT

Satellite
a/b
in sizes
3/5



MS-NAD

Needle
a
in sizes
0,3; 0,5; 1,5



Wooden Polishing Media (dry process)

- polishing and smoothing effect
- various shapes

HT

Trapeze
in sizes
4-12



HW

Cube
in sizes
4-16



Granulate	Granulate for Dry Polishing				
	Nutshell Granulate		WN-P	WN-S	WN-U*
	Granulation		polishing	grinding	not impregnated
	Very coarse		30 (4-6 mm)	--	30 (4-6 mm)
	coarse		50 (2,4-4 mm)	50 (2,4-4 mm)	50 (2,4-4 mm)
	Less coarse		100 (1,7-2,4 mm)	100 (1,7-2,4 mm)	100 (1,7-2,4 mm)
	Medium coarse		200 (1,3-1,7 mm)	200 (1,3-1,7 mm)	200 (1,3-1,7 mm)
	Less fine		300 (0,8-1 mm)	300 (0,8-1 mm)	300 (0,8-1 mm)
	Fine		400 (0,4-0,8 mm)	400 (0,4-0,8 mm)	400 (0,4-0,8 mm)
	Very fine		500 (0,2-0,4 mm)	500 (0,2-0,4 mm)	500 (0,2-0,4 mm)
	Maize Granulate		MAS		
	Granulation		impregnated	not impregnated	
	Coarse		--	1,7 - 2,2 mm	
			--	1,1 - 1,6 mm	
			--	0,8 - 1,8 mm	
Medium		0,4 - 0,8 mm	0,4 - 0,8 mm		
Fine		0,2 - 0,4 mm	0,2 - 0,4 mm		

* Impregnation with grinding or polishing paste necessary before use

Plastic Granulate	Ceramic Granulate	White Corundum
GUU in sizes 0,25 to 0,5 mm	GU in sizes 0,5 to 5,8 mm	ZO in sizes 0,210 to 0,420 mm
		

Additives	
Anti adhesion balls	Prevent sticking and packing of extremely flat and thin workpieces
Degreasing compound	For oil- and greaseless pieces during processing in mass finishing machines
Flocculant	Organic splitting agents for supportive/enhanced water purification of oil-contaminated waste water
Defoamer	Silicone and silicone-free defoamer for aqueous systems. Excellent long term effect in fully synthetic KSS as well as in emulsions without negative effects on emulsion stability
Polishing paste, Brilliance cream	For high-quality surfaces and corrosion protection in conjunction with nut shell granulate and wooden polishing media
Adhesive-/shining oil	Application in conjunction with granulate and polishing powder for enhanced substrate adhesion; relubrication of dry granulate
Grinding paste	Roughening of already smoothed abrasives, increase of grinding efficiency
Further dimensions and qualities on request	

Basically, any compound can be used for any metal. For metals sensitive to rust, please observe the corrosion protection. The particularly good suitability and properties of the individual compounds are indicated.

Compound	Grinding Compound			PH-Value (1-%ige Lösung)
	VF-08-101	grinding / deburring / smoothing produces homogeneous surface, suitable for circulation	Brass, Copper	7,1
	VF-08-105	grinding / deburring / smoothing brightening effect, not suitable for circulation	Light Metal, Non-Ferrous Metal, Stainless Steel	3,6
	VF-08-106	grinding / deburring / smoothing temporary corrosion protection, suitable for circulation	Steel, Iron	10
	Grinding Compound / Polishing Compound			
	VF-08-100	grinding / smoothing / polishing brightening effect, temporary corrosion protection, not suitable for circulation	Light Metal, Non-Ferrous Metal, Stainless Steel Plastic	7,8
	VF-08-108	grinding / smoothing / polishing low brightening effect, hardly any colour change of the workpieces, suitable for high-gloss polishing of alu- minium, silver and gold, conditional corrosion protec- tion, suitable for circulation	All Metals (Steel limited suitability) Aluminium, Silver and Gold	8,8
	VF-08-109	grinding / smoothing / polishing brightening effect, suitable for high gloss polishing (es- pecially for copper, stainless steel and brass), recom- mendation: mixture from 2%, high temporary corrosion protection, suitable for circulation	All Metals	9,7
	Polishing Compound			
	VF-08-104	smoothing / polishing / high-gloss polishing no brightening effect, no colour change of the work- pieces, recommendation: mixture from 2%, not suitable for circulation	All Metals (except Steel)	3,6
VF-08-112	smoothing / polishing / mirror finishing brightening effect, recommendation: mixture from 3%, temporary corrosion protection, suitable for circulation	All Metals, espe- cially for Gold and Silver	7,5	

Subject to technical changes