



KRAMPE HAREX®

KNOW WHY.

SOLUTIONS THAT MAKE A BLAST

ABRASIVES & SERVICE+



Hardening / Shaping / Roughening & Tarnishing / Deburring / Rust Removal /
Decoating / Descaling / Smoothing & Polishing / Fettling

KNOW WHY OUR SOLUTIONS MAKE A BLAST.

Because with

18,400 m²

of **production space** we're as big as 3 soccer pitches and our just-in-time deliveries are right on target.

Because since

1982

our **know-how** as a specialised manufacturer of abrasives has grown steadily broader and deeper.

Because from

A-Z

we accompany you through **every step of the process** to give you the perfect abrasive **whatever the application**.

Because we operate a

DIN EN ISO 9001:2015

certified **quality management** system.

Because with

21

agents worldwide we're never far away.

Because we offer

100 %

Customised mixes of cast steel and steel cut wire shot.

Because customers from

40

different **countries** worldwide trust in our service and our abrasives.

Argentina
Baltic States
Belgium
Brazil
Chile
Germany
France
Italy
Canada
Netherlands
Austria
Poland
Portugal
Sweden
Slovakia
Spain
Switzerland
Czech Republic
Turkey
USA
Belarus



KRAMPEHAREX® – KNOW WHY EVERY ABRASIVE IS A PLEDGE.

KrampeHarex® is a specialised manufacturer of abrasives with operations all over the world. Our know-how when it comes to blasting processes has grown steadily broader and deeper ever since we were first founded in 1982. Today, first-class precision instruments for a variety of industrial applications are produced at three different locations – built to the highest quality, compliant with international standards and routinely checked and documented in our own QM laboratory.

We offer premium-quality abrasives for every application, guaranteed to be safe and reliable and neither toxic nor silicogenic or carcinogenic. For numerous regular customers, the biggest and most convincing argument for KrampeHarex® is our above-average service. Our aim: to provide you with a tailor-made solution that reconciles your company's specific requirements with economic demands.

Efficient and customised abrasives with precisely matched technology – that's why manufacturers around the world put their trust in KrampeHarex®. Let's get together to optimise your products and your production processes!

THE KRAMPEHAREX® QUALITY PLEDGE:

-  **ISO certified quality management**
-  **Every stage of production subject to inspection**
-  **Guaranteed safe – from raw material to abrasive**

THE KRAMPEHAREX® ENVIRONMENTAL PLEDGE:

-  **100% green power in all processes**
-  **Highly efficient intersectional technologies**
-  **Eco-friendly production and disposal**

KNOW WHY WE TEAM UP BLASTING PROCESSES WITH ABRASIVES.

Our abrasives portfolio includes two product series – Peenox® and Blastex® – for shot peening and shot cleaning. If the abrasive is precisely matched to the blasting process, you profit from high efficiency and perfect results.

A Shot peening

Shot peening is used to harden or shape the surfaces of a workpiece (peen forming); the abrasive particles are rounded due to the hammer effect. Compressive residual stress is induced in the workpiece, so that the initiation of fatigue cracking is significantly delayed. This means more durable components, enhanced fatigue strength under constantly alternating stress conditions and higher dynamic strength in combination with lightweight materials.

- Hardening
- Shaping

B Shot cleaning

Surfaces which are blasted with round or angular abrasives are cleaned and prepared for downstream coating processes. Descaling and deburring of cast or forged components, descaling of and rust removal from steel profiles or the removal of old paint and other coatings are just a few typical examples. Especially when angular abrasives are chosen, shot cleaning alters specific properties of the surfaces. It can be used to roughen brake pad mounts, for instance, create a positive fit with brake pads or roughen surfaces in preparation for a subsequently applied metallic coating, e.g. prior to galvanising.

- Roughening/tarnishing
- Descaling
- Deburring
- Smoothing/polishing
- Decoating
- Fettling
- Rust removal

Shot peening
Compressed air



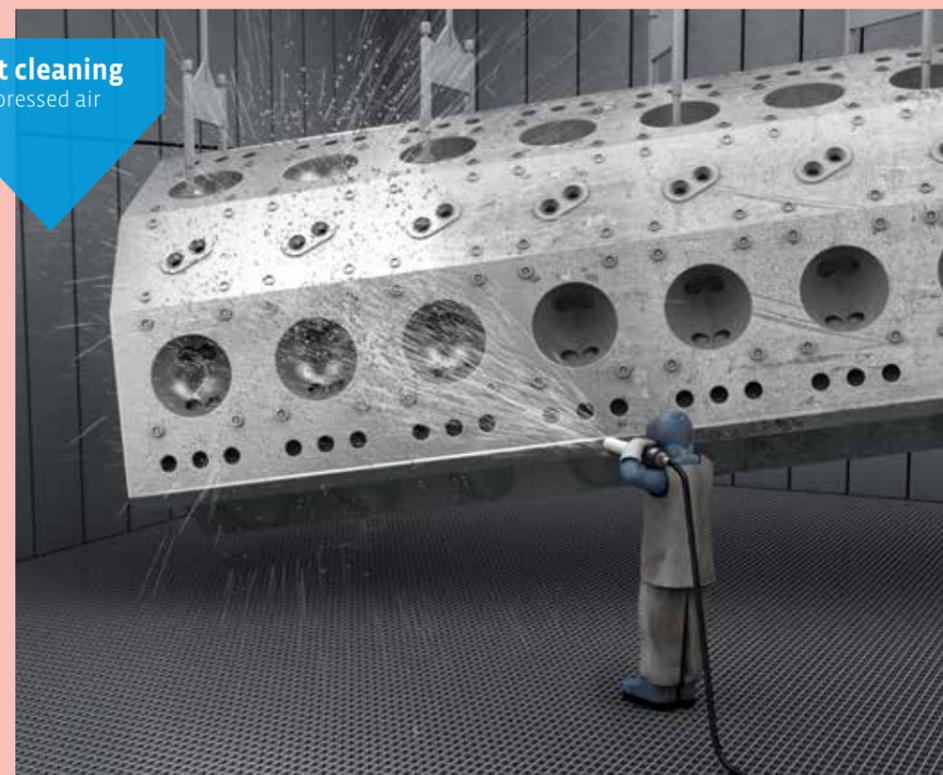
Below: partial hardening
of gear wheels

Shot peening
Shot-blasting wheel



Above: shot peening of coil springs

Shot cleaning
Compressed air



Shot cleaning
Shot-blasting wheel



Right: rust removal
from, and descaling
of, steel girders

Left: manual blasting
of a large cast work-
piece

KNOW WHY
NOT ALL ABRASIVES
ARE ALIKE.

1. SHOT PEENING

2. SHOT CLEANING

GOOD REASONS
TO CHOOSE OUR
ABRASIVES:

- + EXTENSIVE PRODUCT PORTFOLIO
- + QUALITY PLEDGE
- + OPTIMAL ABRASIVE MIX
- + EFFICIENT SOLUTIONS
- + SYSTEM CHECKS
- + SERVICE+

OUR ABRASIVES – YOUR APPLICATIONS.

WB
Shot-blasting
wheel system

AB
Compressed
air system

	STEEL CUT WIRE SHOT					STAINLESS STEEL CUT WIRE SHOT			NON-FERROUS METAL CUT WIRE SHOT				
--	---------------------	--	--	--	--	-------------------------------	--	--	---------------------------------	--	--	--	--

	Peenox® CS	Peenox® CS (as cut)	Peenox® PERFORM+	Peenox® PERFORM+ (as cut)	Blastex® CS	Peenox® ST	Peenox® ST (as cut)	Blastex® ST	Blastex® AL	Blastex® ZN	Blastex® CP	Blastex® BS	Blastex® BZ
--	------------	---------------------	------------------	---------------------------	-------------	------------	---------------------	-------------	-------------	-------------	-------------	-------------	-------------



Special properties & usage	Steel cut wire shot, rounded. For hardening and shaping iron and steel workpieces, especially in vehicle manufacturing, the aviation and aerospace industries and mechanical and apparatus engineering.	Steel cut wire shot, cylindrical. For cleaning and hardening iron and steel workpieces in special applications.	Long-life steel cut wire shot, rounded. For hardening and shaping iron and steel workpieces, especially in vehicle manufacturing, the aviation and aerospace industries and mechanical and apparatus engineering.	Long-life steel cut wire shot, cylindrical. For cleaning and hardening iron and steel workpieces in special applications.	Steel cut wire shot, cylindrical. High blasting performance for efficient cleaning of iron and steel workpieces, especially cast or forged components.	Stainless steel cut wire shot, rounded. For hardening and shaping stainless steel and non-ferrous metal workpieces, especially in vehicle manufacturing, the aviation and aerospace industries and mechanical and apparatus engineering.	Stainless steel cut wire shot, cylindrical. For cleaning and hardening stainless steel and non-ferrous metal workpieces in special applications.	Stainless steel cut wire shot, cylindrical. For efficient cleaning of stainless steel and non-ferrous metal workpieces, especially cast or forged components.	Aluminium cut wire shot, cylindrical. For gentle cleaning and deburring of die-cast aluminium and magnesium workpieces.	Zinc cut wire shot, cylindrical. For gentle cleaning and deburring of die-cast zinc workpieces.	Copper cut wire shot, cylindrical. For gentle cleaning and deburring of copper workpieces as well as for special applications.	Brass cut wire shot, cylindrical. For gentle cleaning and deburring of cast brass workpieces.	Bronze cut wire shot, cylindrical. For gentle cleaning and deburring of bronze workpieces.
----------------------------	---	---	---	---	--	--	--	---	---	---	--	---	--

Shape	○	⊂	○	⊂	⊂	○	⊂	⊂	⊂	⊂	⊂	⊂	⊂
-------	---	---	---	---	---	---	---	---	---	---	---	---	---

Blasting system	AB / WB												
-----------------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------	---------

Hardening	+	+	+	+		+	+						
-----------	---	---	---	---	--	---	---	--	--	--	--	--	--

Shaping	+	+	+	+		+	+						
---------	---	---	---	---	--	---	---	--	--	--	--	--	--

Roughening													
------------	--	--	--	--	--	--	--	--	--	--	--	--	--

Deburring					+			+	+	+	+	+	+
-----------	--	--	--	--	---	--	--	---	---	---	---	---	---

Rust removal					+			+					
--------------	--	--	--	--	---	--	--	---	--	--	--	--	--

Decoating					+			+					
-----------	--	--	--	--	---	--	--	---	--	--	--	--	--

Descaling					+			+	+	+	+	+	+
-----------	--	--	--	--	---	--	--	---	---	---	---	---	---

Smoothing, Polishing													
----------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

Tarnishing													
------------	--	--	--	--	--	--	--	--	--	--	--	--	--

Fettling					+			+					
----------	--	--	--	--	---	--	--	---	--	--	--	--	--

Cleaning					+			+	+	+	+	+	+
----------	--	--	--	--	---	--	--	---	---	---	---	---	---

Structuring								+					
-------------	--	--	--	--	--	--	--	---	--	--	--	--	--

Sweeping													
----------	--	--	--	--	--	--	--	--	--	--	--	--	--

Other applications													
--------------------	--	--	--	--	--	--	--	--	--	--	--	--	--

SHOT PEENING

SHOT CLEANING

OUR ABRASIVES – YOUR APPLICATIONS.

WB
Shot-blasting
wheel system

AB
Compressed
air system

CAST ABRASIVES

NON-METALLIC ABRASIVES

	Steel Shot LC	Steel Shot HC	Steel Grit	Stainless Steel Shot	Stainless Steel Grit	Chilled Iron Shot	Chilled Iron Grit	Ceramic Beads	Glass Beads	Glass Granulate	Fused Alumina	Synthetic Abrasive
PRODUCTS												
Special properties & usage	LC cast steel, round. Long service life, low consumption. For economical cleaning and surface preparation of iron and steel workpieces, especially cast components.	HC cast steel, round. High blasting performance. For economical cleaning and surface preparation of iron and steel workpieces, especially forged components, steel objects and structural steelwork.	Cast steel, angular. For economical cleaning and surface finishing of iron and steel workpieces, also in preparation for coating.	Cast stainless steel, round. For economical cleaning and surface preparation of stainless steel and non-ferrous metal workpieces, especially cast components.	Cast chrome steel, angular. For economical cleaning and surface finishing of stainless steel and non-ferrous metal workpieces, also in preparation for coating.	Chilled iron, round. Not an abrasive. For gravity cleaning, as filling material, for backfilling moulds and as an aggregate for concrete in special applications in industry.	Chilled iron, angular. Hard abrasive for cleaning and surface finishing of iron and steel workpieces with compressed air, also in preparation for coating.	Ceramic beads, round. Very hard abrasive for cleaning, hardening and shaping of workpieces, especially in the aviation and aerospace industries and medical technology.	Glass beads, round. Hard, non-ferrous abrasive for economical cleaning of fragile components and for hardening and shaping workpieces.	Glass granulate, angular. Non-ferrous abrasive for cleaning and roughening the surfaces of metallic and non-metallic workpieces.	Fused alumina, angular. Brown or white fused alumina. For cleaning and roughening surfaces in medical and industrial applications, especially for in the manufacture of laminate.	Synthetic abrasive, angular. Fine abrasive for gentle cleaning and deburring of injection moulded components, paint removal and cleaning of moulds and tools.
Shape	○	○	⊞	○	⊞	○	⊞	○	○	⊞	⊞	⊞
Blasting system	AB / WB	AB / WB	AB / WB	AB / WB	AB / WB		AB	AB / WB	AB	AB	AB	AB
SHOT PEENING		+						+	+			
Shaping		+						+	+			
Roughening			+		+		+			+	+	
Deburring	+	+		+					+			+
Rust removal	+	+	+				+				+	
Decoating	+	+	+	+	+		+	+	+	+	+	+
Descaling	+	+	+	+	+							
SHOT CLEANING								+	+			
Smoothing, Polishing												
Tarnishing			+		+		+			+	+	
Fettling	+	+		+								
Cleaning			+		+		+	+	+	+	+	+
Structuring				+					+		+	
Sweeping			+		+		+					
Other applications						• Ballast • Filling & backfilling • Radiation protection					• Wear protection	

KNOW WHY PEENOX® IS PERFECT FOR SHOT PEENING.

The choice of abrasive is a critical factor in shot peening – regardless of whether the aim is to optimise the load-bearing capacity and durability of safety-relevant components or to enhance the dynamic strength of springs, for example. Our Peenox® product series demonstrably achieves superior shot peening results.

Cut wire shot is a quality product which enhances a workpiece's fatigue strength better than any other metallic abrasive. Peenox® PERFORM+ is a particularly durable material for users seeking a cost-efficient solution.

»A PARTICULARLY DURABLE ABRASIVE«

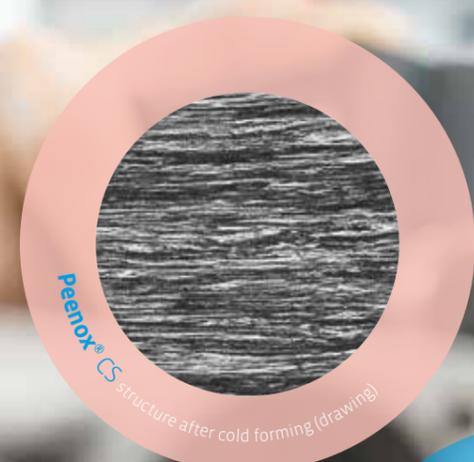
Cylindrical steel cut wire shot

Rounded steel cut wire shot with 3 grades of roundness



	Peenox® CS (to VDFI)		Peenox® CS (to SAE AMS)		Peenox® ST (to SAE AMS)	
Type of abrasive	Steel cut wire shot		Steel cut wire shot		Stainless steel cut wire shot	
Grain shape	Rounded		Rounded		Rounded	
Usage	Surface hardening (shot peening), surface shaping (peen forming)		Surface hardening (shot peening), surface shaping (peen forming)		Surface hardening (shot peening), surface shaping (peen forming)	
Standards	VDFI 8001		SAE AMS 2431/3: Designation AWCR SAE AMS 2431/8: Designation AWCH		SAE AMS 2431/4	
Hardness	HV 640: 610–670 HV1 (56–59 HRC) HV 670: 640–700 HV1 (57–60 HRC) HV 700: 670–730 HV1 (59–61 HRC)		SAE AMS 2431/3: 45–52 HRC (450–550 HV1) SAE AMS 2431/8: 55–62 HRC (600–750 HV1)		Min. 45 HRC (450 HV1)	
Grain size	0.20 mm 0.30 mm 0.35 mm 0.40 mm 0.50 mm 0.60 mm	0.70 mm 0.80 mm 0.90 mm 1.00 mm 1.20 mm	AWC 12: 0.012" (0.30 mm) AWC 14: 0.014" (0.35 mm) AWC 17: 0.017" (0.40 mm) AWC 20: 0.020" (0.50 mm) AWC 23: 0.023" (0.60 mm) AWC 28: 0.028" (0.70 mm) AWC 32: 0.032" (0.80 mm)	AWC 35: 0.035" (0.90 mm) AWC 41: 0.041" (1.00 mm) AWC 47: 0.047" (1.20 mm) AWC 54: 0.054" (1.40 mm) AWC 62: 0.062" (1.60 mm) AWC 80: 0.080" (2.00 mm) AWC 96: 0.096" (2.40 mm)	AWS 12: 0.012" (0.30 mm) AWS 14: 0.014" (0.35 mm) AWS 17: 0.017" (0.40 mm) AWS 20: 0.020" (0.50 mm) AWS 23: 0.023" (0.60 mm) AWS 28: 0.028" (0.70 mm) AWS 32: 0.032" (0.80 mm)	AWS 35: 0.035" (0.90 mm) AWS 41: 0.041" (1.00 mm) AWS 47: 0.047" (1.20 mm) AWS 54: 0.054" (1.40 mm) AWS 62: 0.062" (1.60 mm) AWS 80: 0.080" (2.00 mm) AWS 96: 0.096" (2.40 mm)
	Other grain sizes and mixes on request		Other grain sizes and mixes on request		Other grain sizes and mixes on request	
Packaging	Bag 25 kg	BigBag 1000 kg	Drum 907 kg	Bag 25 kg	BigBag 1000 kg	Drum 907 kg

	Peenox® PERFORM+ (to VDFI)		Peenox® PERFORM+ (to SAE AMS)			
Type of abrasive	Steel cut wire shot		Steel cut wire shot			
Grain shape	Rounded		Rounded			
Usage	Surface hardening (shot peening), surface shaping (peen forming)		Surface hardening (shot peening), surface shaping (peen forming)			
Standards	VDFI 8001 Customer-specific requirements		SAE AMS 2431/3: Designation AWCR SAE AMS 2431/8: Designation AWCH Customer-specific requirements			
Hardness	HV 640: 610–670 HV1 (56–59 HRC) HV 670: 640–700 HV1 (57–60 HRC) HV 700: 670–730 HV1 (59–61 HRC) HV 800: 770–830 HV1 (63–65 HRC)		SAE AMS 2431/3: 45–52 HRC (450–550 HV1) SAE AMS 2431/8: 55–62 HRC (600–750 HV1) SAE AMS 2431: 63–65 HRC (770–830 HV1)			
Grain size	0.30 mm 0.35 mm 0.40 mm 0.50 mm 0.60 mm	0.70 mm 0.80 mm 0.90 mm 1.00 mm 1.20 mm	AWC 12: 0.012" (0.30 mm) AWC 14: 0.014" (0.35 mm) AWC 17: 0.017" (0.40 mm) AWC 20: 0.020" (0.50 mm) AWC 23: 0.023" (0.60 mm) AWC 28: 0.028" (0.70 mm)	AWC 32: 0.032" (0.80 mm) AWC 35: 0.035" (0.90 mm) AWC 41: 0.041" (1.00 mm) AWC 47: 0.047" (1.20 mm) AWC 54: 0.054" (1.40 mm) AWC 62: 0.062" (1.60 mm)		
	Other grain sizes and mixes on request		Other grain sizes and mixes on request			
Packaging	Bag 25 kg	BigBag 1000 kg	Drum 907 kg	Bag 25 kg	BigBag 1000 kg	Drum 907 kg



»EFFICIENT, HIGH PERFORMANCE ABRASIVES«

KNOW WHY BLASTEX® IS PERFECT FOR SHOT CLEANING.

Deburring, desanding, descaling, cleaning: all the most important aftertreatment activities on cast or forged components are normally carried out using the proven shot-blasting wheel process. Blastex® by KrampeHarex® offers ideal material properties for this purpose and is available in all relevant materials.

High-quality basic material is used by KrampeHarex® to obtain first-class abrasives with a precise geometry, preventing subsequent surface irregularities and ensuring excellent blasting results.

Blastex®



Blastex® CS
Steel cut wire shot



Blastex® ST
Stainless steel cut wire shot



Blastex® AL
Aluminium cut wire shot



Blastex® ZN
Zinc cut wire shot



Blastex® CP
Copper cut wire shot

	Blastex® CS 			Blastex® ST 		
Type of abrasive	Steel cut wire shot			Stainless steel cut wire shot		
Grain shape	Cylindrical			Cylindrical		
Usage	Deburring, rust removal, decoating, descaling, fettling, cleaning			Deburring, rust removal, decoating, descaling, fettling, cleaning, structuring		
Standards	Works standard (based on DIN 8201-4)			DIN 8201-4		
Hardness	400-550 HV1 (40-55 HRC)			1.4301: 400-550 HV1 (41-52 HRC) 1.4310: 500-650 HV1 (49-58 HRC)		
Grain size	0.40 mm 0.60 mm 0.80 mm 1.00 mm 1.20 mm 1.40 mm	1.60 mm 1.80 mm 2.00 mm 2.20 mm 2.40 mm 2.60 mm		0.30 mm 0.35 mm 0.40 mm 0.50 mm 0.60 mm 0.70 mm	0.80 mm 0.90 mm 1.00 mm 1.20 mm 1.40 mm 1.60 mm	1.80 mm 2.00 mm 2.20 mm 2.40 mm 2.60 mm
	<i>Other grain sizes and mixes on request</i>			<i>Other grain sizes and mixes on request</i>		
Packaging	 Bag 25 kg	 BigBag 1000 kg	 Drum 907 kg	 Bag 25 kg	 BigBag 1000 kg	 Drum 907 kg

-  Top-quality basic materials
-  High performance
-  Optimal blasting results
-  Long service life
-  Low system wear
-  No contact corrosion if identical materials are used

	Blastex® AL 		Blastex® ZN 		Blastex® CP 	
Type of abrasive	Aluminium cut wire shot		Zinc cut wire shot, ZincPlus cut wire shot		Copper cut wire shot	
Grain shape	Cylindrical		Cylindrical		Cylindrical	
Usage	Deburring, descaling, cleaning, fettling		Deburring, descaling, cleaning, fettling		Deburring, descaling, cleaning, fettling	
Standards	Based on DIN 8201-4		Based on DIN 8201-4		Based on DIN 8201-4	
Hardness	90-140 HV0.5 (depending on material grade)		Zinc cut wire shot: 35-40 HV0.2 ZincPlus cut wire shot: 40-45 HV0.2		110-140 HV0.5	
Grain size	0.40 mm 0.50 mm 0.60 mm 0.70 mm 0.80 mm	0.90 mm 1.00 mm 1.20 mm 1.40 mm 1.60 mm	0.50 mm 0.60 mm 0.70 mm 0.80 mm 0.90 mm	1.00 mm 1.20 mm 1.40 mm 1.60 mm	0.40 mm 0.50 mm 0.60 mm 0.70 mm 0.80 mm 0.90 mm 1.00 mm	1.20 mm 1.40 mm 1.60 mm 1.80 mm 2.00 mm 2.20 mm 2.40 mm
	<i>Other grain sizes and mixes on request</i>		<i>Other grain sizes and mixes on request</i>		<i>Other grain sizes and mixes on request</i>	
Packaging	 Bag 8 kg	 BigBag 400 kg	 Bag 25 kg	 BigBag 1000 kg	 Bag 25 kg	 BigBag 1000 kg

»COST-EFFICIENT
ABRASIVES FOR
THE MOST DIVERSE
APPLICATIONS«

	Steel Shot LC 	Steel Shot HC 	Steel Grit 
Type of abrasive	LC cast steel	HC cast steel	Cast steel
Grain shape	Round	Round	Angular
Usage	Deburring, rust removal, decoating, descaling, fettling	Hardening, shaping, deburring, rust removal, decoating, descaling, fettling	Roughening, rust removal, decoating, tarnishing, sweeping
Standards	SAE J444 ISO 11124-4	Works standard, SAE J444, ISO 11124-3 (DIN 8201-2)	Works standard, SAE J444, ISO 11124-3 (DIN 8201-2)
Hardness	New material: 40–50 HRC (400–520 HV1) Operating mix: 46–50 HRC (460–520 HV1)	46–51 HRC (450–535 HV1)	46–52 HRC (480–550 HV1): type GP 53–57 HRC (570–650 HV1): type GL Min. 64 HRC (min. 800 HV1): type GH
Grain size	S 70: 0.12–0.43 mm S 390: 0.85–1.70 mm S 110: 0.18–0.60 mm S 460: 1.00–2.00 mm S 170: 0.36–0.85 mm S 550: 1.18–2.00 mm S 230: 0.50–1.00 mm S 660: 1.40–2.36 mm S 280: 0.60–1.18 mm S 780: 1.70–2.80 mm S 330: 0.71–1.40 mm	S 70: 0.12–0.50 mm S 390: 0.85–1.70 mm S 110: 0.18–0.71 mm S 460: 1.00–2.00 mm S 170: 0.42–0.85 mm S 550: 1.18–2.36 mm S 230: 0.50–1.00 mm S 660: 1.70–2.80 mm S 280: 0.60–1.18 mm S 780: 1.70–2.80 mm S 330: 0.71–1.40 mm	G 120: 0.07–0.35 mm G 18: 0.85–1.70 mm G 80: 0.12–0.50 mm G 16: 1.00–2.00 mm G 50: 0.30–0.85 mm G 14: 1.18–2.36 mm G 40: 0.50–1.18 mm G 12: 1.40–2.80 mm G 25: 0.60–1.40 mm
	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>
Packaging	 Bag 25 kg  BigBag 1000 kg	 Bag 25 kg  BigBag 1000 kg	 Bag 25 kg  BigBag 1000 kg

	Stainless Steel Shot 	Stainless Steel Grit 	Chilled Iron Grit 
Type of abrasive	Cast stainless steel	Cast chrome steel	Chilled iron
Grain shape	Round	Angular	Angular
Usage	Deburring, decoating, descaling, fettling, structuring	Roughening, decoating, tarnishing, sweeping	Rust removal, decoating, sweeping
Standards	Works standard	Works standard	ISO 11124-2 (DIN 8201-3)
Hardness	New material: approx. 30 HR C (300 HV1) Operating mix: approx. 47 HR C (475 HV1)	Approx. 58 HR C (660 HV1)	Min. 64 HRC (min. 800 HV1)
Grain size	S 10: 0.05–0.20 mm S 100: 1.00–1.40 mm S 20: 0.09–0.32 mm S 150: 1.25–1.70 mm S 30: 0.14–0.50 mm S 200: 1.40–2.00 mm S 40: 0.40–0.80 mm S 300: 1.70–3.00 mm S 50: 0.60–1.00 mm S 60: 0.70–1.25 mm	GM 10: 0.05–0.20 mm GM 100: 1.00–1.40 mm GM 20: 0.09–0.32 mm GM 150: 1.25–1.70 mm GM 30: 0.14–0.50 mm GM 200: 1.40–2.00 mm GM 40: 0.40–0.80 mm GM 300: 1.70–3.00 mm GM 50: 0.60–1.00 mm GM 60: 0.70–1.25 mm	G 05: 0.10–0.30 mm G 39: 1.00–1.40 mm G 07: 0.20–0.40 mm G 47: 1.20–1.70 mm G 12: 0.30–0.70 mm G 55: 1.40–2.00 mm G 17: 0.40–0.80 mm G 66: 1.70–2.40 mm G 24: 0.60–1.00 mm G 80: 2.00–2.80 mm G 34: 0.80–1.20 mm
	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>
Packaging	 Bag 25 kg  BigBag 1000 kg  Drum 750 kg  Canister 25 kg	 Bag 25 kg  BigBag 1000 kg  Drum 750 kg  Canister 25 kg	 Bag 25 kg  BigBag 1000 kg

Cast abrasives



Steel Shot LC
LC cast steel



Steel Shot HC
HC cast steel



Steel Grit
Cast steel



Stainless Steel Shot
Cast stainless steel



Stainless Steel Grit
Cast chrome steel



Chilled Iron Grit
Chilled iron

KNOW WHY
QUALITY
IS CRITICAL.

PRODUCT DATA
SHEETS ON:
www.krampeharex.com

Ceramic Beads



Glass Beads



Fused Alumina



Type of abrasive	Ceramic beads	Glass beads	Brown fused alumina, white fused alumina
Grain shape	Round	Round	Angular
Usage	Hardening, shaping, decoating, smoothing, polishing, cleaning	Hardening, shaping, deburring, decoating, smoothing, polishing, cleaning, structuring	Roughening, rust removal, decoating, tarnishing, cleaning, structuring, wear protection
Standards	SAE J1830 SAE AMS 2431/7	DIN 8201-7	DIN 8201-6 FEPA
Hardness	Hardness (Mohs): approx. 7-7.5 Mohs Hardness (Rockwell): approx. 60 HRC Hardness (Vickers): approx. 700 HV	Hardness (Mohs): approx. 6-7 Mohs Hardness (Rockwell): approx. 58 HRC Hardness (Vickers): approx. 645 HV	Hardness (Mohs): approx. 8-9 Mohs
Grain size	B 205: 0-63 µm B 125: 0-125 µm B 120: 63-125 µm B 60: 125-250 µm B 40: 250-425 µm B 30: 425-600 µm B 20: 600-850 µm	40-70 µm 70-110 µm 90-150 µm 100-200 µm 150-250 µm 200-300 µm 300-400 µm 400-850 µm	F 12: 1400-2000 µm F 14: 1180-1700 µm F 16: 1000-1400 µm F 20: 850-1180 µm F 22: 710-1000 µm F 24: 600-850 µm F 30: 500-710 µm F 36: 425-600 µm F 40: 335-500 µm F 46: 300-425 µm F 54: 300-425 µm F 60: 212-300 µm F 70: 180-250 µm F 80: 150-212 µm F 90: 125-180 µm F 100: 106-150 µm F 120: 90-125 µm F 150: 63-106 µm F 180: 63-90 µm F 220: 53-75 µm
	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>	<i>Other grain sizes and mixes on request</i>
Packaging	Canister 25 kg BigBag 1000 kg Drum 25 kg	Bag 25 kg BigBag 500/1000 kg	Bag 25 kg BigBag 1000 kg

Non-metallic abrasives



Ceramic Beads



Glass Beads



Fused Alumina

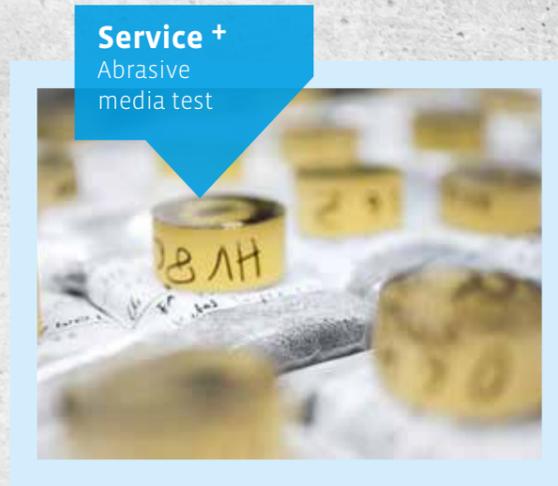
KNOW WHY WE ACCOMPANY YOU THROUGH EVERY STEP. THAT'S SERVICE+

The significance of abrasives is growing steadily as the demands facing manufacturers in the global market increase. A fundamental analysis of the blasting processes is vital for efficient and cost-effective working. That's why we offer you not only premium-quality abrasives for any application but also a comprehensive package of services.

In direct interaction with you, we share our knowledge, discuss questions, resolve problems and develop new ideas. We accompany you from the identification of the optimal abrasive all the way to the impeccably blasted workpiece. We search for solutions until we find the one that meets your requirements perfectly. We want you to understand what you have to gain from entering into a partnership with us.

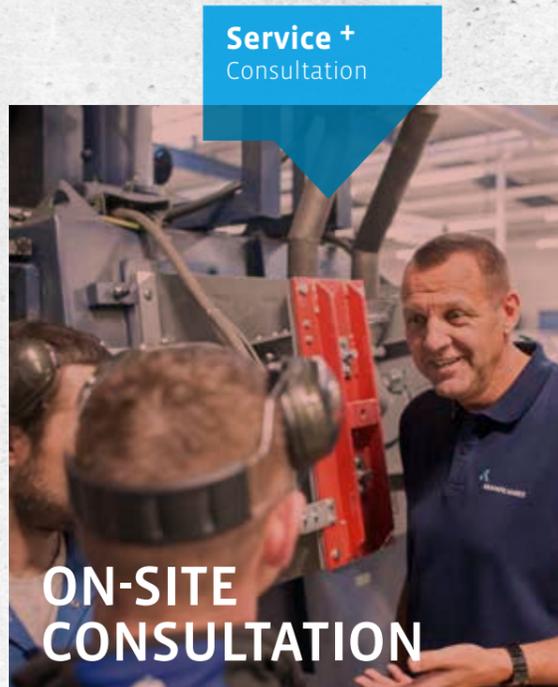
Service+ solutions for your project:

- Consultation
- Measuring
- System check
- Abrasive media test
- Customised mixes
- Quality system



For premium quality.

We examine the quality of your abrasives for you and determine their durability by means of an Ervin test. That way, you can be certain that the abrasives you choose also satisfy your cost-efficiency requirements.



For optimal processes.

By taking samples directly on your site, we can test the composition of the operating mix in the blasting system and identify possible malfunctions before they have a chance to occur. If a more in-depth investigation is necessary, this is done in our own lab using the latest measuring and inspection technology.

For the right abrasive media.

Material, specific weight, grain shape & size, hardness: starting with the customer's blasting requirements, we identify the optimal abrasive for your application – precisely matched to the blasting time and intensity as well as the conditions in the works. From screen analyses to abrasive media tests, we master all relevant methods.



Service + Custom-made



For customised mixes.

We are the only provider to offer three metallic abrasives – steel cut wire shot as well as high-carbon and low-carbon cast steel – which are represented equally in our portfolio. We are thus also in a position to offer special mixes of cast steel and steel cut wire shot.



For the optimal configuration.

During the blasting process we carry out system checks on-site at your facilities, inspecting process-relevant system components such as turbines, air separators and filters in order to determine whether your system is optimally configured.

»We inspect all abrasives in our own laboratory at every stage of production, based on the most stringent criteria.«

Marita Lenkenhoff, Test Lab





KRAMPE HAREX®

KNOW WHY.

GERMANY

KrampeHarex GmbH & Co. KG
Pferdekamp 6-8
D-59075 Hamm

Phone +49 (0)2381977 977
Fax +49 (0)2381977 955
Internet www.krampeharex.com
Email info@krampeharex.com

KrampeHarex Leisnig GmbH
Gorschmitzer Weg 2f
D-04703 Leisnig

Phone +49 (0)34321 - 63620
Fax +49 (0)34321 - 636 211
Internet www.krampeharex.com
Email leisnig@krampeharex.com

CZECH REPUBLIC

KrampeHarex CZ spol. sr. o.
Osvobozeni 234
CZ-66481 Ostrovacice

Phone +420 549 245 064
Fax +420 541 247 817
Internet www.krampeharex.cz
Email info@krampeharex.cz

