

SHOT PEENING PROCESS TECHNOLOGY _ BLASTING BEADS

plasting purpose	SURFACE FINISH SHOT PEENING																SURFACE STRAIN HARDENING ABRASIVES (shot-peening)																
	blasting for deburring, smoothing, lapping and polishing (general finishing, antireflex finishing, decorating, designing, ornamenting, structuring, matting, satin finishing), exposure of surface defects																increasing material endurance and stability, size retention, sealing and quiet running, improvement of lubricant film adhesion, reduction of notch sensitivity, prevention of stress crack corrosion, straightening and shaping																
application	matting of stainless steel	smoothing of moulds from the rubber and plastics industry	smoothing of moulds from the foundry and glass industry	reflex free finishing of bumpers, trims, radiator grill	reflex free finishing of fittings, door handles	reflex free finishing of wiper arms, mirror and lamp sockets	reflex free finishing of phono, TV and camera parts	reflex free finishing of measuring and display devices	reflex free finishing of optical and acoustic parts	finishing and deburring of watch casings and watch parts	finishing of household devices and household appliances	finishing of ornaments	deburring and finishing of fine mechanical and precision parts	deburring and smoothing of precision-cast parts (V2A, Ti)	deburring and smoothing of precision-cast parts (SM, LM)	smoothing and finishing after assembly	deburring of sintered parts	finishing, ornaments, decor, jewellery, medals, coins	finishing of steel and LM strips and sheets	gear wheels, worms, worm wheels, intermediate gear	parts of office machines	precision chain parts	shafts, axles, bolts, cones, drillings, joints	weapon components	rolls, welding seams	valves, valve seats, pistons, cylinders, connecting rods, tappets	shovel systems for all rotating machinery	cutting, milling and broaching tools, cams	leaf, coil and spiral springs, stabilizers	wedges, groove, tongues	gauges, measuring tools		
size range	0 – 50µm	✓					✓			✓			✓					✓															
40 – 70µm	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		✓			✓												✓	✓					
50 – 105µm	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		✓			✓												✓	✓					
70 - 110µm	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓			✓			✓									✓	✓	✓			✓	
80 – 125µm	✓		✓	✓	✓	✓	✓	✓		✓	✓			✓	✓			✓						✓		✓	✓	✓			✓	✓	
90 – 150µm				✓	✓	✓				✓	✓			✓	✓			✓		✓				✓		✓	✓	✓			✓	✓	
100 – 200µm				✓						✓	✓			✓	✓			✓		✓		✓		✓		✓	✓	✓			✓	✓	
150 – 250µm										✓	✓			✓	✓			✓		✓		✓		✓		✓	✓	✓			✓	✓	
200 – 300µm										✓				✓	✓			✓		✓		✓		✓		✓	✓			✓	✓		
200 – 400µm														✓				✓		✓		✓		✓		✓	✓			✓	✓		
300 – 400µm														✓				✓		✓		✓		✓		✓	✓			✓	✓		
400 – 600µm														✓				✓		✓		✓		✓		✓	✓			✓	✓		
400 – 800µm																		✓		✓		✓		✓		✓	✓			✓	✓		
600 – 800µm																		✓		✓		✓		✓		✓	✓			✓	✓		