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|---|---|---|--|---|---------------------|-------------------|
| <p>Combine el color de la marca con el color de la pasta.</p> | <p>Agencez les couleurs du point aux couleurs du bouchon de la pâte de polissage.</p> |  |  |  | | |
| MATERIAL | HARD METALS | SOFT METALS | | JEWELRY GOLD & SILVER | | |
| Match the color of the Compound | STEP 1 | STEP 2 & 3 | STEP 1 | STEP 2 & 3 | STEP 1 | STEP 2 & 3 |
| | CLEAN POLISH | BUFF SHINE | CLEAN POLISH | BUFF SHINE | CLEAN POLISH | BUFF SHINE |
| SPIRAL SEWN | ● | ● | ● | | | |
| CUSHION SEWN | | ○ | | ○ | ○ | |
| FLANNEL SEWN | | ● | | ● | | ● |
| <p>Combine el color de la marca con el color de la pasta.</p> | <p>Agencez les couleurs du point aux couleurs du bouchon de la pâte de polissage.</p> |  |  |  | | |
| MATERIAL | BRASS & COPPER | | NICKEL & CHROME | | PLASTICS | |
| Match the color of the Compound | STEP 1 | STEP 2 & 3 | STEP 1 | STEP 2 & 3 | STEP 1 | STEP 2 & 3 |
| | CLEAN POLISH | BUFF SHINE | CLEAN POLISH | BUFF SHINE | CLEAN POLISH | BUFF SHINE |
| SPIRAL SEWN | ● | | ● | | | |
| CUSHION SEWN | | ○ | | ○ | ● | ○ |
| FLANNEL SEWN | | ● | | ● | | ● |

COMPOUNDS

- Black - E5 - Emery: Most Aggressive cutting, removes scratches, rust, & burrs from ferrous metals
- Brown - TC6 - Tripoli: Aggressive, removes surface marks on all non ferrous metals and plastics
- Gray - SCR - Stainless: General Purpose, Good cut and color, restores luster to ferrous metals
- Blue - PBC - Plastic: Excellent for plastics, acrylics & removing scratches from Corian
- White - WR1 - White Rouge: Restores natural luster to non-ferrous i.e. Aluminum, Copper & Brass
- Red - JR1 - Jewelers Rouge: Finest abrasive, premium product for coloring precious metals
- Green - GRN - Green Rouge: Brilliantly finishes all metal, particularly ferrous metal, Great coloring

Buffing Wheels

SPIRAL SEWN - The workhorse for most aggressive cutting

CUSHION SEWN - Ideal for light cutting and coloring

FLANNEL SEWN - Ideal for the final finish and a brilliant luster



Buffing Instructions

Applying the compound to your buffing wheel

On a new wheel: Be sure the wheel is revolving toward you and has attained full speed. Then pass the compound lightly across wheel face in front of, and a little below spindle, until face is slightly coated. Now hold a clean piece of old metal lightly against wheel face for a few seconds to spread coating. After face has been adequately charged with compound, you are ready to buff. It will be necessary to apply more compound from time to time as you buff, and the best way to do this is with a wiping motion, being careful not to overload the wheel. Never use a wheel for coloring which has previously been used for coarse buffing or cutting down. Particles of grit remaining in the face may scratch your final finish. You will save time and avoid costly mistakes by using a separate wheel for each type of compound.

It is easier to buff the correct way

Never put the compound on the article to be buffed. Grasp your work firmly and apply it lightly against face of wheel. Make sure to keep it below the center of the wheel, otherwise the buff might catch in your work and pull it out of your hands. Keep your work constantly in motion, always removing it from the wheel with a slanting downward stroke. This will blend buffing marks and help avoid spotty or streaked results. Wipe additional compound across wheel face as needed, but do not overload. Overloaded wheels will produce many thick, black streak marks. If this occurs, clean the buff with a buff rake or file and reapply the compound as needed. Do not use too much pressure against the wheel: let the compound and the wheel do the work. Use appropriate buffing wheels matched with compounds when changing from cutting to coloring to prevent coarser grits from becoming embedded in coloring wheels, potentially scratching your final finish. When finished, wipe the buffed surface with a soft cloth dipped in powdered whiting (talcum powder) to remove all traces of compound. Hot soapy water may also be used. A little practice will enable you to obtain the results you want.

Hints and Recommendations

- Use only one compound per buffing wheel. Using a pen or marker, label the side of each buff with the compound name or model # being used for future reference.
- Friction will melt the compound onto the wheel. Apply additional compound as needed.
- After cleaning, apply a sealer or car wax to your work to prevent the return of tarnish or oxidation.
- To clean excessive compound build-up off the buffing wheel face, hold a Wheel Rake firmly with two hands lightly up against the spinning buffing wheel. After the excess compound is removed, you are ready to continue with your project.
- Use great care when buffing plated metal. Thin plating is easily buffed off. Inspect plated work carefully. If you are unsure whether or not the piece to be worked is plated, try a magnet. If the magnet sticks, most likely the item is plated.