

General Instructions for Metal Finishing with a Tumble-Polisher



When finishing metal parts, such as silver castings, there are several different compounds which may be used: the most common being stainless-steel burnishing shapes (94-089) of different sizes as a pre-polish, followed by impregnated media such as crushed pecan shell (Ref 94-084) or maize (Ref 94-088).

When used, the stainless steel shapes should be small enough to pass through any holes in the object.



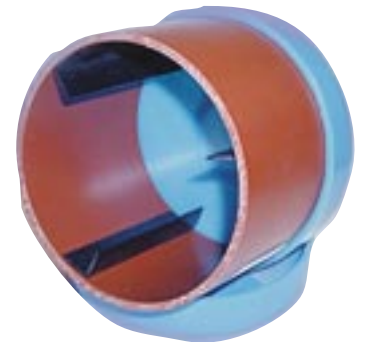
Step 1) A mixture of about two-parts stainless steel shapes (in volume) to a maximum of one-part items to be polished, should be placed in the (vaned) barrel. Do not fill the barrel to more than about 2/3rds full.

Step 2) Add about one heaped tablespoonful of tumbling 'soap' (Ref 94-087) for a 1400gms barrel (or one level tablespoonful for a 900gms barrel) to act as a lubricant and polishing agent and to assist as a rust inhibitor for the steel.

Step 3) Add water to the barrel content to just cover the mix. After replacing the lid, the barrel should be run for as long as is necessary; inspecting it every half hour or so until the required finish is obtained.

Remember that the steel shapes will only polish a smooth surface - they will not remove material or get 'pitting' out of a bad casting. If the work comes out dirty or tarnished, it is usually a sign that the soap needs replacing: wash out the barrel and recharge as above.

Never leave the steel shapes in just water alone as they will cease to polish effectively.

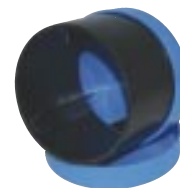


Plastic Barrels

To open the long-life plastic barrel - (700gms 10-038 or 1400gms 10-039) - push either end cap off with your thumbs. When new they are sometimes tight, but if the barrel lid is held under running hot water for a few moments it expands -faster than the body - and can be removed more easily.

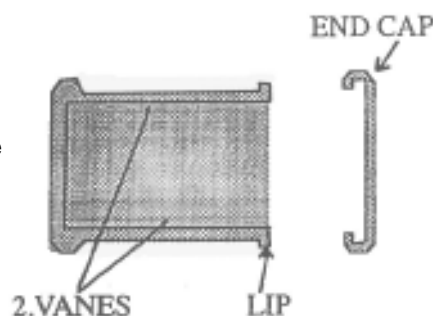
When replacing the lid ensure that all the surplus air has been expelled from the barrel, by lifting one side of the lid with your fingers as you press the centre of the cap with your thumbs - you will hear the air hiss out.

Make absolutely sure that the caps are on properly and as far as they will go - THIS IS MOST IMPORTANT.



Rubber Barrels

The Metalsmith barrel is an all rubber construction and is only available in one size (1400gms capacity). The barrel has an end cap that peels off from a lip on the end of the barrel. Inside the barrel there are two vanes which improve the tumbling action and keep the metal parts moving. When replacing the end cap make sure all surfaces are clean and that the end cap is located properly over the lip. Push the end cap into place if necessary.



If your machine is designed to carry the large capacity (2.25Kgs) rubber barrels, the following notes apply:

When fitting the rubber lid, ensure that the grooves are clean and that the tongue engages the groove all the way round. When opening, the pressure ring (10-024) may be rolled down the barrel, instead of being removed completely. Squeezing one side of the barrel assists with opening; - DO NOT use a sharp instrument.



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