

# ABRASIVE MEDIA

**In the mass finishing processes it is critical to choose appropriate media according to the material and processing purpose.** Both factors impact the processing time and desirable results.

Synthetic, ceramic, porcelain and stainless steel media with compounds are used for wet processing, on the other hand walnut shell with polishing paste is used for dry processing.

There is a wide variety of grinding and polishing media in regard to shape, size and abrasiveness.

Supporting compounds are added to abrasive media in wet process. Additives in the compound help to clean, brighten and passivate workpieces.

MEDIA ABRASIVE FORCE			
TYPE	GRINDING FORCE	GRINDING EFFECT	
Ceramic A			
Ceramic BD			
Plastic 01PP/01PS10			
Plastic A1PS15			
Plastic 02PS10/02PP10			
Plastic 05PP/05PS10			
Plastic 06PP/06PS10			
Plastic A6PS15			
Porcelain CMP			

PORCELAIN CHIPS			
	TYPE	SYMBOL	SIZE in mm
<i>pin</i>		2x5 CMG/CMP*	2x5
		2x8 CMG/CMP	2x8
		3x10 CMG/CMP	3x10
		6x15 CMG/CMP	6x15
<i>ball</i>		fi 1,0 CMG/CMP	fi 1,0
		fi 1,5 CMG/CMP	fi 1,5
		fi 3 CMG/CMP	fi 3
		fi 4 CMG/CMP	fi 4
		fi 5 CMG/CMP	fi 5
<i>mix</i>		CMG/CMP	mix

\*CMG - smoothing process, CMP - polishing process

PLASTIC CHIPS				
	SYMBOL/COLOUR	PYRAMID (PP)	CONE (PS)	SIZE in mm
01	black			10x10
02	green			10x10 15x15 20x20
03	pink			PS 14x14 PP 18x18
05	blue			10x10
06	white			10x10
A1	brown	X		15x15
A6	pink	X		15x15

CERAMIC MEDIA				
	TYPE	SYMBOL	SIZE in mm	ABRASIVE CLASS
<i>prism oblique</i>		GP20x20	20 x 20	A, BD*
		GP15x10	15 x 10	A
		GP15x15	15 x 15	A
		GP10x10	10 x 10	BD
		GP6x10	6 x 10	A, BD
		GP4x4	4 x 4	BD
<i>prism</i>		G25x25	25 x 25	BD
		G15x15	15 x 15	A, BD
		G10x10	10 x 10	A
		G6x6	6 x 6	A, BD
		G4x4	4 x 4	A, BD
<i>tristar oblique</i>		STP15x10	15 x 10	BD
		STP6x6	6 x 6	A, BD
<i>cone</i>		KC15	15 x 15	A, BD
<i>ellipse</i>		E10x5x10	10 x 5 x 10	A
<i>ellipse oblique</i>		EP10x5x10	10 x 5 x 10	BD

\* A - more aggressive, BD- less aggressive