

# POLISHING/SATINISING

## Stationary machines



### Important user information

#### Polishing/satinising using stationary machines



To be noted when selecting a tool and using stationary machines:

#### 1. General user information

The correct cutting speed when using polishing buffs on polishing and other stationary machines must be determined from case by case.

The recommended maximum operating speed of 3,000 rpm should, however, not be exceeded.

#### 2. Detailed information on optimum speeds

We recommend the following starting values:

Use	Cutting speed
Grinding	approx. 30 m/sec.
Satinising	approx. 20 m/sec.
Cutting	approx. 30-35 m/sec.
Polishing	approx. 30 m/sec.

Summary of cutting speeds as a factor of speed and diameter:

rpm / Ø	150	200
2,600	20 m/sec.	27 m/sec.
2,800	22 m/sec.	29 m/sec.
3,000	23 m/sec.	31 m/sec.

#### Polishing compounds and the role they play in the finishing process

Polishing compounds are essential for all polishing jobs because they contain the abrasive particles needed to achieve a particular surface finish. It is also important to select the correct polishing compound for the desired surface finish.

Please check your product choice using the information in the info heading. It provides an overview of the compounds available and their suitability for particular finishing steps.

➔ More on finding the right compound for your application can be found in the technical information on the first page of "Polishing/Satinising".

**USE**

	Steel	Stainless steel	Aluminum	Brass	Copper
white (cutting)	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
white (polishing)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
brown (cutting)	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
brown (polishing)	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
blue (colouring)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

		4 white	RRP	5 brown	RRP	6 blue	RRP
g	pcs.	Order no.	€	Order no.	€	Order no.	€
110	15	2103005333	2.10	2103007012	2.50	2103000461	2.25
700	8	8103005333	8.75	8103007012	11.40	8103000462	8.90



#### Important note:

No polishing compound is needed for satinising because the abrasive particles are already embedded in the base material of the satiniser.