



GENERAL RECOMMENDATIONS

Individual descriptions are stated in general terms, since the correct choice of polishing buff depends on a number of factors which may be unknown to us: condition of the raw material prior to grinding, shape of article, type of metal, grade of polishing composition, contact pressure, finish, all play a part in final selection.

From detailed information about these points together with the diameter, width and bore of the buffs used on your machines, we will be able to recommend the most economical system for your purpose.

All buffs are either biascut or full leaf. The biascut buff is more specifically designed for use on automatic polishing machines, and offers the following advantages:

1. Greater durability.
2. Cooler running.
3. Quicker polishing action.
4. Greater flexibility
 - All resulting in better finishes at reduced cost.

TABLE OF SURFACE SPEEDS r/min TO SELECT THE MOST SUITABLE DIAMETER OF BUFF

Diameter of buff in mm	150	175	200	250	300	350	400	450	500
Speed r/min									
1400	660	768	882	1104	1320	1536	1752	1980	2196
1600	756	882	1008	1254	1506	1758	2004	2238	2514
1800	852	990	1134	1410	1692	1980	2256	2544	2826
2000	942	1104	1260	1566	1884	2184	2508	2826	3144
2200	1032	1200	1380	1728	2070	2418	2760	3108	3456
2400	1140	1320	1506	1884	2256	2640	3000	3390	3780
2600	1224	1428	1632	2040	2448	2856	3192	3684	4080
2800	1320	1536	1758	2196	2634	3078	3504	3960	4410
3000	1428	1650	1884	2352	2820	3300	3780	4230	4740

ECONOMICAL CUTTING SPEEDS

Non-ferrous metal approx. 2160 m/min (±15%)

Steel, cast iron approx. 2100 m/min (±15%)

Plastic, lacquers approx. 900 m/min (±15%)

Water fittings, valves, etc (400 mm dia. Approx. 800 r/min approx.. 1200 m/min (±15%))