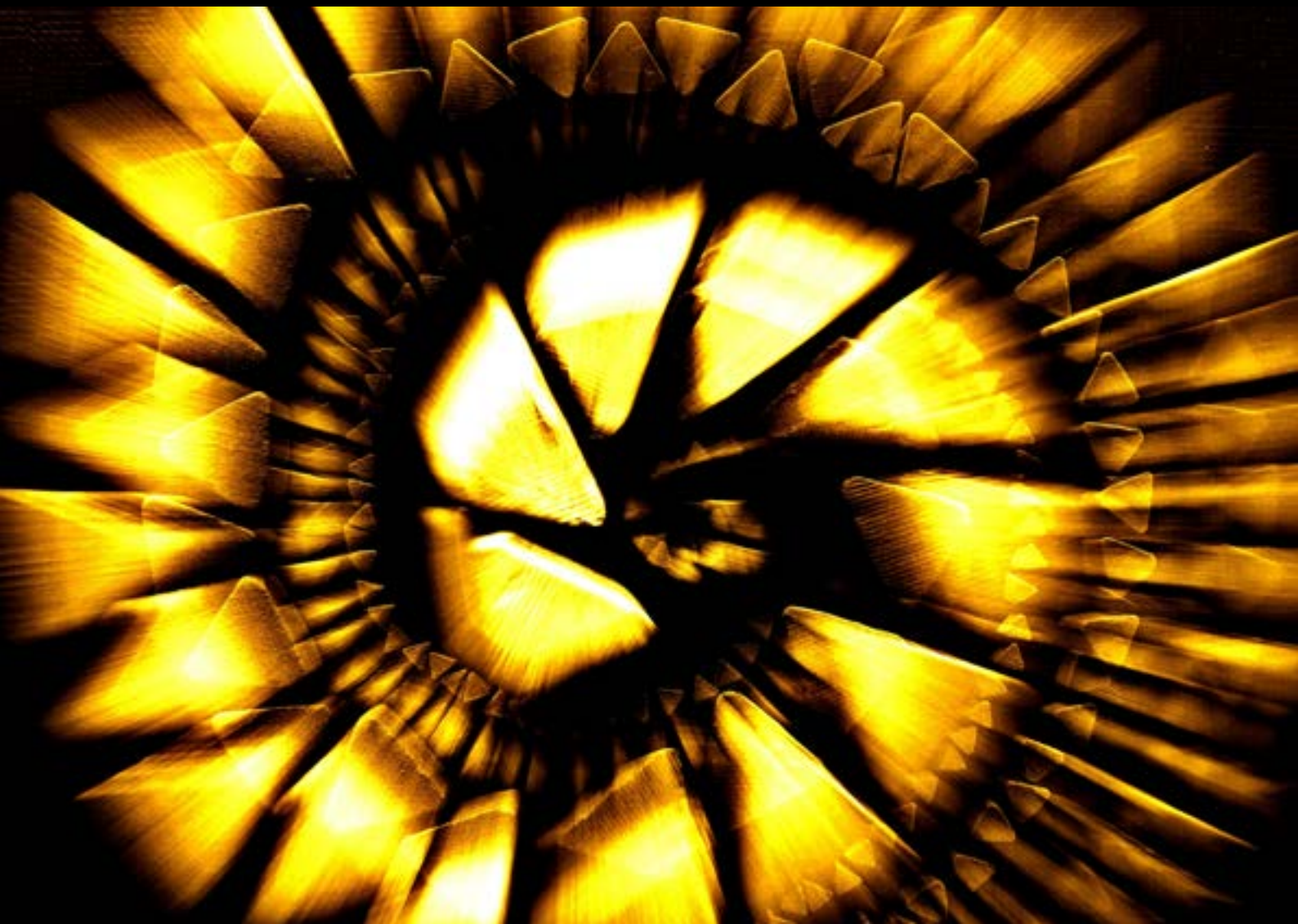


Consumables



Rösler provides total finishing solutions

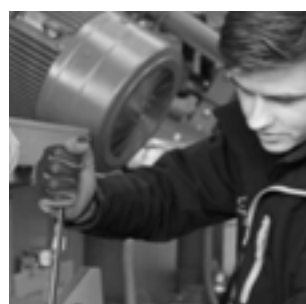


When it comes to surface finishing, Rösler is known to offer complete, well-engineered process solutions. Based on our comprehensive knowledge of mass finishing and shot blasting technologies, we can provide our customers with practically unlimited finishing solutions. In our state-of-the-art test lab, we conduct meaningful test trials to develop the optimum finishing processes for our customers because only complete solutions yield the best results. We are not simply offering specific surface finishing processes but we also supply perfectly matched auxiliary equipment and consumables. This approach has proven to be highly successful and has established Rösler as the global technological and market leader, with groundbreaking innovations and extremely high quality standards.

In more than 60 countries we support our customers with a comprehensive network of Rösler sales branches and independent distributors.



Rösler is the only supplier in its field maintaining test labs all over the world, where we develop process solutions under actual operating conditions and select the most suitable equipment. This approach saves our customers not only long travel distances and high freight costs, but it also provides them with products and processes that have been extensively tested by our specialists under the most severe operating conditions.



DIN EN ISO 9001 and 50001



Test lab mass finishing

Global network of test labs

Test labs for mass finishing and shot blasting at the Rösler headquarters in Untermerzbach:

- ▶ More than 95 mass finishing and shot blast machines.
- ▶ About 2,700 m² (27,000 sqft) workspace.

Our teams in USA, Great Britain, France, Netherlands, Belgium, Spain, Turkey, Romania, Italy, Austria, Switzerland, Russia, Brazil, Serbia and India provide similar test lab services.

Complete solutions

Besides demanding high quality, environmentally safe and efficient products, our customers also prefer to purchase all process components from one single source. That is why we offer not merely the processing equipment but the complete package with perfectly matched consumables. This guarantees the best finishing results and absolute process safety. Our global service teams take care of the delivery and the installation for you. Qualified engineers train our customers right at their location. And, of course, our after-sales service members will answer all of your questions. Quick supply of all spare parts and professional consultation by our experienced process specialists ensure that your finishing processes are always running smoothly.

Rösler Academy

Knowledge transfer in the fields of mass finishing and shot blasting from a single source

For example, in the course "MF.6 consumables and their applications" our expert trainer, certified by TÜV Rheinland, explains which types of consumables must be used for a wide range of finishing processes and which grinding, polishing and drying media along with the respective compounds are available. You will receive comprehensive information about the function, selection criteria and fields of application for the various media and compounds.

If you wish to learn more about this and other seminars please visit us at www.rosler-academy.com.

We look forward to welcoming you!



Fields of application / Examples of applications



Overview



Selection Criteria for Rösler Consumables

6 - 7



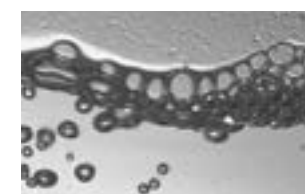
Auxiliary Mass Finishing Media

24 - 25



Quality Abrasive Media

8 - 15



Process Water Cleaning

26 - 27



Mass Finishing Compounds

16 - 23

Consumables

When it comes to consumables, no one in the industry can match our product line, or our experience. For over 60 years, Rösler has produced high-quality ceramic media. In addition, Rösler produces plastic media and environmentally-friendly mass finishing compounds.

All this adds up to 15,000 different consumables. Quality is another area in which Rösler cannot be matched.

We manufacture our consumables in accordance with the DIN EN ISO 9001 and 50001 quality control standards. Our standards for environmental protection are just as high. We use environmentally-friendly raw materials, and ensure that our manufacturing process maintains the highest standards for keeping the environment clean.

Selection Criteria for Rösler Consumables

Mass Finishing

Deburring | Rough grinding | Fine grinding | Smoothing | Polishing | Radiusing | Cleaning | Degreasing | Descaling | Corrosion Protection | Rust Removal | Ball Burnishing | Pressure Deburring

Media	Composition	The composition of the media determines grinding performance and the effect on the surface.
	Shape	The shape of the component to be finished determines the shape of the media required. The correct fit between media and component ensures that all surface areas are finished consistently, and there is no lodging of the media. The shape of the media also has an effect on the performance. Angled and edged shapes are more aggressive than rounded shapes.
	Size	Size and weight are key factors in determining performance. Large, heavy media cuts more aggressively, and leaves a rougher surface; small, lightweight media is less aggressive and more suitable for smoother surface requirements.
	Separating	Once the process is finished, the media must be separated completely from the components. Screening is the most common method of separation, requiring that the media be smaller than the components. Ferrous components may be separated magnetically. Inverse separation may be used in cases where the media is larger than the components. Custom solutions can be developed to meet individual requirements.
Compound	Type	<p>The mass finishing compound is an important part of the finishing process, and the right compound makes the difference between a good surface finish and a great surface finish. Compounds keep the surfaces of the media and components clean, and can also provide corrosion protection and/or degreasing. In order to determine the right compound for the process you must consider:</p> <ul style="list-style-type: none"> ▶ the material the component is made of ▶ the required surface finish ▶ the individual application and process requirements ▶ the properties of the compound <p>Due to the ease of dosing, liquid compounds are most widely used with modern finishing systems. Powder compounds are recommended for special applications such as shock degreasing and media cleaning.</p>
	Other	<p>Adhesion Prevention Adding Rösler's RAT anti-adhesion balls to the surface finishing process prevents parts from sticking to one another and ensures that all sides of all parts will be finished consistently.</p> <p>Grinding Additive To enhance the grinding performance of media in certain applications, a grinding Additive is used. It is applied to each batch manually at a rate of 0.5 to 1.0 kg per 100 kg of media, or automatically using powder dosing systems.</p>

Special Processes

RÖSLER Keramo-Finish®	Media	RP and RCP ceramic media with minimum abrasion are used for the finishing and polishing processes.
	Compound	This process requires a combination of RÖSLER Keramo-Finish® RSP and RPP pastes, followed by Rösler FC and ZF series compounds for rinsing off the pastes and final polishing.
Rösler ISF® Chemically accelerated mass finishing	Media	Special ISF®-Media
	Compound	Special compounds for chemically accelerated surface finishing are matched to the materials to be processed.
Rösler Ball Polishing and Pressure Deburring	Media	Stainless steel media from the RESK, RESA or SAT series is used and Pressure Deburring to burnish or pressure deburr parts in the surface finishing system.
	Compound	FC series ball burnishing compounds are used to provide optimum results.
Rösler Dry Polishing	Media	Rösler polishing media SV and SVK series are used for this process. They are pre-treated with dry polishing pastes.
	Compound	Rösler dry polishing pastes of RPP 7.. and RSP 7.. series.

For processing your components, we manufacture a complete line of surface finishing equipment:
 Rotary vibrators | Tub vibrators | Continuous Flow installations | Rotomatics | Long Radius | Plunge finisher | Centrifugal disk finishing machine | Drag grinding installations | Drying machines

Catalogues are available upon request.

Quality Abrasive Media – the most comprehensive range in the world



Ceramic Media Production

Rösler ceramic media is manufactured to exacting standards. We do our own body preparation, formulation, and maintain full control over all aspects of the manufacturing process. Starting with specially selected raw materials, the materials are mixed, formed and fired in a fully-automated state-of-the-art kiln to ensure consistent quality, and continuously reproducible results. Rösler has been producing high-quality media for over 60 years, and has the experience and the technology to ensure that our media is capable of finishing components to the highest standards, and balancing quality and cost.



Plastic Media Production

Our standards are no less exacting for our plastic media. Where others follow, we continuously improve our production processes to stay in the lead. The entire production process, mixing to forming to curing is totally automated. The process is computer controlled and continuously monitored. All shapes and sizes of our finishing media are cured. This allows us to increase quality further, and is a requirement for ensuring consistent wear and cutting performance, and above all, reproducible results during the finishing process.



Supply Quality

In our central warehouse, and in the warehouses of our subsidiaries worldwide, we stock approx. 8,000 tons of high-quality consumables, ensuring timely supply of the consumables you need, when you need them.

Ceramic Media

Further dimensions on request.
Special types for specific fields of application – contact us or our sales representatives!

Ordering Example:	Quality RM	Measurement 10/15	Shape S
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Quality	Specific Weight g/cm ³	Grinding Performance	Grinding Effect
RP Keramo-Finish®	2.91		
RF	2.40		
RCP	3.60		
RM	2.49		
RPM	2.50		
RCB	2.50		
RS	2.52		

Shape	D Triangle	F Triangle with big radius	S* Angle Cut Triangle	Z Cylinder	ZS* Angle Cut Cylinder	QZ Quinto
Measurement (mm)						
	a/b	a/b	a/b	a/b	a/b	a/b
	02/02 09/09 03/03 10/06 04/04 10/10 06/06 15/15 07/07	10/10	03/08 06/10 04/04 08/12 04/10 09/09 05/05 10/15 05/10 12/04	0,8/03 03/10 1,4/05 04/10 1,5/05 05/10 1,7/05 06/10 01/03 07/15 02/05 10/15 03/05 12/25	01/03 04/10 1,2/03 04/13 1,5/05 05/10 1,5/05 06/10 1,7/05 06/13 02/05 07/15 03/05 08/15 03/10 09/20 04/05 10/20	08/08
	03/03 10/10 04/04 13/13 05/05 15/10 06/06 15/15 08/08 20/20	06/06	10/06	03/03 03/05 04/04 06/10 06/08 08/15 10/14 10/10 12/12 15/36		
	03/03 09/09 04/04 15/15 06/06 20/20 07/07 25/25 08/08		04/13 10/15 05/12 12/12 06/06 13/13 07/07 15/18 08/08 20/08 09/09	1,7/04 08/13 02/05 10/16 03/05 12/15 04/10 18/30 07/15	1,7/05 07/13 02/05 08/10 2,5/05 09/15 03/05 10/08 04/05 10/15 04/10 12/20 05/10 13/15 06/10	10/12 14/17
	02/02 20/20 03/03 25/25 04/04 30/30 06/06 40/40 08/08 50/50 10/10 13/13 15/15	06/06 08/08 10/10 13/13 15/15 20/20	03/10 15/18 04/10 16/32 06/10 20/20 08/20 20/30 10/15 25/25 10/20 30/25 13/26 30/30 15/15 35/35	02/05 12/16 04/10 12/25 05/08 15/40 06/10 20/40 07/15 08/20 09/13 10/16	1,5/06 09/20 02/05 10/15 03/05 10/20 03/10 12/20 04/10 12/25 05/10 15/25 06/13 15/30 07/15 20/20 08/15 25/30	15/15 15/18
	04/04 06/06 10/10 15/15 20/20 25/25	20/20	03/10 13/13 04/10 15/15 05/10 20/20 06/06 25/25 08/20 30/25 10/15 35/35	04/08 10/20 05/10 20/40 20/40	04/10 15/30 05/10 20/40 06/13 25/30 09/20 10/20 12/20	08/08
	04/04 15/15 05/05 20/20 06/06 25/25 08/08 30/30 10/10 40/40 13/13	10/10 15/25	04/10 13/15 06/15 15/15 07/07 20/20 10/10 25/25 10/15 30/30	06/13 10/20 10/20 15/40 20/40	03/10 10/20 15/30 20/40	
	02/02 15/15 03/03 16/16 04/04 18/20 05/05 20/12 05/10 20/16 06/06 20/20 06/08 25/25 07/07 30/25 08/08 30/30 10/08 35/10 10/10 40/40 13/13 50/50 15/12	06/06 10/10 13/13 15/15 20/20 30/30	03/05 15/15 03/10 15/18 04/04 16/32 04/10 20/20 05/10 20/30 06/06 22/08 06/10 25/25 08/20 30/25 09/10 30/30 10/15 35/35 10/20 40/40 13/26	01/04 10/20 1,4/04 12/12 1,7/04 12/16 02/05 14/40 03/10 15/30 04/10 15/40 05/10 18/40 06/10 20/40 06/14 07/13 08/20	1,5/03 08/20 02/05 09/20 2,7/05 10/15 03/05 10/20 03/10 12/20 04/10 12/25 05/10 15/20 06/10 15/25 06/13 15/30 07/13 20/40 07/15 25/30	10/12 12/12 15/15 15/18 15/25 20/20 25/25

DZ Tristar	DZS* Angle Cut Tristar	ST Star	E Ellipse	ES* Angle Cut Ellipse	W Elbow	P Pyramid	K Cone	R Rhombus	PA Paraboloid	G Granulate
a/b	a/b	a/b	a/b/c	a/b/c	a/b	a/b	a	a/b/c	a/b	Øa Ø
04/04 02/02 sk 05/05 03/03 sk 06/06 04/04 sk 08/08 06/06 sk 10/10 08/08 sk	04/08 06/06 06/10 10/10 sk		08/09/03 20/20/08 10/10/05 15/15/04 15/15/06	15/15/04 15/15/06	10/10 sk					2 3 4 5 6 8
04/04 02/02 sk	04/04			20/20/08						3 4 6
04/04 06/06 sk 05/05 10/10 sk	04/05		08/09/03 15/15/06 20/20/08	15/15/06 25/30/13						
03/03 06/06 sk 04/04 10/10 sk 06/06 10/10 15/15 20/20 30/30	04/04 06/06 06/10 10/12 15/06 15/18 20/20 25/25 30/12 10/12 sk	20/08 22/12 30/12 35/12 45/16	14/14/05 15/15/04 15/15/06 20/20/08 20/20/10	15/15/04 15/15/06 20/15/08 25/25/10 25/25/13	10/05 10/10 14/14 15/10 15/15 20/20 25/25	15/16 15 22/25 19 25/27 20 30/34 30 35/39 35 40/45 P/R 40 45/50 P/R 45 10 P/PQ 60 15 P/PQ	15 19 20 30 35 40 45 60	35/18/25 50/30/30	30/17 50/28	1,2 9 2 10 3 11 4 14 5 18 6 7 8
10/10 20/20	10/10 15/15 15/18 20/10	20/12 22/10 30/12 45/16	14/14/05 15/15/04 15/15/06 20/20/08 20/20/10 25/25/10 25/25/15	20/15/08 25/25/13 25/30/10	20/20 15/15 sk	15/16 19 22/29 20 25/27 25 30/34 30 35/39 45 40/45 P/R 45/50 P/R 15 P/PQ	19 20 25 30 45			
03/03 04/04 10/10 20/20	10/20 20/10	30/12 45/16	08/10/03 15/15/04 15/15/06 20/20/08			15/16 30 25/27 40 30/34 60 35/39	30 40 60			
03/03 04/04 05/05 06/06 06/06 10/10 07/07 08/08 10/10 15/15 20/20 30/30 04/04 sk 06/06 sk 10/10 sk	04/04 05/05 06/06 10/12 15/18 20/20 30/12 10/12 sk 15/15 sk	20/08 20/12 22/12 30/12 35/12 45/16	10/10/05 14/14/05 15/15/04 15/15/06 20/20/08 20/20/10 25/25/10 25/25/15	15/15/04 15/15/06 20/15/06 25/15/10 25/25/13 30/30/12	10/05 10/10 15/10 15/15 20/20 14/14 sk	15/16 15 17/20 19 22/25 20 25/27 25 30/34 30 35/39 35 40/45 P/R 40 45/50 P/R 60 10 P/PQ 15 P/PQ	15 19 20 25 30 35 40 60	35/18/25 50/30/30 50/40/40 50/40/30	30/17 50/28	2 3 4 5 6 7 8 11

Special types: RSS/SCH, RPM/D, RSA, RMM, RMB/S, RMST, RXXF, RFP, RPA, RBCP, RA, RAH, RMA, RSD, RMB, S-Type, RFS, RXXD, RXX/2, RIC/F, ROM/A, RSRE, RSRED, RCP/2, Steatit balls

* Angle of angle cut media 30°, sk: sharp-edged, P/PQ: mixture of pyramids and tetrahedrons
P/R: pyramid with big edge radius

... to be continued on following page

Ceramic Media

Further dimensions on request.
Special types for specific fields of application – contact us or our sales representatives!

Ordering Example:	Quality RM	Measurement 10/15	Shape S
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Quality	Specific Weight g/cm ³	Grinding Performance	Grinding Effect
RSS	2.52		
RSF	2.39		
RSG	2.51		
RXF	2.63		
RX	2.60		
RMB/D1	2.55		
RXX	2.67		

Shape	D Triangle	F Triangle with big radius	S* Angle Cut Triangle	Z Cylinder	ZS* Angle Cut Cylinder	QZ Quinto
Measurement (mm)						
	a/b	a/b	a/b	a/b	a/b	a/b
	04/04 20/20 06/06 25/25 10/10 40/40 13/13 50/50 15/15	04/04 06/06 13/13 15/15 20/20 22/22	02/20 20/30 04/10 25/25 06/13 30/23 10/15 30/25 13/26 30/30 15/18 35/35 20/20	07/13 20/40 10/20 25/40 12/25 15/40 18/40	05/10 12/20 06/10 15/25 07/14 15/40 08/20 20/40 09/20 25/25 10/20	
	02/02 15/10 03/03 15/15 04/04 20/12 05/05 20/20 06/06 25/25 07/07 30/20 08/08 30/30 10/06 40/40 10/10 50/50		04/10 20/30 06/10 25/25 10/06 10/15 13/26 15/10 15/18	07/08	02/05 10/15 03/05 10/20 04/05 12/20 04/10 15/25 06/13 20/20 07/15 25/30 09/15	12/12
	02/02 15/15 03/03 20/20 04/04 25/25 06/06 30/30 08/08 35/35 10/10 40/40 13/13	06/06 10/10 13/13 15/15	04/10 20/20 06/10 20/30 08/20 22/08 10/15 22/24 10/20 25/25 13/26 30/25 15/15 30/30 15/18 35/35	03/05 15/30 06/10 18/40 06/14 20/40 07/15 10/16 12/16	1,5/04 08/15 02/05 10/20 03/05 12/20 03/10 12/25 04/05 15/25 04/10 15/30 05/10 20/40 06/13 25/30 07/15	10/12 15/18 20/20 25/25
	04/04 13/13 06/06 15/15 07/07 20/20 08/08 25/25 10/10 30/30	10/10 13/13 20/20 25/25	04/04 15/18 06/10 25/30 08/20 30/23 10/15 30/30 13/13 35/35 15/15		1,2/03 06/13 1,7/03 07/15 02/05 10/20 03/05 12/20 04/10 15/25 05/10	10/12
	03/03 13/13 04/04 15/15 05/05 20/20 06/06 25/15 07/07 25/25 08/08 30/30 10/10	08/08 10/10 15/15	06/10 15/18 08/20 20/20 10/10 22/08 10/15 22/24 12/10 25/25 13/13 30/25 15/15	07/13 10/15	1,7/03 08/15 03/05 12/20 04/05 15/30 06/10 20/40 07/15	10/12 15/15 15/18
	04/04 20/20 06/06 25/15 08/08 25/25 10/10 30/30 13/13 40/40 15/15	08/06 13/13 15/15	04/08 15/18 06/13 20/20 10/15 25/25 13/13 30/23 15/15 30/30	02/06 07/13 08/20 10/20 20/40	02/05 08/15 03/05 10/20 04/10 12/25 05/10 15/25 06/13 20/20 07/15	12/12 15/15 15/18 20/20
	04/04 20/20 06/06 25/15 08/08 25/25 10/10 30/30 13/13 15/15	10/10 15/15 25/25	04/04 15/18 06/10 20/20 08/08 22/08 09/09 22/24 10/10 25/25 10/15 30/30 12/20 35/35 13/13 40/40 15/15	03/10 04/10 06/10 07/13 10/10 20/40	03/05 09/15 04/05 10/20 05/10 12/20 06/10 15/25 07/15 08/15	10/12 15/15 20/20

DZ Tristar	DZS* Angle Cut Tristar	ST Star	E Ellipse	ES* Angle Cut Ellipse	W Elbow	P Pyramid	K Cone	R Rhombus	PA Paraboloid	G Granulate
a/b	a/b	a/b	a/b/c	a/b/c	a/b	a/b	a	a/b/c	a/b	Øa Ø
	10/12 15/18	20/12 20/08 22/12 30/12 35/12 45/16	10/12/05 15/15/06 20/20/08 25/25/10 25/25/13	15/15/06 20/20/08 25/25/10 30/30/12	10/10 15/10 15/15 20/12			50/30/30 50/40/30 50/40/40		
06/06 10/10 06/06 sk 10/10 sk	10/12 15/18	20/08 20/12 22/12	10/12/05 15/15/04 15/15/06 20/20/08		15/15			50/30/30		
04/04 05/05 06/06 10/10 04/04 sk 06/06 sk 10/10 sk	04/10 06/06 06/10 10/12 15/15 15/18 20/20 20/30 25/25 30/10	20/08 22/12 30/12 35/12 45/16	10/12/05 14/14/05 15/15/04 15/15/06 20/20/08	15/15/06 25/25/10 25/25/13	10/10 15/15 20/20	15/16 22/25 25/27 30/34 35/39 40/45 P/R 45/50 P/R 15 P/PQ	15 19 20 30 35 40 60	50/30/30 30/17 50/28	2 3 4 5 6 8 11 18	
06/06	04/04 04/10 06/06 10/12 15/18 15/10 sk	30/12 45/16	08/10/03 14/14/05 15/15/06	20/20/08	14/14 sk	35/39				5,5 8
06/06 10/10	10/12 15/18		14/14/05 15/15/06 20/20/08	25/50/13		10 P/PQ 15 P/PQ				
03/03 04/04 06/06 08/08 10/10	04/04 06/06 10/10 10/12 13/20 15/18 20/20 25/10 30/12	20/08 30/12 35/12	15/15/04 15/15/06 20/20/08 25/25/10	15/15/06 20/20/08	20/20	15/16 25/27 10 P/PQ 15 P/PQ		50/30/30		8
10/10	10/12 15/18 15/06 20/20 30/10	45/16	14/14/05 20/20/08	25/25/13	10/10 15/10 15/15 20/20			50/40/40		

Special types: RSS/SCH, RPM/D, RSA, RMM, RMB/S, RMST, RXXF, RFP, RPA, RBCP, RA, RAH, RMA, RSD, RMB, S-Type, RFS, RXXD, RXXV2, RIC/F, ROM/A, RSRE, RSRED, RCP/2, Steatit balls

* Angle of angle cut media 30°, sk: sharp-edged, P/PQ: mixture of pyramids and tetrahedrons
P/R: pyramid with big edge radius

Plastic Media

Further dimensions on request.
Special types for specific fields of application – contact us or our sales representatives!

Ordering Example:	Quality RKM	Measurement 40	Shape P
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Quality	Specific Weight g/cm ³	Grinding Performance	Grinding Effect	
RKF	1.51			
RKM	1.72			
RKH/4	1.97			
RKK	1.79			
RKB/W	1.78			
RKG	1.72			
RKB/W2	1.80			
RKV	1.82			
RKS	1.85			
RKE	1.82			
RKX	1.82			

Shape	K Cone		P Pyramid			PA Paraboloid		PDZ Tristar Pyramid		DK Wedge		QZ Quinto		L Lens	
Measurement (mm)	10	20	6 PQ	20	50	16/10									
	12	25	10	25	60	20/11									
	15	30	12	30		29/17									
	18		15	40		40/23									
Measurement (mm)	10	25	60	6 PQ	25	60	16/10	40/23	20	65/25 DZ				16	
	12	30	70	10	30	70	20/11	50/27	25						
	15	35		12	40	80	29/17	60/33	30						
	18	40		15	45		35/19	70/39	40						
	20	50		20	50				60						
Measurement (mm)	6	18		6 PQ	20		16/10		20	10/20		20		16	
	10	20		10			20/11		30	12/16					
	12	25		12			29/17			15/20					
	15	30		15						20/36					
Measurement (mm)	10	25		10	25	60	20/11	60/33	20						
	12	30		12	30		29/17		30						
	15	40		15	40		40/23		40						
	20	50		20	50		50/27								
	Measurement (mm)	10	20	40	6 PQ	20	50	16/10	40/23	20	10/20				
12		25	50	10	25	60	20/11	50/27	25						
15		30	60	12	30		29/17	60/33	30						
18		35	70	15	40		35/19	70/39	40						
Measurement (mm)	6	15	25	6 PQ	20		16/10		20	10/20				16	
	10	18	30	10	30		20/11								
	12	20		12			29/17								
Measurement (mm)	12	30	60	12	30		20/11	60/33	20	10/20				16	
	15	35		15	40		29/17	70/39	30						
	20	40		20	45		40/23		60						
	25	50		25	50		50/27								
Measurement (mm)	10	20	60	10	30		16/10		30						
	12	25		12			20/11								
	15	30		15			29/17								
	18	40		20											
Measurement (mm)	10	25	60	10	25	60	16/10	50/27	20						
	12	30		12	30	80	20/11	60/33	25						
	15	40		15	40		29/17	70/39	30						
	20	50		20	50		40/23		40						
	Measurement (mm)	10	20		6 PQ	20		16/10							
12		25		10	25		20/11								
15		30		12	30		29/17								
18		40		15			40/23								
Measurement (mm)	10	20		6 PQ	30		20/11								
	12	25		10	40		29/17								
	15	30		15			50/27								

Special types: RKP, RKF/O, RKD, RKB/H, RKB/W1, RKB/W3, RKB/W4, RKB/W43, RKS/2, RKS/3, RKS/G, RPU, RPE, RKM/E,RKF/B, RKS/F, RKE/F, RKE/5, RKE/6, RKX/F, RKH, RKH/5, RBKM, RKB/WB 1, RKB/WB 2, RKS/M, RKV/YF, RKEY2

PQ: square base, DZ: pyramid tristar obtuse

Mass Finishing Compounds – the most comprehensive range in the world



Rösler Mass Finishing Compounds

Rösler's compounds are ideal for all surface finishing processes. Their manufacture combines environmental protection, precision, and quality of process technology. Our Research and Development process takes place both in our development laboratory and in our test centres worldwide. We are continuously improving our products, as well as developing new ones, ensuring that we can always provide the right compound to fit your process and your budget.

Thorough testing of raw materials and finished products according to DIN EN ISO 9001 and 50001 standards allow us to fully document the quality control used in the production of our consumables. Regardless of which of our products you utilize, you can be sure that environmental protection will be a part of your surface finishing process.



Supply Quality

In our central warehouse, and in the warehouses of our subsidiaries worldwide, we stock 8,000 types of high-quality consumables, ensuring timely supply of the consumables you need, when you need them.

Liquid Compounds

Rösler's liquid compounds are the foundation of the modern mass finishing process. Thanks to their ability to remove contaminants such as metal and/or media fines from the process, they keep the components and the media clean and ensure that the media perform properly. Choose the right product for your application from Rösler's product range. This will guarantee that your solution is both economical and environmentally-friendly.

Type	FC 115	FC 120	FC 124 S	FC 230	FC 321	FC 396	FC 410	FC 430	FC 491	FC 630 AL
Description	Corrosion protection for all rust-sensitive ferrous metals	Universal cleaning and polishing material with corrosion protection	Cleaning and polishing compound with corrosion protection for none ferrous metals and stainless steel	Cleaning and polishing compound for non-ferrous metals and stainless steel	Degreasing compound with corrosion protection	High alkaline degreasing compound special for high oily components	Etching compound	Etching and polishing compound for all non-ferrous metals and stainless steel	Passivation compound to improve the adhesion and bonding properties of aluminum	Polishing compound with brightening effect for all metals, especially titanium
pH Value 0.5 %	8.8	7.6	8.0	7.5	7.8	11.5	1.8	2.6	2.3	7.9
material	Steel/Iron	++	+	++	•	+	++	+	•	•
	Stainless Steel	•	+	+	++	++	++	+	++	•
	Copper/Brass	•	+	+	++	++	•	+	++	++
	Aluminum	•	+	+	++	++	•	++	++	++
	Zinc	•	+	+	+	++	•	+	+	++
	Magnesium	•	•	•	+	+	•	•	•	+
	Grinding/ Deburring/ RADIUSING Edges	++	+	++	+	++	++	•	•	•
application	Degreasing/ De-oiling	•	•	+	•	++	++	•	•	•
	Smoothing/ Polishing	•	+	++	++	+	•	+	++	++
	Etching	•	•	•	•	•	•	++	+	++
	Polishing	•	+	++	++	+	•	+	++	++
	Ball Polishing	•	•	•	+	•	•	++	++	+
	Descaling/ Derusting	•	•	•	•	•	•	++	+	•
properties	Corrosion Protection	++	+	++	•	+	++	•	+	•
	Cleaning	+	+	+	+	++	+	+	++	+
	Degreasing	•	•	•	•	++	++	•	•	•
	Brightening	•	+	++	++	++	•	+	++	•
	Foam	•	+	+	+	•	•	+	++	+

State: 05/2016

Subject to revision

- ++ = very well suited/high
- + = suitable/average
- = conditionally suitable/less

Recirculation Compounds

Rösler's recirculation compounds are a combination of technology, functionality, biological stability, and high durability that provide consistent process quality for every application.

Type	ZF 110 i	ZF 113	ZF 138	ZF 231	ZF 311	ZF 322	ZF 322 S
Description	Corrosion protection for all rust-sensitive ferrous metals	Universal cleaning compound with corrosion protection for all ferrous and non-ferrous metal	Cleaning compound with high corrosion protection for all ferrous metals	Special compound for cleaning and passivating magnesium	Low foam cleaning and passivating compound, particularly suitable for very oily stamped parts	Degreasing compound with corrosion protection for all metals	Degreasing compound with good corrosion protection for all ferrous and nonferrous metals
pH Value 0.5 %	9.9	8.9	9.5	11.4	9.6	8.7	8.9
material	Steel/Iron	++	+	++	•	++	+
	Stainless Steel	+	+	++	•	+	++
	Copper/Brass	•	+	•	•	•	+
	Aluminum	•	+	•	•	•	++
	Zinc	•	+	•	•	•	+
	Magnesium	•	•	•	++	•	•
	application	Grinding/ Deburring/ RADIUSING Edges	++	++	++	+	++
Degreasing/ De-oiling		•	+	+	•	++	++
Smoothing/ Polishing		++	+	•	•	•	+
properties	Corrosion Protection	++	+	++	•	++	+
	Cleaning	+	+	++	•	++	+
	Degreasing	•	+	++	+	++	++
	Brightening	•	+	++	+	•	++
	Foam	•	•	•	•	•	•

State: 05/2016

Subject to revision

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We provide special compounds for special processes. Please contact us.

Powder Compounds

Powdered mass finishing compounds work in tandem with other products. These include: initial degreasing, etching and descaling, enhancing cutting performance of media, and cleaning of grinding media.

Type	R 11	R 20	R 35 E	R 40	R 55	R 60	
Description	Corrosion protection and cleaning compound	Cleaning and corrosion protection compound with brightening effect	Universal degreaser with corrosion protection	Acid product for etching and descaling	Grinding additive for increasing grinding performance and cleaning grinding bodies	Polishing compound with brightening effect	
pH Value 0.5 %	11.0	9.0	10.5	1.8	10.5	9.2	
material	Steel/Iron	++	+	++	+	++	+
	Stainless Steel	+	+	+	+	+	+
	Copper/Brass	•	+	+	+	+	++
	Aluminum	•	+	+		•	+
	Zinc	•	+	+		•	+
	Magnesium			•			
application	Grinding/Deburring/Radiusing Edges	++	+	++		++	+
	Degreasing/De-oiling	+	+	++			
	Smoothing/Polishing	+	+	+		•	++
	Etching				+		
	Polishing		+				++
	Ball Polishing						+
	Descaling/Derusting				+		
properties	Corrosion Protection	++	+	++		•	+
	Cleaning	++	+	++		+	+
	Degreasing	+	+	++			
	Brightening	+	+	+			++
	Foam	+	+	+	+		+

State: 04/2014

Subject to revision

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Grinding Pastes

The RÖSLER Keramo-Finish® grinding process is particularly economical with our grinding pastes in non-circulated processes.

Type	RSP 626	RSP 6264	RSP 6268	—	RSP 6286	standard	recirculation suitable for automatic dosing by pump
Description	Universal grinding product	Product with enhanced grinding performance	Very strong grinding product	Product with enhanced grinding performance	Extremely strong grinding product		
pH Value 0.5 %	ca. 9.0	ca. 9.0	ca. 9.0	ca. 9.5	ca. 9.0		
material	Steel/Iron	++	++	+	+	+	
	Stainless Steel	+	+	++	++	++	
	Copper/Brass	+	+	+	+	+	
	Aluminum	•	•	•	•	•	
	Zinc	•	•	•	•	•	
appli- cation	Grinding/Deburring/ Radiusing Edges	+	++	++	++	++	
	Smoothing/Polishing	+	•	•	•		
circulation powder	RSP 506 S	RSP 5064 S	RSP 587	RSP 508	RSP 5086 S		
pumpable paste for circulation application	RSP 806	RSP 8064	RSP 887	RSP 808	RSP 8086		

State: 05/2016

Subject to revision

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We provide special compounds for special processes. Please contact us.

Polishing Pastes

The RÖSLER Keramo-Finish® polishing process refines, superfinishes, and produces mirror-bright, high polish surfaces. Rösler polishing pastes are designed to produce the required surface finish, are environmentally-friendly, and economical to utilise. In addition to pastes, we have also developed powdered products for use with recirculation systems.

Type	RPP 623	RPP 627	RPP 6279	RPP 629	RPP 632 R	standard	recirculation suitable for automatical dosing by pump	
Description	Polishing product with light grinding effect	Light grinding product with good smoothing and polishing effect	Universal product for polishing	Polishing product with good brightening power	Polishing additive with good brightening effect			
pH Value 0.5 %	9.0 approx.	9.0 approx.	9.0 approx.	9.0 approx.	8.7 approx.			
material	Steel/Iron	++	+	++	+	+		
	Stainless Steel	+	++	++	+	+		
	Copper/Brass	•	+	++	++	++		
	Aluminum	•	•	•		•		
	Zinc	•	•	•		•		
application	Grinding/Deburring/Radiusing Edges	+	+	+	•	•		
	Smoothing/Polishing	+	++	++	++	++		
	Polishing	+	+	++	++	++		
circulation powder	RPP 503	RPP 527	RPP 579	RPP 590	RPP 520			
paste for recirculation, pumpable	RPP 803	RPP 827	RPP 879	RPP 890	RPP 820			

State: 05/2016

Subject to revision

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Dry Polishing Media and Compounds

Dry polishing media SV (corn cob) and SVK (nut shells) are treated with dry polishing compounds for use in rotary vibrators, high-energy centrifugal systems, and barrels. This media/compound combination works to achieve a fine, smooth high-end polish with a bright luster on ductile surfaces. We can also adapt both media and compounds for specialised applications.

All dry polishing media is ready to use, and available in a variety of sizes.

Type	RPP 746	RPP 747	RPP 7221 A	RPP 722 L3
Description	Polishing additive with particular brightness	Polishing additive with good brightening effect	Polishing additive with good brightening effect for stainless steel	Polishing additive with good brightening effect
material	Plastic	+	+	+
	Stainless Steel	+	+	+
	Non-ferrous material	+	+	+
	Aluminum	+	+	+
	Zinc	+	+	+
	application	Smoothing/Polishing	+	+
Polishing		+	+	+

State: 04/2014

Subject to revision





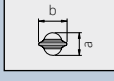


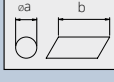
+ = suitable/average

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Auxiliary Mass Finishing Media



Rösler stainless steel media is available in a variety of shapes, including ball, ballcone, satellite and pin, for high-lustre burnishing and pressure deburring of ferrous and non-ferrous metal components.

Further dimensions and steel qualities on request

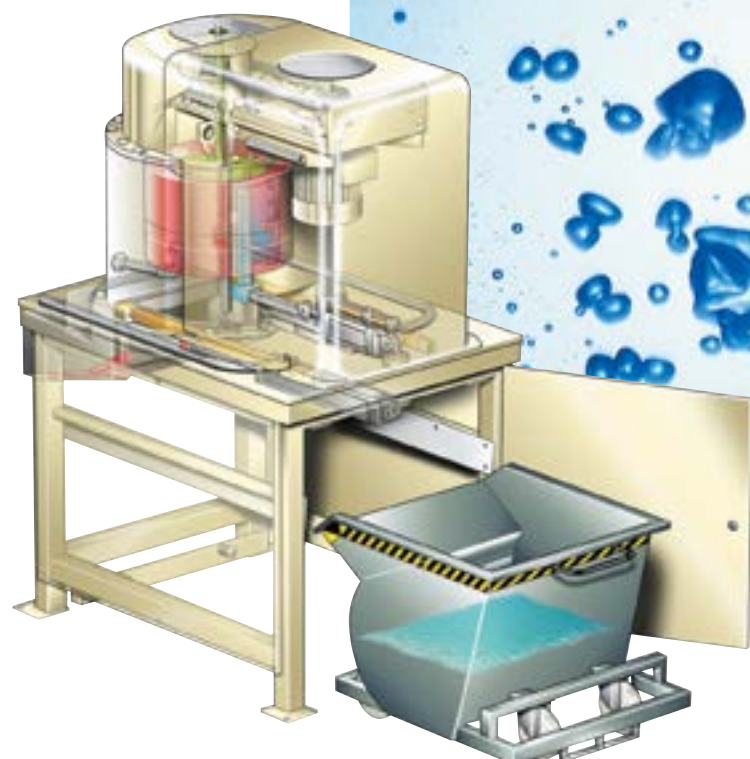
Stainless Steel Polishing Media	Materials	Designation	Dimensions in mm		Grain Size				
			∅	a/b					
Balls	1.4301 = AISI 304 1.4034 = AISI 420 1.4401 = AISI 316	RESK 2.0 RESK 2.8 RESK 3.2 RESK 3.9 RESK 4.5 RESK 5.0	∅ 2.0 ¹ ∅ 2.8 ¹ ∅ 3.2 ¹ ∅ 3.9 ¹ ∅ 4.5 ¹ ∅ 5.0 ¹						
Ballcones	1.4301 = AISI 304 1.4034 = AISI 420 1.4401 = AISI 316	SAT 03/05 SAT 05/07 SAT 07/10 SAT 08/12		03/05 05/07 07/10 08/12					
Pins	1.4301 = AISI 304 1.4034 = AISI 420	RESA 01/05 RESA 01/09 RESA 1.6/07 RESA 02/05 RESA 03/03 RESA 03/09		01/05 01/09 1.6/07 02/05 03/03 03/09					

¹ good class G600

Dry and Polishing Media	Materials	Designation	Dimensions in mm		Grain Size			
			∅	a/b				
Drying granulate Supervelat SV Alternatively: Material with low dust portion SV....N	Maize-cellulose product for spotless drying, cleaning, and polishing components.	SV 6 SV 8 SV 12 SV 16 SV 20 SV 30 SV 40 SV 8 N SV 12 N SV 16 N SV 20 N			2.0-5.0 approx. 2.0-4.0 approx. 1.6-2.0 approx. 0.8-1.6 approx. 0.6-1.0 approx. 0.4-0.7 approx. 0.2-0.4 approx. 2.0-3.2 approx. 1.4-2.0 approx. 0.8-1.6 approx. 0.6-1.0 approx.			
Nutshell Granulate	Natural product for polishing components.	SVK 6 SVK 8 SVK 16 SVK 20 SVK 30 SVK 40			2.40-4.00 approx. 1.70-2.40 approx. 1.40-1.70 approx. 0.45-1.00 approx. 0.45-0.80 approx. 0.20-0.45 approx.			
Glass Balls		RGK RGK RGK	∅ 3 ∅ 4 ∅ 5					

Anti-stick Separating Balls	Prevents the sticking of flat components in all grinding operations.	RAT 1 RAT 2			0.3-0.9 approx. 0.05-0.25 approx.			
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Process Water Cleaning



Process Water Cleaning

Effective process water cleaning requires a processing system optimised for enhanced results. Special recirculation compounds, combined with process water cleaners and flocculants, all work together to achieve the required finish, while keeping the process water clean and stable. Please contact us for more information about our treatment options using:

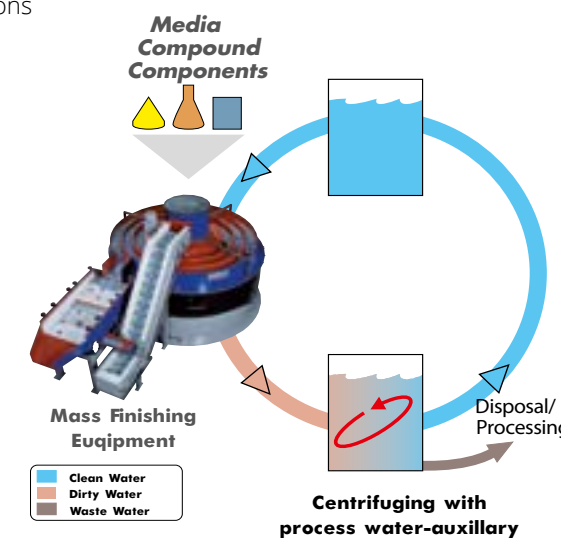
- ▶ process water centrifuges with Turbo-Floc® technology
- ▶ process water separators and settling tanks
- ▶ auxiliary equipment, such as buffer tanks, reaction tanks, and lifting stations

Chemical and mechanical waste water treatment systems complete our range of equipment and processing chemicals. We specialize in semi-automatic and fully automatic flocculation systems with capacities from 50 to 5,000 l/h.

Recirculation Process

Compared to traditional surface finishing without process water recirculation, you can achieve savings of up to:

- ▶ 80 % in compound usage
- ▶ 95 % in process water consumption



Process Water Cleaners (circulation systems)

Liquid for circulation system

Type	AR 8400	AR 8403	AR 8404	AR 8405	AR 8407
Function	Cationic Polymer for keeping the recycling system stable				
Consumption	As supplied or mixed with water at a ratio 1:4 up to 1:10, approximately 0.1 – 1.0 kg/m ³				

Powder for circulation system

Type	AR 7120	AR 7134
Function	Powder flocculants for effective removal of oil and grease from recycling systems; no buildup of salt in the process liquid	
Consumption	Depending on the degree of contamination from 0.1 kg/m ³ up to 1.0 kg/m ³	

Subject to revision

Chemical and Mechanical Waste Water Treatment (precipitation/flocculation)

We recommend suitable treatment systems to keep waste water treatment safe and economical regardless of how specialised your individual requirements are. We have years of experience, gained from more than 1,000 systems supplied. Our well-equipped development and analysis laboratory and the latest technology is at our disposal.

Powder flocculants for waste water treatment

Type	AR 7009	AR 7038	AR 7090	AR 7234
Function	Powder products for waste water of surface finishing, optimised for effective removal of oils, greases, rests of compounds, metals and solids in batch processing machines.			
Consumption	Depending on the rate of pollution 1 up to 10 kg/m ³			

Subject to revision



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► and more than 150 representations worldwide

