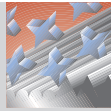
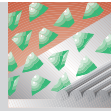


www.rosler.com



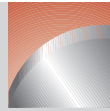
Grinding



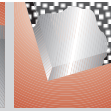
Fine Finishing



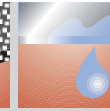
Deburring



Radiussing



Degreasing



Drying



Polishing



Passivation



Consumables



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 surface finishing compounds.

All this adds up to 8,000 different consumables. Quality is another area in which Rösler cannot be matched.

We manufacture our consumables in accordance with the DIN EN ISO 9001 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.



	Page
Selection Criteria	4 – 5
Quality Abrasive Media	6 – 7
Ceramic Media 1	8 – 11
Plastic Media 2	12 – 13
Surface Finishing Compounds 3	14 – 21
Surface Finishing Process Auxiliaries 4	22 – 23
Process Water Cleaning	24 – 25



ISO 9001: 2008

Selection Criteria for Rösler Consumables

Surface Finishing

Deburring · Rough grinding · Fine grinding · Smoothing · Polishing · Radiussing · 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 surface 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.</p> <p>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 <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	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.
	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.

If you have any questions, please contact us or our sales representatives!

Special Processes

Rösler Keramo-Finish® For a highgloss polish	Chips	RP and RCP ceramic media with minimum abrasion are used for the finishing and polishing processes
	Compound	This process requires a combination of Keramo-Finish® RSP and RPP pastes, followed by Rösler FC and ZF series compounds for rinsing off the pastes and final polishing.
Rösler ChemoFinish® Chemically accelerated surface finishing	Chips	Special ChemoFinish® media and S series media are used for this type of process.
	Compound	Special CFN or CF-D series compounds are used for rapid chemical surface finishing, followed by Rösler FC series compounds for rinsing and polishing.
Rösler Ball Polishing and Pressure Deburring	Media	Stainless steel media from the RESK, RESA or SAT series is used 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 · Trough vibrators · Continuous Flow installations · Rotomatics · Long Radius · Plunge finisher · High energy disc systems · Drag grinding installations · Drying machines

Catalogues are available upon request.

Quality Abrasive Media

– the **most comprehensive range** in the world.



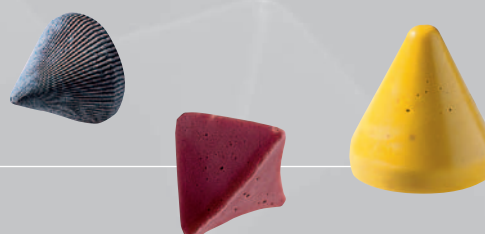
Ceramic Media Production

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.

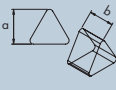
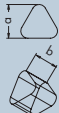
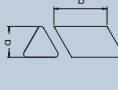
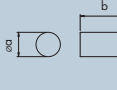
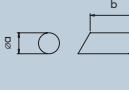



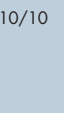
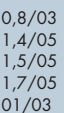
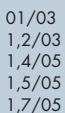
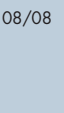


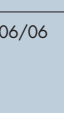
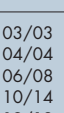
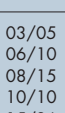





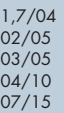
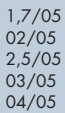
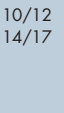


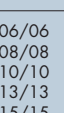
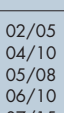
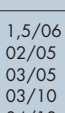
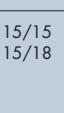


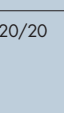
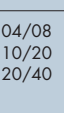
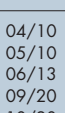
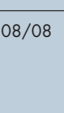


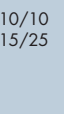
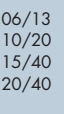
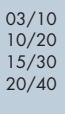



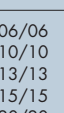
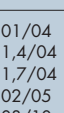
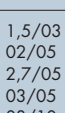
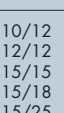


Supply Quality

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.













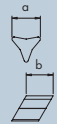
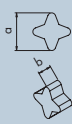
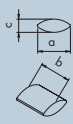


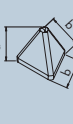

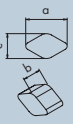
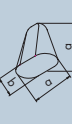



Ceramic Media

Ordering Example: Quality RM Measurement 10/15 Shape S				Shape	D Triangle		F Triangle <small>with big radius</small>		S* Angle Cut Triangle		Z Cylinder		ZS* Angle Cut Cylinder		QZ Quinto	
Quality	Specific Weight g/cm ³	Grinding Performance	Grinding Effect	Measurement		a/b		a/b		a/b		a/b		a/b		a/b
RP Keramo-Finish®	2.91			02/02	09/09	10/10		10/10	03/08	06/10		08/08		08/08		08/08
				03/03	10/06				04/04	08/12						
				04/04	10/10				04/10	09/09						
				06/06	15/15				05/05	10/15						
				07/07					05/10	12/04						
RF	2.40			03/03	10/10	06/06		10/06		10/06		10/06		10/06		10/06
				04/04	13/13											
				05/05	15/10											
				06/06	15/15											
				08/08	20/20											
RCP	3.60			03/03	09/09				04/13	10/15		10/15		10/15		10/15
				04/04	15/15				05/12	12/12						
				06/06	20/20				06/06	13/13						
				07/07	25/25				07/07	15/18						
				08/08					08/08	20/08						
RM	2.49			02/02	20/20	06/06		10/10	03/10	15/18		10/10		10/10		10/10
				03/03	25/25				04/10	16/32						
				04/04	30/30				06/10	20/20						
				06/06	40/40				08/20	20/30						
				08/08	50/50				10/15	25/25						
RPM	2.50			04/04		20/20		10/10	03/10	13/13		10/10		10/10		10/10
				06/06					04/10	15/15						
				10/10					05/10	20/20						
				15/15					06/06	25/25						
				20/20					08/20	30/25						
RCB	2.50			04/04	15/15	10/10		15/25	04/10	13/15		10/10		10/10		10/10
				05/05	20/20				06/15	15/15						
				06/06	25/25				07/07	20/20						
				08/08	30/30				10/10	25/25						
				10/10	40/40				10/15	30/30						
RS	2.52			02/02	15/15	06/06		10/10	03/05	15/15		10/10		10/10		10/10
				03/03	16/16				03/10	15/18						
				04/04	18/20				04/04	16/32						
				05/05	20/12				04/10	20/20						
				05/10	20/16				05/10	20/30						

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

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


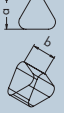

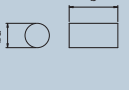
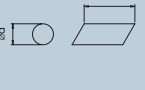









DZ Tristar	DZS* Angle Cut Tristar	ST Star	E Ellipse	ES* Angle Cut Ellipse	W Elbow	P Pyramid	K Cone	R Rhombus	PA Paraboloid	G Ball
										
										
a/b	a/b	a/b	a/b/c	a/b/c	a/b	a/b	a	a/b/c	a/b	Ø
04/04 05/05 06/06 08/08 10/10	02/02 sk 03/03 sk 04/04 sk 06/06 sk 08/08 sk 10/10 sk	04/08 06/06 06/10 10/12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

Subject to revision, Date: 05/2012

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














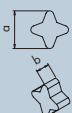
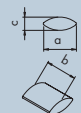
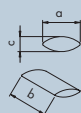
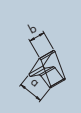
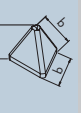


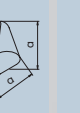

... to be continued on following page

Ceramic Media

Ordering Example: Quality RM Measurement 10/15 Shape S				Shape	D Triangle	F Triangle with big radius	S* Angle Cut Triangle	Z Cylinder	ZS* Angle Cut Cylinder	QZ Quinto
Quality	Specific Weight g/cm ³	Grinding Performance	Grinding Effect	Measurement	 a/b	 a/b	 a/b	 a/b	 a/b	 a/b
RSS	2.52				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	
RSF	2.39				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
RSG	2.51				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
RXF	2.63				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
RAH	2.55				03/03 15/15 04/04 20/20 06/06 25/25 08/08 30/30 10/10 40/40 13/13 50/50		04/10 15/15 06/06 15/18 10/15 20/20 13/13 25/25 13/20 30/30	04/10 05/10 10/10 15/30	03/05 10/20 04/10 13/25 06/13 15/25 07/15 20/20 08/15	10/12
RX	2.60				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
RMB/DI	2.55				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
RXX	2.67				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 15/30 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

Special types: RSS/SCH, RPM/D, RSA, RMM, RMB/S, RMST, RXXF, RFP, RPA, RBCP, RA, 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

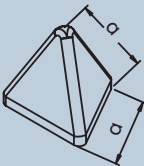
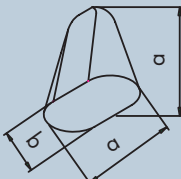
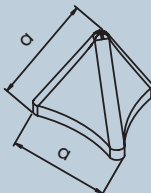
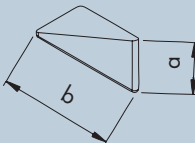


DZ Tristar	DZS* Angle Cut Tristar	ST Star	E Ellipse	ES* Angle Cut Ellipse	W Elbow	P Pyramid	K Cone	R Rhombus	PA Paraboloid	G Ball
										
										
a/b	a/b	a/b	a/b/c	a/b/c	a/b	a/b	a	a/b/c	a/b	Ø
	10/12 15/18	20/12 20/08 22/12 30/12 35/12 45/16	10/12/05 15/15/06 20/20/08 25/25/10 25/30/10 30/30/12	15/15/06 20/20/08 25/25/10 25/30/10 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 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
	15/18 20/08	30/12 35/12 45/16	15/15/06 20/20/08 20/20/10							
06/06 10/10	10/12 15/18		14/14/05 15/15/06 20/20/08	25/50/13		10 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		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		

Subject to revision, Date: 05/2012

Plastic Media

Ordering Example: Quality RKM Measurement 40 Shape P					Shape	Measurement	K Cone 		
Quality	Specific Weight g/cm³	Grinding Performance	Grinding Effect				a		
RKF	1.51						10 12 15 18	20 25 30	
RKM	1.72						10 12 15 18 20	25 30 35 40 50	60 70
RKH/4	1.97						6 10 12 15	18 20 25 30	
RKK	1.79						10 12 15 20	25 30 40 50	
RKB/W	1.78						10 12 15 18	20 25 30 35	40 50 60 70
RKG	1.72						6 10 12	15 18 20	25 30
RKB/W2	1.80						12 15 20 25	30 35 40 50	60
RKV	1.82						10 12 15 18	20 25 30 40	60
RKS	1.85						10 12 15 20	25 30 40 50	60
RKE	1.82						10 12 15 18	20 25 30 40	
RKX	1.82						10 12 15	20 25 30	

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

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

Surface Finishing Compounds

– the **most comprehensive range** in the world.



Rösler Surface 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 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 surface 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
<i>Description</i>	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
<i>pH Value 0.5 %</i>	8,8	7,6	8,0	7,5	7,8	11,5	1,8	2,6	2,3	7,9
metals	Steel/Iron	++	+	+	●	+	++	+	●	●
	Stainless Steel	●	+	++	++	+	++	+	++	++
	Copper/Brass	●	+	++	++	+	●	+	++	++
	Aluminium	●	+	++	++	+		++	++	++
	Zinc	●	+	++	+	+		+	●	++
	Magnesium								●	
application	Grinding/Deburring/Radiussing	++	+	+	+	+	++	●	+	+
	Degreasing/De-oiling		●	●	●	++	++	+		●
	Smoothing/Polishing		+	++	++	+		++		++
	Polishing		+	++	++	+		++		++
	Ball Polishing		●	●	+			++	++	+
	Descaling/Derusting					●	++	+		
properties	Corrosion Protection	++	+	+	●	+	+		●	●
	Cleaning	●	+	+	+	++	++	++	+	+
	Degreasing		●	●	●	++	++	++	●	●
	Brightening		+	++	++	++		+	++	++
	Foam		+	+	+	+		●	++	+
	Etching							+	++	

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

Subject to revision

Date: 03/2011

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 metals	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 non-ferrous metals
pH Value 0.5 %	9,9	8,9	9,5	11,4	9,6	8,7	8,9
metals	Steel/Iron	++	+	++		++	+
	Stainless Steel	+	+	++		++	++
	Copper/Brass		+	●		+	+
	Aluminium		+	●		++	++
	Zinc		+	●	●	+	+
	Magnesium				++		
application	Grinding/Deburring/Radiussing Edges	++	++	++	+	++	+
	Degreasing/De-oiling			+	+	++	+
	Smoothing/Polishing		+	●		+	++
properties	Corrosion Protection	++	+	++		++	+
	Cleaning	+	+	++	+	+	++
	Degreasing		+	++	+	++	++
	Brightening		+	++	+	●	++

Date: 03/2011

Subject to revision

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We provide
special compounds for special processes
Please contact us.

Powder Compounds

Powdered surface 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
metals	Steel/Iron	++	+	++	+	+	+
	Stainless Steel	+	+	+	+	+	+
	Copper/Brass	●	+	+	+	+	++
	Aluminium	●	+	+		+	+
	Zinc	●	+	+		+	+
	Magnesium						
application	Grinding/Deburring/Radiussing Edges	++	+	++		++	+
	Degreasing/De-oiling	+	+	++			
	Smoothing/Polishing	+	+	+			++
	Polishing	+				++	
	Ball Polishing						+
	Descaling/Derusting				+		
properties	Corrosion Protection	++	+	++			+
	Cleaning	++	+	++		+	+
	Degreasing	+	+	++			
	Brightening	●	+	+			++
	Foam	+	+	+	+		+
	Etching				+		

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Subject to revision

Date: 03/2011

Grinding Pastes

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

Standard Paste		RSP 626	RSP 6264	RSP 6268	RSP 6286	Standard
Description		Universal grinding product	Product with enhanced grinding performance	Very strong grinding product	Extremely strong grinding product	
pH Value 0.5 %		9,0 approx.	9,0 approx.	9,0 approx.	9,0 approx.	
metals	Steel/Iron	++	++	+	+	recirculation suitable for automatical dosing by pump
	Stainless Steel	+	+	++	++	
	Copper/Brass	+	+	+	+	
	Aluminium	•	•	•	•	
	Zinc	•	•	•	•	
	Magnesium					
appli- cation	Grinding/Deburring/ Radiussing Edges	+	++	++	++	
	Smoothing/Polishing	+	•	•		
circulation powder		RSP 506 S	RSP 5064 S	RSP 587	RSP 5086 S	
pumpable paste for circulation application		RSP 806	RSP 8064	RSP 887	RSP 8086	

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We provide
**special compounds and pastes
for special processes**
Please contact us.

Subject to revision

Date: 03/2011

Polishing Pastes

The 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.

	Standard Paste	RPP 623	RPP 627	RPP 6279	RPP 629	RPP 632 R	
	<i>Description</i>	Polishing product with light grinding effect	Light grinding product with good smoothing and polishing effect	Universal product for polishing, low grinding performance	Polishing product with good brightening power	Polishing additive with good brightening effect for steel and stainless steel	Standard
	<i>pH Value 0.5 %</i>	9,5 approx.	9,0 approx.	9,0 approx.	9,0 approx.	9,0 approx.	
metals	Steel/Iron	++	++	++	+	+	recirculation suitable for automatic dosing by pump
	Stainless Steel	++	++	++	+	+	
	Copper/Brass	●	++	++	++	++	
	Aluminium	●	●	●			
	Zinc	●	●	●			
	Magnesium						
application	Grinding/Deburring/ Radiussing 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	

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Subject to revision

Date: 03/2011

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.

Paste		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
metals	Steel/Iron	+	+	+	++
	Stainless Steel	++	++	+	++
	Copper/Brass	++	++	++	+
	Aluminium	+	+	++	+
	Zinc	++	++	++	+
	Titanium	+	+	+	+
applica- tion	Grinding/Deburring/ Radiussing Edges				
	Polishing	++	+	++	++

Date: 03/2011

Subject to revision

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+ = suitable/average

We provide
**special compounds, media and
pastes for special processes**
Please contact us.

Auxiliary Surface 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.

Stainless Steel Polishing Media

For high-lustre burnishing and pressure deburring

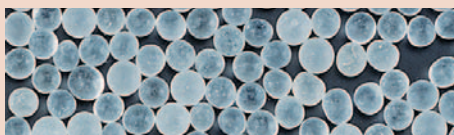
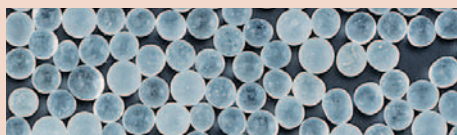
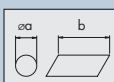
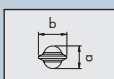
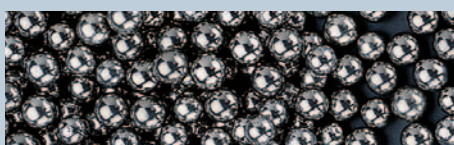
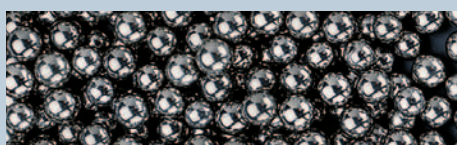
	Materials	Designation	Dimensions in mm			
			Ø	a/b	Grain Size	
Balls	1.4301 = AISI 304 1.4034 = AISI 420 1.4401 = AISI 316	RESK 2,0 RESK 2,8 RESK 3,2 RESK 3,9 RESK 4,5 RESK 5,0	Ø 2,0 ¹ Ø 2,8 ¹ Ø 3,2 ¹ Ø 3,9 ¹ Ø 4,5 ¹ Ø 5,0 ¹			
Ballcones	1.4301 = AISI 304 1.4034 = AISI 420	SAT 03/05 SAT 05/07 SAT 07/10 SAT 08/12		03/05 05/07 07/10 08/12		
Pins	1.4301 = AISI 304 1.4034 = AISI 420 1.0616 = AISI 1086	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		

¹goods class 6

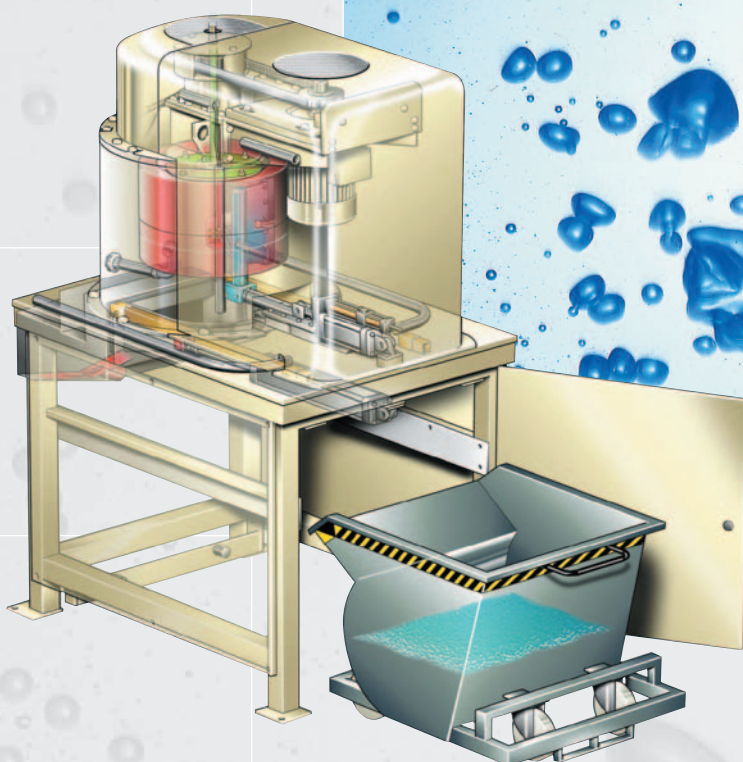
Dry and Polishing Media

Drying granulate Supervelat SV	Low dust maize-cellulose product for spotless drying, cleaning, and polishing components.	SV 6 SV 8 SV 12 SV 16 SV 20 SV 30			3,2-4,5 approx. 2,0-3,2 approx. 1,5-2,0 approx. 1,0-1,5 approx. 0,7-1,0 approx. 0,5-0,7 approx.	
Alternatively: Material with low dust portion SV....N		SV 12 N SV 16 N SV 20 N			1,5-2,0 approx. 1,0-1,5 approx. 0,7-1,0 approx.	
Nutshell Granulate	Dust-reduced product for polishing components.	SVK 6 SVK 8 SVK 16 SVK 20				
Glass Balls		RGK RGK RGK	Ø 3 Ø 4 Ø 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.	

Further dimensions and
steel qualities on request



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:

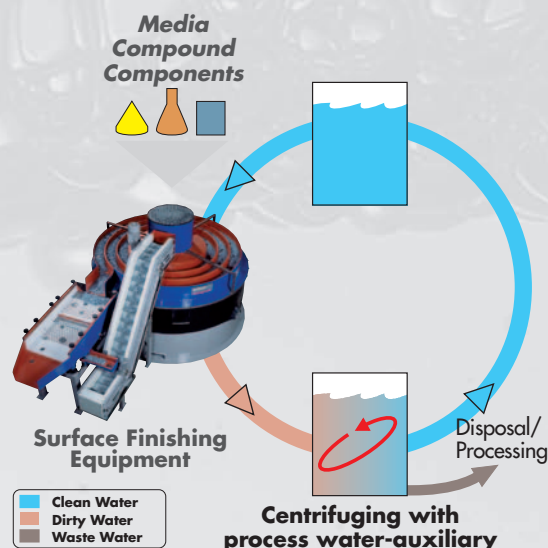
- ▶ process water centrifuges with Turbo-Floc® technology
- ▶ process water separators and settling tanks
- ▶ auxiliary equipment, such as buffer tanks, reaction tanks, and lifting stations

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 8407	AR 8403	AR 8404	AR 8405	AR 8400
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/m³				

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/m³ up to 1.0 kg/m³	

Date: 05/2012

Subject to revision

Chemical and Mechanical Waste Water Treatment (precipitation/flocculation)

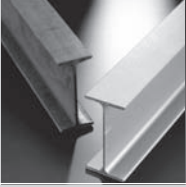
We recommend suitable treatment systems to keep waste water treatment safe and economical regardless of how specialised your individual requirements are. We have years of experience, gained from more than 1,000 systems supplied. Our well-equipped development and analysis laboratory and the latest technology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

Powder flocculants for waste water treatment

Type	AR 7009	AR 7090	AR 7038	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 kg/m³ up to 10 kg/m³			

Date: 05/2012

Subject to revision



finding a better way ...

When it comes to dealing with surface finishing and surface preparation problems, Rösler offers **the total process solution!** Our customers can choose between two processing technologies, **Vibratory finishing or Shot blasting**, which offer virtually unlimited possibilities. Through extensive processing trials, we always find the right finishing solution for our customer's needs.

This includes not only the development of a specific finishing process, but also the selection of the right equipment and consumables.

We deliver the total solution to satisfy your surface finishing requirements. Our success in the market proves that we are right. It is not by chance that our innovative developments and our high quality standards have established Rösler as the world technology and market leader in surface finishing and surface preparation.

In more than 60 countries we support our customers with a closely-knit network of Rösler subsidiaries and sales representatives.

We are the only company in our field operating test and demonstration centres throughout the world. This allows us to run test trials under real production conditions close to our customers.

This offers several advantages: Our customers save time and money, and at the same time – through our professional processing trials and advice – they are assured of receiving the best process solutions and products available on the market!



Worldwide Demonstration and Test Centres

Our main test centers for vibratory finishing and shot blasting are located at the Rösler headquarters in Untermerzbach, Germany:

- more than 95 vibratory finishing and shotblasting systems
- working space: approx. 2,700 square meters

Similar test centres are located in the United States, Great Britain, France, the Netherlands, Belgium, Switzerland, Spain, Italy, Austria, South Africa, Brazil and India.

The Total Process Solution

Consumables, machines and process safety in perfect combination:

- The optimum interaction between consumables, machinery and process stability produces excellent finishing results
- Cost saving automation allows running multiple process steps without any operator intervention
- Comprehensive training of your operators and maintenance staff
- After-sales service guarantees high uptimes for your equipment

Environmental Protection – Top Quality

The consideration of environmental issues guarantees a high level of product quality and environmental protection.

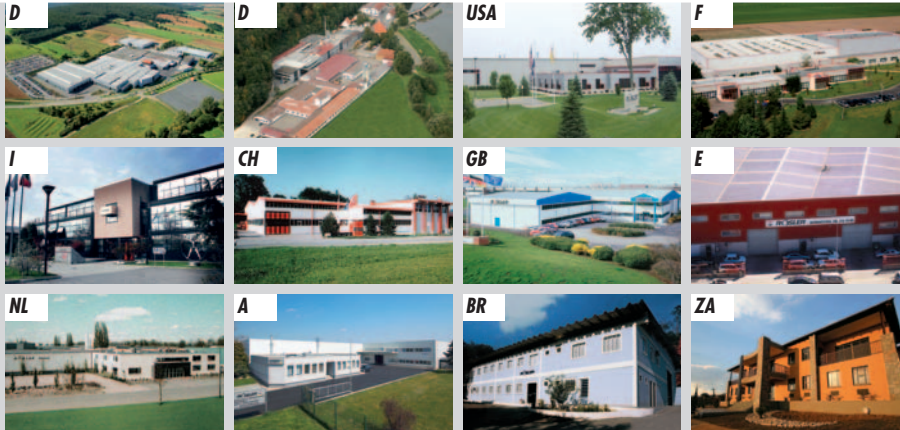
For example, circulating the process water is a key feature of our mass finishing technology. In this case, the positive effect on the environment is reflected in savings of compound and water of up to 95%. At the same time, a high level of process reproducibility and finishing quality is guaranteed.

Team Spirit

The consideration of ecological aspects in all our manufacturing processes results in eco-friendly and – at the same time – high quality products. In this respect the recycling of the process liquids is a central feature of our state-of-the-art mass finishing systems.

The positive environmental impact of these recycling systems is directly reflected in compound and water savings of up to 95% compared to conventional mass finishing processes. Furthermore, such recycling systems guarantee high quality finishing results and absolute process repeatability which are an essential requirement for today's high volume industrial production."





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- and more than 60 representations worldwide

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