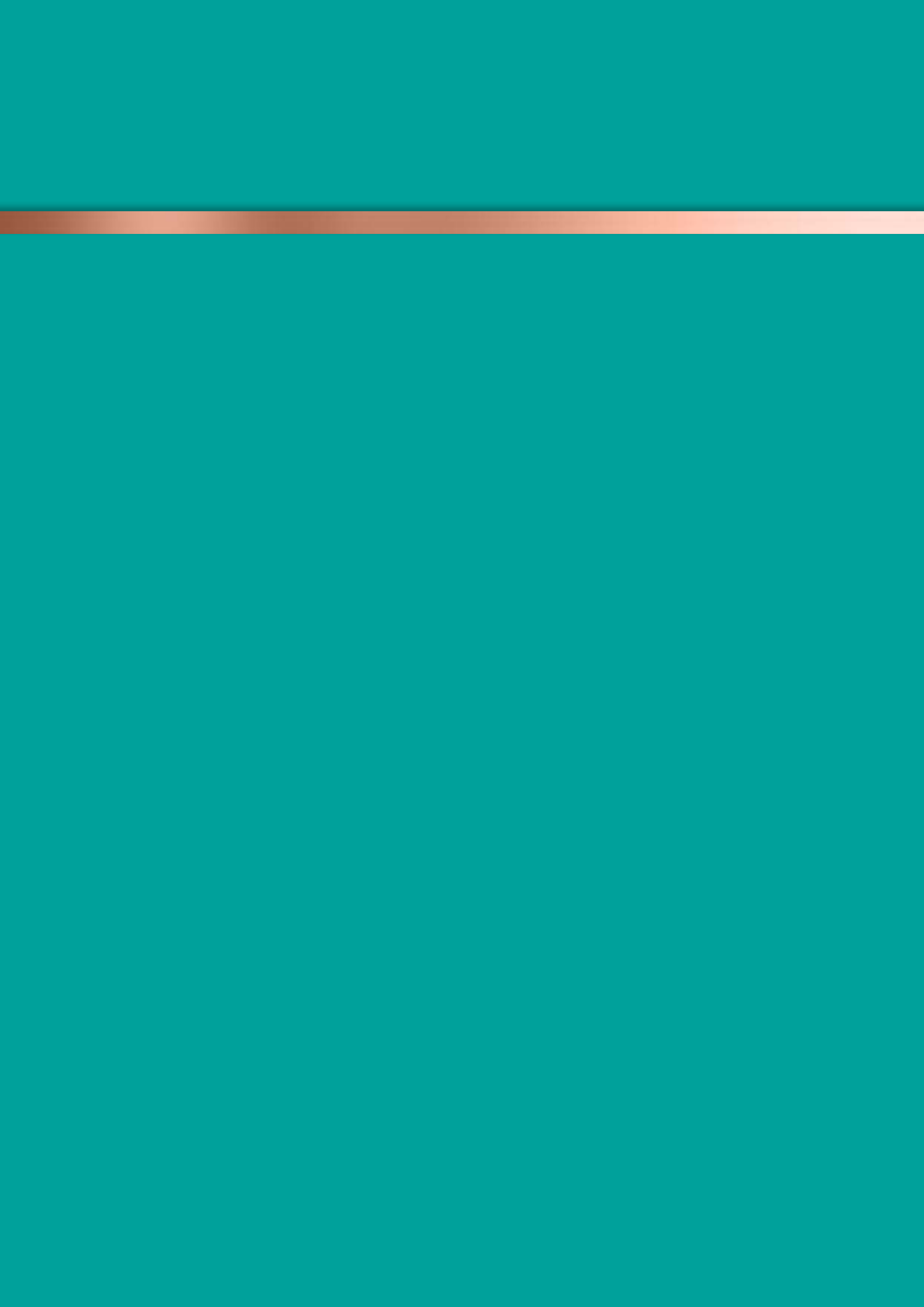




Kuhmichel
ABRASIVES FOR EXPERTS



FROM EXPERT
TO EXPERT



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From expert to expert.



In-depth surface technology

Just as you are the expert on your product, we are the experts on everything that can perfect your product.

At Kuhmichel, we are proud of the fact that we have one of the most diverse ranges of abrasive media and minerals in Europe.



Partnership is our philosophy.

Our customers

Our sales process has successfully ensured that many of our customers are long-standing ones. We understand that trust is not won overnight, and our goal is to build long-term partnerships with our customers.

A Kuhmichel customer

- knows where to find us when he needs high-quality abrasives;
- knows that Kuhmichel has the widest range on the market;
- knows that we understand the processes because of personal training and experience;
- trusts our advice, because we know what he wants;
- has confidence in us, knowing that we are not just interested in a quick sale.



Quality and safety combined.



Good quality safely assured

Quality and safety are inextricably linked at Kuhmichel. The quality of our products is defined by numerous industry and customer standards. The safety of our products is so important that to us, quality equals safety. All of our products are tested at our in-house and external laboratories to ensure that they satisfy our high quality and safety requirements.



We value our resources.

Sustainability

Environmental protection is vital. Material sustainability, a necessary process in today's world, can be extremely cost-effective in the long term. With this in mind, we built Europe's largest abrasive recycling plant in 2012.

Our focus is on the processing and reutilisation of spent mineral and metallic blast residues, used grinding wheels, ceramic/metallic coating powders, and materials from the refractory industry.





Here, there and everywhere.

Being close to our customers is important to us. Therefore Kuhmichel is international and we speak many languages.



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White fused alumina

Areas of application

- Reusable abrasive, fine abrasive, dry abrasive, wet abrasive
- Bonded grinding wheels
- Grinding media on underlay
- Loose grinding medium
- Refractory products
- Electrical engineering
- Wear protection
- Catalyst supports
- Thermosetting plastics

Blasting systems

- Pressure blast machines
- Injector blast cabinets

Packaging

- 25/20 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Customer approvals

- PMC 3052 (Pratt & Whitney)
- CSS12 (Rolls-Royce)
- ABR 9-0160 (Airbus)

Deliverable standards and specifications

- FEPA F Standard
- FEPA P Standard
- EN ISO 11126-7
- DIN ISO 8486-1
- DIN 8201-6
- DIN EN 4637
- MIL A-A-59316
- ANSI B74-12
- JIS R6001
- DMR71-100
- NF L 06-828
- D50TF5 Class A (GE)

White fused alumina is a product for high-tech applications. Our customers in the medical, aerospace and optical industries attach great importance to this iron-free material, which offers the highest purity, a high degree of whiteness, extreme hardness and a large selection of precise grain sizes, down to 3µm.

Physical properties

Hardness	9 mohs
Grain shape	angular
Melting point	approx. 2,050°C
Specific gravity	approx. 3.9 – 4.1 g/cm ³
Bulk density*	approx. 0.8 – 2.1 g/cm ³

*depending on granular size

Typical chemical analysis

	White fused alumina macro	White fused alumina micro
Al ₂ O ₃	99.73 %	99.69 %
Na ₂ O	0.14 %	0.20 %
Fe ₂ O ₃	0.03 %	0.02 %
SiO ₂	0.01 %	0.03 %
CaO	0.02 %	0.05 %
TiO ₂	0.02 %	0.01 %
MgO	0.01 %	0.01 %



Available grain sizes

White fused alumina macro			
FEPA	Grain size range (µm)	FEPA	Grain size range (µm)
F008	2000 – 2800	F046	300 – 425
F010	1700 – 2360	F054	250 – 355
F012	1400 – 2000	F060	212 – 300
F014	1180 – 1700	F070	180 – 250
F016	1000 – 1400	F080	150 – 212
F020	850 – 1180	F090	125 – 180
F022	710 – 1000	F100	106 – 150
F024	600 – 850	F120	90 – 125
F030	500 – 710	F150	63 – 106
F036	425 – 600	F180	53 – 90
F040	355 – 500	F220	45 – 75

Metric	Grain size range (mm)
	0.25 – 0.50
	0.50 – 1.00

Other grain sizes can be produced on request.

White fused alumina micro			
FEPA	Grain size range		
	ds3 factor max. µm	ds50 factor µm	ds94 factor min. µm
F230	82	53.0 +/- 3.0	34
F240	70	44.5 +/- 2.0	28
F280	59	36.5 +/- 1.5	22
F320	49	29.2 +/- 1.5	16.5
F360	40	22.8 +/- 1.5	12
F400	32	17.3 +/- 1.0	8
F500	25	12.8 +/- 1.0	5
F600	19	9.3 +/- 1.0	3
F800	14	6.5 +/- 1.0	2
F1000	10	4.5 +/- 0.8	1
F1200	7	3.0 +/- 0.5	1.0*

*at 80 %



Brown fused alumina

Areas of application

- Reusable abrasive, fine abrasive, dry abrasive, wet abrasive
- Bonded grinding wheels
- Grinding media on underlay
- Loose grinding medium
- Refractory products
- Aggregate/filler

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1t
- 1 t loose in a big bag

Customer approvals

- CSS12 (Rolls-Royce)
- ABR 9-0160 (Airbus)
- PMC 3046 (Pratt & Whitney)
- PMC 3052 (Pratt & Whitney)
- PMC 3132 (Pratt & Whitney)

Deliverable standards and specifications

- FEPA F Standard
- FEPA P Standard
- EN ISO 11126-7
- DIN ISO 8486-1
- DIN 8201-6
- MIL A-A-59316
- ANSI B74-12
- JIS R6001
- NF EN 4638
- D50TF5 Class A+D
- DMR71-100
- NF L 06-829

When it comes to a good price/performance ratio, normal corundum is the first choice for angular mineral products. In addition to its high hardness, normal corundum is also characterised by a pronounced toughness, which gives this iron-free blasting abrasive extreme stability.

Physical properties

Hardness	9 mohs
Grain shape	angular
Melting point	approx. 1,950 °C
Specific gravity	approx. 3.9 – 4.1 g/cm ³
Bulk density*	approx. 1.5 – 2.1 g/cm ³

*depending on granular size

Typical chemical analysis

	Brown fused alumina macro	Brown fused alumina micro
Al ₂ O ₃	95.65 %	94.20 %
TiO ₂	2.42 %	2.79 %
Fe ₂ O ₃	0.12 %	0.33 %
SiO ₂	0.92 %	1.34 %
CaO	0.35 %	0.33 %





Available grain sizes

Brown fused alumina macro

FEPA	Grain size range (µm)	FEPA	Grain size range (µm)
F008	2000 – 2800	F046	300 – 425
F010	1700 – 2360	F054	250 – 355
F012	1400 – 2000	F060	212 – 300
F014	1180 – 1700	F070	180 – 250
F016	1000 – 1400	F080	150 – 212
F020	850 – 1180	F090	125 – 180
F022	710 – 1000	F100	106 – 150
F024	600 – 850	F120	90 – 125
F030	500 – 710	F150	63 – 106
F036	425 – 600	F180	53 – 90
F040	355 – 500	F220	45 – 75

Metric	Grain size range (mm)
	0.06 – 0.12
	0.12 – 0.25
	0.25 – 0.50
	0.50 – 1.00
	1.00 – 2.00
	1.00 – 3.00

Other grain sizes can be produced on request.

Brown fused alumina micro

FEPA	Grain size range		
	ds3 factor max. µm	ds50 factor µm	ds94 factor min. µm
F230	82	53.0 +/- 3.0	34
F240	70	44.5 +/- 2.0	28
F280	59	36.5 +/- 1.5	22
F320	49	29.2 +/- 1.5	16.5
F360	40	22.8 +/- 1.5	12
F400	32	17.3 +/- 1.0	8
F500	25	12.8 +/- 1.0	5
F600	19	9.3 +/- 1.0	3
F800	14	6.5 +/- 1.0	2
F1000	10	4.5 +/- 0.8	1
F1200	7	3.0 +/- 0.5	1.0*

*at 80 %



Brown fused alumina FeSi

Areas of application

- Reusable abrasive
- Wear protection

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Brown fused alumina FeSi is an alternative where the typical fused alumina properties are required but iron-free is not important. The combination of hardness and high weight make this blast media very effective.

Physical properties

Hardness	9 mohs
Grain shape	angular
Melting point	approx. 1,500 °C
Specific gravity	approx. 5.5 g/cm ³
Bulk density*	approx. 2.2 – 3.0 g/cm ³

*depending on granular size

Typical chemical analysis

Al ₂ O ₃	39.00 %
TiO ₂	0.90 %
Fe ₂ O ₃	0.30 %
SiO ₂	0.30 %
Fe	46.00 %
Si	7.20 %
Ti	3.00 %

Available grain sizes

Metric	Grain size range (mm)
	0.12 – 0.25
	0.25 – 0.50
	0.50 – 1.00
	0.50 – 1.50
	1.00 – 1.50
	1.00 – 2.00

Other grain sizes can be produced on request.



Pink fused alumina

Areas of application

- Reusable abrasive, fine abrasive, dry abrasive, wet abrasive
- Bonded grinding wheels
- Grinding media on underlay

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Customer approvals

- CSS12 (Rolls-Royce)

Deliverable standards and specifications

- FEPA F
- FEPA P
- EN ISO 11126-7
- DIN ISO 8486-1
- MIL A-A-59316
- ANSI B74-12
- JIS R6001
- D50TF5 Class A+D

Available grain sizes

FEPA	Grain size range (µm)	FEPA	Grain size range (µm)	FEPA	Grain size range (µm)
F 008	2000 – 2800	F 030	500 – 710	F 080	150 – 212
F 010	1700 – 2360	F 036	425 – 600	F 090	125 – 180
F 012	1400 – 2000	F 040	355 – 500	F 100	106 – 150
F 014	1180 – 1700	F 046	300 – 425	F 120	90 – 125
F 016	1000 – 1400	F 054	250 – 355	F 150	63 – 106
F 020	850 – 1180	F 060	212 – 300	F 180	53 – 90
F 022	710 – 1000	F 070	180 – 250	F 220	45 – 75
F 024	600 – 850				

Other grain sizes can be produced on request.

Our customers use pink fused alumina either as a blasting abrasive or in the manufacture of bonded/coated abrasives. The presence of chromium oxide in this material makes pink aluminium oxide both tough and durable.

Physical properties

Hardness	9 mohs
Grain shape	angular
Melting point	approx. 2,050 °C
Specific gravity	approx. 3.9 – 4.1 g/cm ³
Bulk density*	approx. 1.3 – 2.0 g/cm ³

*depending on granular size

Typical chemical analysis

Al ₂ O ₃	99.30 %
Cr ₂ O ₃	0.30 %
Na ₂ O	0.30 %
Fe ₂ O ₃	0.05 %
CaO	0.05 %



Mixed alumina

Areas of application

- Reusable abrasive, fine abrasive, dry abrasive, wet abrasive
- Bonded grinding wheels
- Refractory products
- Wear protection

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- FEPA F Standard

Mixed alumina is a regenerate of grinding wheels and abrasive residues. After extensive processing in our plant in Ballenstedt, a low-priced, iron-free product is produced. Our customers like to use mixed alumina for many cost-effective, different blast operations.

Physical properties

Hardness	9 mohs
Grain shape	angular
Melting point	approx. 2,000 °C
Specific gravity	approx. 3.9 g/cm ³
Bulk density*	approx. 1.5 – 1.8 g/cm ³

Typical chemical analysis

*depending on granular size

Al ₂ O ₃	88.10 %
SiO ₂	6.80 %
TiO ₂	0.70 %
CaO	0.30 %
MgO	0.30 %
Fe ₂ O ₃	0.20 %
SIC	5.80 %

Available grain sizes

FEPA	Grain size range (µm)	FEPA	Grain size range (µm)	FEPA	Grain size range (µm)
F 008	2000 – 2800	F 030	500 – 710	F 080	150 – 212
F 010	1700 – 2360	F 036	425 – 600	F 090	125 – 180
F 012	1400 – 2000	F 040	355 – 500	F 100	106 – 150
F 014	1180 – 1700	F 046	300 – 425	F 120	90 – 125
F 016	1000 – 1400	F 054	250 – 355	F 150	63 – 106
F 020	850 – 1180	F 060	212 – 300	F 180	53 – 90
F 022	710 – 1000	F 070	180 – 250	F 220	45 – 75
F 024	600 – 850				

Other grain sizes can be produced on request.



SIBASIV

Areas of application

- Reusable abrasive
- Refractory products
- Concrete aggregate

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

SIBASIV is an inert, iron-free and economical alternative to conventional fused alumina grades. Due to its high proportion of titanium dioxide, this abrasive is very tough, and achieves a service life of up to 20 cycles.

Physical properties

Hardness	8 mohs
Grain shape	angular
Melting point	approx. 1,350 °C
Specific gravity	approx. 3.1 g/cm ³
Bulk density*	approx. 1.2 – 1.6 g/cm ³

*depending on granular size

Typical chemical analysis

Al ₂ O ₃	88.26 %
SiO ₂	7.20 %
TiO ₂	3.40 %
Fe ₂ O ₃	1.78 %
CaO	0.49 %
MgO	0.15 %

Available grain sizes

Metric	Grain size range (mm)
	0.25 – 0.50
	0.50 – 1.00
	1.00 – 1.50
	1.00 – 2.00

Other grain sizes can be produced on request.



Emery

Areas of application

- Reusable abrasive
- Rust removal
- Paint stripping
- Roughening

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Emery is a blast abrasive made of natural minerals. This inexpensive product does not quite offer the service life of brown fused alumina and blasting bauxite, SIBASIV, but is classed as “typical for corundum” in its iron-free content and removal capacity.

Physical properties

Hardness	approx. 7.5 – 8.5 mohs
Grain shape	angular
Melting point	approx. 1,400 °C
Specific gravity	approx. 3.5 – 4.0 g/cm ³
Bulk density*	approx. 1.6 – 1.9 g/cm ³

*depending on granular size

Typical chemical analysis

Al ₂ O ₃	61.74 %
Fe ₂ O ₃	24.65 %
SiO ₂	7.31 %
TiO ₂	2.84 %
CaO	3.16 %
MgO	0.34 %

Available grain sizes

Metric	Grain size range (mm)
	0.25 – 0.50
	0.50 – 1.00
	1.00 – 1.50
	1.00 – 2.00

Other grain sizes can be produced on request.



Garnet

Areas of application

- Single-use abrasive, reusable abrasive, fine abrasive, wet abrasive and dry abrasive
- Water jet cutting technology, high-pressure water jet cutting (HPWJC)
- Cleaning building exteriors
- Sweeping

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag
- 25 kg sacks in a big bag up to 1 t

Customer approvals

- CSS211 (Rolls-Royce)

Garnet sand is a natural mineral and an iron-free abrasive. The main field of application is high-pressure water jet cutting. In addition, many customers use garnet sand for blasting.

Physical properties

Hardness	approx. 7.5 – 8 mohs
Grain shape	angular
Melting point	approx. 1,300 °C
Specific gravity	approx. 3.5 – 4.3 g/cm ³
Bulk density*	approx. 1.9 – 2.2 g/cm ³

Typical chemical analysis ^{*depending on granular size}

SiO ₂ (no free silica)	35.00 %
Fe ₂ O ₃	33.00 %
Al ₂ O ₃	23.00 %
MgO	7.00 %
MnO	1.00 %
CaO	1.00 %

Available grain sizes

		GARNET for sweeping and cleaning building exteriors		GARNET for high-pressure water jet cutting	
MESH	Grain size range (mm)	Metric	Grain size range (mm)	MESH	Grain size range (mm)
12/20	0.85 – 1.40		0.01 – 0.06	80	0.180 – 0.400
20/40	0.50 – 1.00		0.06 – 0.10	120	0.125 – 0.250
30/60	0.20 – 0.60		0.10 – 0.25	150	0.106 – 0.212
				180	0.090 – 0.180
				200	0.075 – 0.150
				220	0.063 – 0.125
				240	0.053 – 0.106
				350	0.045 – 0.090

Other grain sizes can be produced on request.



Black silicon carbide

Areas of application

- Reusable abrasive, fine abrasive, wet abrasive and dry abrasive
- Cutting wheels
- Bonded grinding wheels
- Aggregate for concrete and epoxy resin floors
- Lapping and loose ultra-fine grinding
- Wafer industry
- Industrial ceramics

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- FEPA F Standard
- FEPA P Standard

Black silicon carbide is, after diamond and boron carbide, the third hardest mineral in the world. Chemically, silicon carbide is extremely resistant; it resists the strongest alkalis and acids. In addition to its use as a blasting abrasive, silicon carbide is also used as an additive in the production of slip-resistant, wear-resistant and conductive floor coatings.

Physical properties

Hardness	approx. 9 – 10 mohs
Grain shape	angular/fragmented
Melting point	approx. 2,300 °C
Specific gravity	approx. 3.2 g/cm ³
Bulk density*	approx. 0.75 – 1.82 g/cm ³

*depending on granular size

Typical chemical analysis

	Black silicon carbide	Green silicon carbide
SIC	98.00 %	99.00 %
Fe ₂ O ₃	0.20 %	0.20 %
C-free	0.50 %	0.50 %
Magnetic fraction	0.12 %	0.12 %



Available grain sizes

Silicon carbide macro			
FEPA	Grain size range (µm)	FEPA	Grain size range (µm)
F008	2000 – 2800	F046	300 – 425
F010	1700 – 2360	F054	250 – 355
F012	1400 – 2000	F060	212 – 300
F014	1180 – 1700	F070	180 – 250
F016	1000 – 1400	F080	150 – 212
F020	850 – 1180	F090	125 – 180
F022	710 – 1000	F100	106 – 150
F024	600 – 850	F120	90 – 125
F030	500 – 710	F150	63 – 106
F036	425 – 600	F180	53 – 90
F040	355 – 500	F220	45 – 75

Metric (SiC black)	Grain size range (mm)
	0.25 – 0.50
	1.00 – 2.00
	1.00 – 3.00

Other grain sizes can be produced on request.

Silicon carbide micro			
FEPA	Grain size range		
	ds3 factor max. µm	ds50 factor µm	ds94 factor min. µm
F240	70	44.5 +/- 2.0	28
F280	59	36.5 +/- 1.5	22
F320	49	29.2 +/- 1.5	16.5
F360	40	22.8 +/- 1.5	12
F400	32	17.3 +/- 1.0	8
F500	25	12.8 +/- 1.0	5
F600	19	9.3 +/- 1.0	3
F800	14	6.5 +/- 1.0	2
F1000	10	4.5 +/- 0.8	1
F1200	7	3.0 +/- 0.5	1.0*

*at 80 %



Glass beads

Areas of application

- Reusable abrasive, fine abrasive, dry abrasive
- Filler beads
- Reflective glass beads

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Customer approvals

- CSS8 (Rolls-Royce)

Deliverable standards and specifications

- AMS 2431/6
- MIL-G-9954
- NF L 06-831

Available grain sizes

Metric	Grain size range (µm)
	0 – 50
	40 – 70
	70 – 110
	90 – 150
	100 – 200
	150 – 250

Glass beads are a mineral, iron-free, reusable abrasive with a wide range of applications. Due to their spherical shape, they have a low abrasive effect and are therefore ideally suited for gentle cleaning. The special ability of the glass beads is to produce a silky matt surface finish.

Physical properties

Hardness	6 mohs
Grain shape	spherical
Melting point	approx. 730 °C
Specific gravity	approx. 2.5 g/cm ³
Bulk density*	approx. 1.5 – 1.6 g/cm ³

*depending on granular size

Typical chemical analysis

SiO ₂	70.00 – 75.00 %
Na ₂ O	12.00 – 15.00 %
CaO	7.00 – 12.00 %
MgO	max. 5.00 %
Al ₂ O ₃	max. 2.50 %
K ₂ O	max. 1.50 %
Fe ₂ O ₃	max. 0.50 %

Other grain sizes can be produced on request.



Glass granulate

Areas of application

- Reusable abrasive, fine abrasive, wet abrasive, dry abrasive
- Filler

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Glass granulate is popular for fine blasting work on wood and facades. Due to its angular grain shape, glass granulate behaves more abrasively than round glass beads in its blasting behaviour, but is significantly gentler than the various types of corundum.

Physical properties

Hardness	6 mohs
Grain shape	angular
Melting point	approx. 730 °C
Specific gravity	approx. 2 – 2.6 g/cm ³
Bulk density*	approx. 1.2 – 1.8 g/cm ³

*depending on granular size

Typical chemical analysis

SiO ₂	65.00 – 75.00 %
Na ₂ O	12.00 – 18.00 %
CaO	7.00 – 12.00 %
MgO	max. 5.00 %
Al ₂ O ₃	max. 2.50 %
K ₂ O	max. 1.50 %
Fe ₂ O ₃	max. 0.50 %

Available grain sizes

Designation	Grain size range (µm)	Designation	Grain size range (µm)
GGR 220-S	0 – 100	GGR 30/40	300 – 500
GGR 160	40 – 80	GGR 03/06	300 – 600
GGR 140	80 – 150	GGR 24/36	300 – 800
GGR 120	100 – 200	GGR 16/36	400 – 1400
GGR 100	200 – 300		

Other grain sizes can be produced on request.



Steel shot round HC

Areas of application

- Reusable abrasive
- Sand removal
- Descaling
- Deburring
- Blast cleaning
- Micro blasting
- Shot peening

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-3
- DIN 8201-2
- SAE J444
- SAE J827

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
S 070	0.2 – 0.4	S 390	1.0 – 1.4
S 110	0.3 – 0.6	S 460	1.2 – 1.7
S 170	0.4 – 0.7	S 550	1.4 – 2.0
S 230	0.6 – 0.9	S 660	1.7 – 2.2
S 280	0.7 – 1.0	S 780	2.0 – 2.4
S 330	0.9 – 1.2	S 930	2.0 – 2.8

Other grain sizes can be produced on request.

High carbon steel shot is a very efficient abrasive for the surface treatment of metallic products. In contrast to low-carbon cast steel, this product has a higher blasting intensity which enables faster working.

Physical properties

Hardness	40 – 52 HRC (390 – 535 HV)
Grain shape	spherical
Melting point	approx. 1,535 °C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 4.0 – 4.6 g/cm ³
Microstructure	martensitic

*depending on granular size

Typical chemical analysis

C	0.80 – 1.20 %
Mn	0.35 – 1.20 %
Si	0.40 – 1.50 %
S	max. 0.05 %
P	max. 0.05 %
Fe	Remainder



Steel shot round LC

Areas of application

- Reusable abrasive
- Sand removal
- Descaling
- Deburring
- Blast cleaning
- Micro blasting
- Shot peening

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-4
- DIN 8201-2
- SAE J444

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
S 070	0.2 – 0.4	S 390	1.0 – 1.4
S 110	0.3 – 0.6	S 460	1.2 – 1.7
S 170	0.4 – 0.7	S 550	1.4 – 2.0
S 230	0.6 – 0.9	S 660	1.7 – 2.2
S 280	0.7 – 1.0	S 780	2.0 – 2.4
S 330	0.9 – 1.2	S 930	2.0 – 2.8

Other grain sizes can be produced on request.

Low carbon steel casting is a very economical abrasive for the surface treatment of metallic products. Compared with the high carbon product, the low carbon content in this steel shot results in a longer service life.

Physical properties

Hardness of the new grain	35 – 45 HRC (340 – 460 HV)
Hardness in operating mixture	40 – 50 HRC (390 – 530 HV)
Grain shape	spherical
Melting point	approx. 1,535 °C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 4.0 – 4.6 g/cm ³
Microstructure	bainitic

*depending on granular size

Typical chemical analysis

C	0.10 – 0.20 %
Mn	1.00 – 1.50 %
Si	0.10 – 0.25 %
S	max. 0.035 %
P	max. 0.035 %
Fe	Remainder



Steel grit

Areas of application

- Reusable abrasive
- Rust removal
- Paint stripping
- Descaling
- Surface preparation prior to coating
- Blast cleaning
- Rough blasting

Blasting systems

- Pressure blast systems (GH)
- Wheel blasting systems (GL, GP)
(wear protection recommended)

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-4
- DIN 8201-3
- SAE J444
- SAE J993

Available grain sizes

Designation	Grain size range (mm)
G 12	1.7 – 2.4
G 14	1.4 – 2.0
G 16	1.0 – 1.7
G 18	0.7 – 1.4
G 25	0.4 – 1.2

Cast steel grit is available in three hardness classes: GH, GL and GP. It can be used both in compressed air blast systems and in wheel blast systems – preferably with wear protection. Depending on the degree of hardness, this abrasive will sooner or later round off in the operating mixture. Angular cast steel is ideal for cleaning, roughening and descaling, as well as for preparatory blasting before coating metallic components.

Physical properties

Hardness GP	40 – 53 HRC (390 – 550 HV)
Hardness GL	54 – 60 HRC (570 – 720 HV)
Hardness GH	> 61 HRC (> 740 HV)
Grain shape	angular
Melting point	approx. 1,535 °C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 4.0 – 4.6 g/cm ³
Microstructure	martensitic

*depending on granular size

Typical chemical analysis

C	0.80 – 1.20 %
Mn	0.40 – 1.50 %
Si	0.35 – 1.20 %
S	max. 0.05 %
P	max. 0.05 %
Fe	Remainder

Other grain sizes can be produced on request.



Chilled iron grit

Areas of application

- Reusable abrasive
- Rust removal
- Paint stripping
- Rough blasting
- Surface preparation prior to coating

Blasting systems

- Pressure blast systems
- Wheel blasting systems
(wear protection recommended)

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-2
- DIN 8201-3
- BS 2451

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
G 02	0.1 – 0.2	G 34	0.8 – 1.2
G 05	0.1 – 0.3	G 39	1.0 – 1.4
G 07	0.2 – 0.4	G 47	1.2 – 1.7
G 12	0.3 – 0.6	G 55	1.4 – 2.0
G 17	0.4 – 0.8	G 66	1.7 – 2.4
G 24	0.6 – 1.0	G 80	2.0 – 2.8

Other grain sizes can be produced on request.

Angular chilled iron grit is particularly suitable for treating metallic surfaces in pressure blasting systems. Due to its hardness and high carbon content, chilled cast iron repeatedly breaks into sharp-edged particles. This leads to high abrasive performance with short blasting times.

Physical properties

Hardness of the new grain	640 – 900 HV (57 – 67 HRC)
Grain shape	angular
Melting point	approx. 1,535 °C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 3.0 – 4.6 g/cm ³
Microstructure	martensitic

*depending on granular size

Typical chemical analysis

C	2.70 – 3.20 %
Si	0.80 – 2.00 %
Mn	0.30 – 1.00 %
P	0.10 – 0.60 %
S	0.07 – 0.25 %
Fe	Remainder



Cut wire

Areas of application

- Reusable abrasive
- Sand removal
- Descaling
- Fetting
- Blast cleaning

Blasting systems

- Pressure blast machines
- Wheel blasting machines

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-5
- DIN 8201-4

Cylindrical cut wire possesses the precise geometry and compacted structure which together offer maximum impact power. The cylinder edge is abrasive, and this results in good cleaning even of surfaces with stubborn contamination.

Physical properties

Hardness (standard)	+/- 450 HV (44 HRC)
Grain shape	cylindrical
Melting point	approx. 1,535°C
Specific gravity	approx. 7.4 g/cm ³
Bulk density*	approx. 3.9 – 4.9 g/cm ³

*depending on granular size

Typical chemical analysis

C	0.45 – 0.60 %
Mn	0.40 – 0.70 %
Si	0.05 – 0.22 %
P	max. 0.05 %
S	max. 0.05 %
Fe	Remainder

Available grain sizes

Metric	Diameter (mm)	Metric	Diameter (mm)
	0.4		1.6
	0.6		1.8
	0.8		2.0
	0.9		2.2
	1.0		2.4
	1.2		2.6
	1.5		

Other grain sizes can be produced on request.



Cut wire conditioned

Areas of application

- Reusable abrasive
- Shot peening (shot blasting)
- Surface deformation

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- EN ISO 11124-5
- DIN 8201-4
- SAE J441
- AMS 2431/3
- AMS 2431/8
- VDFI 8001

Conditioned cut wire is produced especially for shot peening. Peening with conditioned cut wire increases the load capacity and service life of dynamically stressed components such as springs, gears and shafts. Its solidified surface significantly increases the bending and torsional strength.

Physical properties

Hardness (standard)	+/- 640 HV (56 HRC)
Grain shape	rounded
Melting point	approx. 1,535°C
Specific gravity	approx. 7.4 g/cm ³
Bulk density*	approx. 4.4 – 4.8 g/cm ³

*depending on granular size

Typical chemical analysis

C	0.73 – 0.78 %
Mn	0.50 – 0.80 %
Si	0.10 – 0.30 %
P	max. 0.035 %
S	max. 0.035 %
Fe	Remainder

Available grain sizes

Metric	Diameter (mm)	Metric	Diameter (mm)
	0.3		0.9
	0.4		1.0
	0.5		1.2
	0.6		1.4
	0.7		1.6
	0.8		

Other grain sizes can be produced on request.



Stainless steel shot CrNi

Areas of application

- Reusable abrasive
- Sand removal
- Descaling
- Micro blasting
- Structural blasting
- Blast cleaning
- Surface finishing

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Customers use stainless steel shot CrNi to treat parts made of aluminium, copper and stainless steel. Long service life and low system-wear make this stainless steel abrasive very economical.

Physical properties

Hardness of the new grain	+/- 20 HRC (235 HV)
Hardness in operating mixture	+/- 45 HRC (460 HV)
Grain shape	spherical
Melting point	approx. 1,450 – 1,500°C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 3.8 – 4.6 g/cm ³
Microstructure	austenitic

*depending on granular size

Typical chemical analysis

Cr	16.00 – 20.00 %
Ni	7.00 – 9.00 %
Si	1.80 – 2.20 %
Mn	0.70 – 1.20 %
C	0.05 – 0.20 %

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
ALPHA 010	0.0 – 0.2	ALPHA 060	0.7 – 1.2
ALPHA 020	0.1 – 0.3	ALPHA 100	1.0 – 1.4
ALPHA 030	0.2 – 0.5	ALPHA 150	1.2 – 1.7
ALPHA 040	0.4 – 0.8	ALPHA 200	1.4 – 2.0
ALPHA 050	0.6 – 1.0	ALPHA 300	1.7 – 3.2

Other grain sizes can be produced on request.



Stainless steel shot Cr

Areas of application

- Reusable abrasive
- Sand removal
- Descaling
- Deburring
- Micro blasting
- Structural blasting
- Sweep blasting of zinc-plated parts
- Surface finishing

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Stainless steel shot Cr is an attractively-priced alternative to stainless steel shot CrNi, and is used for machining aluminium castings and other non-ferrous materials. In the operating mixture, this chromium abrasive has an extremely high hardness which enables fast process times.

Physical properties

Hardness of the new grain	+/- 40 HRC (390 HV)
Hardness in operating mixture	+/- 50 HRC (530 HV)
Grain shape	round
Melting point	approx. 1,450 – 1,500°C
Specific gravity	approx. 7 g/cm ³
Bulk density*	approx. 3.8 – 4.6 g/cm ³
Microstructure	martensitic

*depending on granular size

Typical chemical analysis

Cr	12.00 – 20.00 %
Si	max. 4.00 %
Mn	max. 2.00 %
Ni	max. 0.95 %
C	max. 0.30 %

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
BETA 010	0.0 – 0.2	BETA 060	0.7 – 1.2
BETA 020	0.1 – 0.3	BETA 100	1.0 – 1.4
BETA 030	0.2 – 0.5	BETA 150	1.2 – 1.7
BETA 040	0.4 – 0.8	BETA 200	1.4 – 2.0
BETA 050	0.6 – 1.0	BETA 300	1.7 – 3.2

Other grain sizes can be produced on request.



Stainless steel grit Cr-Grit

Areas of application

- Reusable abrasive
- Blast cleaning
- Sweep blasting of zinc-plated parts
- Micro blasting
- Structural blasting
- Paint stripping
- Descaling
- Surface preparation prior to coating
- Creating non-slip surfaces in the stone industry

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
DELTA 010	1.7 – 2.5	DELTA 025	0.4 – 1.0
DELTA 012	1.4 – 2.0	DELTA 040	0.3 – 0.8
DELTA 014	1.2 – 1.7	DELTA 050	0.2 – 0.6
DELTA 016	1.0 – 1.4	DELTA 080	0.1 – 0.3
DELTA 018	0.7 – 1.2	DELTA 120	0.0 – 0.2

Other grain sizes can be produced on request.

Stainless steel casting angular Cr-Grit can be a worthwhile alternative to an iron-free, mineral abrasive due to its extraordinarily long service life. The angular grain shape makes it possible to prepare stainless materials for subsequent surface coating.

Physical properties

Hardness	+/- 59 HRC (710 HV)
Grain shape	angular
Melting point	approx. 1,450 – 1,500°C
Specific gravity	approx. 7.0 g/cm ³
Bulk density*	approx. 4.0 – 4.2 g/cm ³

*depending on granular size

Typical chemical analysis

Cr	27.00 – 30.00 %
C	1.95 – 2.20 %
Si	1.80 – 2.20 %
Mn	0.70 – 1.20 %
Ni	0.00 – 0.50 %



Aluminium shot

Areas of application

- Reusable abrasive
- Cleaning
- Deburring
- Soft blasting

Blasting systems

- Pressure blast systems
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Aluminium shot is particularly suited to the gentle blasting of aluminium, magnesium and zinc die-castings.

Physical properties

Hardness	90 – 120 HV
Grain shape	rounded
Melting point	approx. 660 °C
Specific gravity	approx. 2.5 – 2.8 g/cm ³
Bulk density*	approx. 0.9 – 1.5 g/cm ³

*depending on granular size

Typical chemical analysis

Al	97 – 98 %
Mg	0.80 %
Si	max. 1.00 %
Fe	max. 0.40 %
Mn	max. 0.30 %
C	max. 0.10 %

Available grain sizes

Metric	Grain size range (mm)
	0.4 – 0.8
	0.8 – 1.2
	1.2 – 1.8
	1.8 – 2.5

Other grain sizes can be produced on request.



Ceramic beads

Areas of application

- Reusable abrasive, fine abrasive, wet abrasive, dry abrasive

Blasting systems

- Pressure blast systems
- Injector blast cabinets
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Deliverable standards and specifications

- AMS 2431/7
- NF L 06-831

Ceramic beads from Kuhmichel create perfect surfaces with a silky matt sheen. Ceramic abrasives are in the upper bracket in terms of price, but they offer an extraordinarily long service life.

Physical properties

Hardness	approx. 7 – 7.5 mohs
Grain shape	spherical
Melting point	approx. 2,100 °C
Specific gravity	approx. 3.8 g/cm ³
Bulk density*	approx. 2.1 – 2.4 g/cm ³

*depending on granular size

Typical chemical analysis

ZrO ₂	61.98 %
SiO ₂	27.77 %
Al ₂ O ₃	4.57 %
CaO	3.47 %
Fe ₂ O ₃	0.14 %
TiO ₂	0.34 %

Available grain sizes

Metric	Grain size range (µm)	Metric	Grain size range (µm)
	0 – 63		250 – 425
	0 – 125		425 – 600
	70 – 125		600 – 850
	125 – 250		850 – 1180

Other grain sizes can be produced on request.



Areas of application

- Fine abrasive, wet abrasive, dry abrasive
- Cleaning building exteriors and monument renovation
- Reconditioning vintage cars

Blasting systems

- Pressure blast machines
- Injector blast machines

Packaging

- 25 kg sacks on pallets each up to 1,225 kg

Soda

Soda is suitable for gentle cleaning without any removal of material on the base body. Soda abrasive proves particularly useful for paint stripping and degreasing, in the restoration of buildings and monuments and in eliminating fire damage. Soda can be used as a drying agent and, mixed with a water mist, also as a wet abrasive.

Physical properties

Hardness	2.5 – 3 mohs
Grain shape	irregular
Melting point	Decomposition point: > 60 °C / total 270 °C
Specific gravity	approx. 2.2g/cm ³
Bulk density*	0.65 – 1.2 g/cm ³

*depending on granular size

Typical chemical analysis

No Fe fractions
99.6 % NaHCO_3

Available grain sizes

Designation	Grain size range (mm)
00/50	0 – 0.50
27/50	0.27 – 0.50

Other grain sizes can be produced on request.



Nutshell

Areas of application

- Reusable abrasive, dry abrasive
- Additive for polishing and grinding pastes
- (Additive for) oil binding agents
- Drying agents

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Nutshell is an organic, reusable abrasive made of broken, cleaned and sieved walnut shells. Due to its low hardness, nutshell is mainly used for surface applications, causing no loss of substance in the base material. Nutshell is an extremely environmentally-friendly product, and is manufactured from 100 % renewable, raw materials.

Physical properties

Hardness	approx. 2.5 – 3.5 mohs
Grain shape	angular
Melting point	approx. 170 °C
Specific gravity	approx. 1.0 – 1.2 g/cm ³
Bulk density*	approx. 0.45 – 0.8 g/cm ³

*depending on granular size

Typical chemical analysis

No Fe fractions

Available grain sizes

Designation	Grain size range (mm)	Designation	Grain size range (mm)
2/12	0.10 – 0.20	12/3	1.00 – 1.70
6/12	0.20 – 0.45	12/3E	1.30 – 1.70
4/6	0.45 – 0.80	CAG 16/10	1.70 – 2.40
3/6	0.45 – 1.00	8/10	2.40 – 4.00
16/5	0.80 – 1.30	1/27	4.00 – 6.00
15/10	1.00 – 1.50		

Other grain sizes can be produced on request.



Corn cob

Areas of application

- Reusable abrasive, dry abrasive
- Dry material in vibratory finishing and barrel finishing machines
- Additive for polishing and grinding pastes
- Oil binding agent

Blasting systems

- Pressure blast systems
- Injector blast cabinets

Packaging

- 20 kg sacks on pallet up to 540 kg and 780 kg

Corn cob is an extremely soft, organic abrasive consisting of cleaned, crushed and sieved corn cob. Just like nutshell, corn cob is obtained from 100 % renewable, raw materials.

Physical properties

Hardness	approx. 4.5 mohs
Grain shape	irregular
Melting point	approx. 170 °C
Specific gravity	approx. 0.9 g/cm ³
Bulk density*	approx. 0.45 – 0.8 g/cm ³

*depending on granular size

Typical chemical analysis

No Fe fractions

Available grain sizes

Designation	Grain size range (µm)	Designation	Grain size range (µm)
GM 100	0 – 250	GM 16	1000 – 1500
GM 40	180 – 600	GM 12	1500 – 2000
GM 30	250 – 710	GM 8	2000 – 3150
GM 20	560 – 1000	GM 6	3800 – 4500

Other grain sizes can be produced on request.



Plastic abrasives

Areas of application

- Reusable abrasive, fine abrasive, wet abrasive, dry abrasive
- Deburring
- Paint stripping
- Surface cleaning without loss of substance

Blasting systems

- Pressure blast systems
- Injector blast cabinets
- Wheel blasting systems

Packaging

- 25 kg sacks on pallet up to 1 t
- 1 t loose in a big bag

Customer approvals

- CSS227 (Rolls-Royce)

Deliverable standards and specifications

- MIL-P-85891A

Available grain sizes

MESH	Grain size range (mm)	MESH	Grain size range (mm)
008/014	1.40 – 2.40	020/030	0.60 – 0.80
008/016	1.20 – 2.40	020/040	0.40 – 0.80
008/020	0.80 – 2.40	030/040	0.40 – 0.60
010/020	0.80 – 2.00	040/060	0.25 – 0.40
012/016	1.20 – 1.70	060/080	0.18 – 0.25
012/020	0.80 – 1.70	080/120	0.12 – 0.18
016/020	0.80 – 1.20		

Other grain sizes can be produced on request.

Plastic abrasives were originally developed for the aerospace industry. They are used for the cleaning or paint-stripping of surfaces, without changing the treated substrate.

Physical properties

Hardness TYPE II	Barcol 54 – 65 (3.5 mohs)
Hardness TYPE III	Barcol 64 – 72 (4.0 mohs)
Hardness TYPE V	Barcol 46 – 54 (3.2 – 3.5 mohs)
Grain shape	angular
Melting point	< 500°C
Specific gravity	approx. 1.5 g/cm ³
Bulk density*	approx. 0.8 – 0.9 g/cm ³

*depending on granular size

Typical chemical analysis

Plastics from:	Urea, melamine and acrylic
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Polyamide

Areas of application

- Reusable abrasive
- Thermoset deburring
- Rubber deburring
- Silicone deburring

Blasting systems

- Pressure blast systems
- Injector blast cabinets
- Wheel blasting systems

Packaging

- 25 kg PE sacks on pallet up to 1 t

Polyamide is mainly used as a blast media for deburring parts made of thermoset. As polyamide is comparatively soft, plastic surfaces can be processed without incurring damage.

Physical properties

Hardness	2 – 3 mohs
Grain shape	cylindrical/cubic
Melting point	approx. 215 – 225 °C
Specific gravity	approx. 1.08 – 1.60 g/cm ³
Bulk density*	approx. 0.7 g/cm ³

*depending on granular size

Typical chemical analysis

Plastics from:	Polyamide 6, additives < 1%
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Available grain sizes

cylindrical			cubic		
Size in mm (diameter x length)	Colour		Size in mm (diameter x length)	Colour	
0.50 x 0.50	red, natural		0.50 x 0.50	red, natural	
0.75 x 0.75	red, natural		0.60 x 0.60	red, natural	
1.00 x 1.00	red, natural		0.75 x 0.75	red, natural	
1.00 x 1.50	red, natural		1.00 x 1.00	red, natural	
1.50 x 1.00	red, natural		1.20 x 1.20	red, natural	
1.50 x 1.50	red, natural		1.50 x 1.50	red, natural	
2.00 x 2.00	red, natural				

Other grain sizes can be produced on request.

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