

Recommendations for the choice of the appropriate microblasting agents

Microblasting agent IEPCONORM	Grain size (standard value)	Surface geometry (topography)	Surface quality (standard value)			Remarks and areas of application
			Ra	N	DIN	
MS 2040 A	400 - 1'200 µm	sharp pointed	6,3	N 9	36	Preparation of adhesive surfaces for PVD- / CVD- and galvanic coatings. Preparation of adhesive surfaces for welding and plasma coatings. General cleaning operation in the tool manufacture. Step-by-step ultrafine processing surfaces, especially after sinking, wire eroding or after chip removal or grinding. Production of pure and defined surface geometries. Removal of surface destructions and loose particles on form materials. Structuration of surfaces.
MS 4090 A	250 - 500 µm		3,2	N 8	30	
MS/S 60 A	200 - 300 µm		2,6	N 8	27	
MS 245 A	50 - 250 µm		0,8 - 1,6	N 6 / 7	18 - 24	
MS 90150 A	75 - 150 µm		1,2	N 7	21	
MS 300 A	30 - 70 µm		1,1	N 5 / 6	21	
MS 475 A	15 - 35 µm		0,4 - 0,8	N 6	12 - 18	
MS 550 A-20	10 - 20 µm		0,5	N 6	15	
MS 245 B	150 - 250 µm	concave	1,0	N 6	21	Densification with silk mat finish. Ultrafine processing of surfaces and targeted densification of surfaces ("Shot Peening" effect). Antiadhesion.
MS 320 B	70 - 110 µm		0,8	N 6	18	
MS 400 B	40 - 60 µm		0,8	N 6	18	
MS 550 B	20 - 30 µm		0,4	N 5	12	
MS 245 BT	150 - 250 µm	concave	1,0	N6	21	For a defined densification as well as integration of heat-proofing (up to 1'000° C), dry antiseize agents. TRIBOFINISH treatment with very good antiadhesion qualities of surfaces.
MS 320 BT	70 - 110 µm		0,9	N 6	18	
MS 400 BT	40 - 60 µm		0,8	N 6	18	
MS 550 BT	20 - 30 µm		0,4	N 5	12	
MS/Z 200 A	125 - 250 µm	sharp pointed	3,2	N 8	30	Cleaning and deburring of medical parts (instruments / implants)
MS/Z 425 A	30 - 125 µm		1,2	N 7	27	
MS/Z 120 B	250 - 425 µm	concave	1,2	N7	21	Ultrafine deburring as well as targeted densification of surfaces ("Shot Peening" effect). Excellent for the defined densification of food and medicine conformal steels (V4A and Ti).
MS/Z 250 B	125 - 250 µm		0,8	N 6	18	
MS/Z 350 B	70 - 125 µm		0,8	N 6	18	
MS/Z 500 B	30 - 70 µm		0,8	N 6	18	
BR 75 A	45 - 100 µm	edged	little changings			Ultrafine deburring of precise mechanical parts for the watch, clock and electronic industry as well as for instruments of the medical technology.
BR 51 B	45 - 63 µm	round	little changings			Ultrafine deburring as well as targeted densification of precise mechanical parts for the watch, clock and electronic industry as well as for instruments of the medical technology.

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SDK 0,4 A SDK 0,6 A	0,4 mm 0,6 mm	sharp pointed	depending on material			Structuration of hard form tool surfaces. Coarse deburring and edge roundness.
SDK 0,4 B SDK 0,6 B	0,4 mm 0,6 mm	concave	depending on material			Shot Peening / densification of all metals. Structuration of hard form tool surfaces.
SR 100 B SR 200 B	50 - 90 µm 50 - 250 µm	round	depending on material			Shot Peening / densification of all metals. Structuration of hard form tool surfaces.
NK 0,2 B NK 0,4 B NK 0,8 B	100 - 200 µm 200 - 400 µm 400 - 800 µm	non-abrasive	constant			Cleaning without abrasion of delicate high-polish surfaces (softblasting). Coated surfaces can also to be cleaned without any problems. Deburring of finest burrs.
NK 0,2 BT NK 0,4 BT NK 0,8 BT	100 - 200 µm 200 - 400 µm 400 - 800 µm	non-abrasive	constant			"TRIBOFINISH" treatment. Fixation of antiseize agents at friction surfaces. Antiadhesion.
K 60 A K 300 A K 700 A K 1200 A	200 - 400 µm 300 - 500 µm 500 - 800 µm 800 - 1'600 µm	non-abrasive	constant			Cleaning without abrasion of form tool surfaces (softblasting). Removal of residues from rubber, parting and separating agents, sediments of colouring pigments and plastics. Coated surfaces can also to be cleaned without any problems. Deburring of finest burrs on plastic parts.

Remarks / comments:

For an optimisation of the pairing properties (adherence, antiadherence) as well as in questions about gliding and sliding characteristics or wear resisting coating possibilities, please do not hesitate to contact us. We are pleased to help you.