

## **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 steel burnishing shapes (Ref 94-086 or 94-089-stainless) of different sizes as a pre-polish, followed by impregnated media such as crushed walnut shell (Ref 94-084) or maize (Ref 94-088).

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

**Step 1)** A mixture of about two-parts shapes (in volume) to one-part items to be polished, should be placed in the (vaned) barrel and then filled about 2/3rds full.

**Step 2)** Add about one to two tablespoons of tumbling 'soap', Ref 94-087, (for a 3lbs 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 about two hours and then continue with inspection every 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 quickly go rusty and cease to polish. If there is any sign of rust then add more 'soap' (Ref 94-087)

Plastic items may be finished using hard wood media (94-085) and the same can be used for non-ferrous metal with the addition of 'Turbo-Brite' polish (Ref 94-094).

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