

BUFFS - MOPS - WHEELS FOR POLISHING AND BRIGHT FINISHING

MATERIALS AND APPLICATIONS

COTTON CLOTH WOOLLEN CLOTH	BRIGHT, MIRROR FINISH	ALL METALS ALUMINIUM AND ALLOYS
RODIFLEX (ABRASIVE SPONGE)	SATIN FINISH	STAINLESS STEEL ALUMINIUM
TAMPICO FIBRE PLAITED SISAL	BRIGHT FINISH, SATIN FINISH BRIGHT FINISH, SATIN FINISH	STAINLESS STEEL ALL METALS
SISAL + COTTON SISAL	PRE-POLISH AND POLISH PRE-POLISH AND POLISH	ALL METALS ALL METALS
STEEL WIRE	PRE-POLISH, SATIN FINISH	STAINLESS STEEL
ABRASIVE CLOTH	GRINDING (WET OR DRY)	FERROUS METALS AND NON FERROUS METALS

TYPES

- simple sections buffs, or simple sections buffs with central stitching: traditional buffs generally used on hand held spindles, manual machines. They are made up of various qualities of cotton (also with "stock material"), of woollen cloth, of Rodiflex. They can be prepared in "packs" with stitching at the centre.
- simple sections buffs with stitchings: traditional big diameter buffs for robot, with stitchings at request.
- **ventilated buffs:** for all polishing, bright/mirror finish and satin finish operations of flat and shaped pieces on manual and automatic machines. They can be made up of natural and treated cotton cloth, woollen cloth, Rodiflex, sisal+cotton and sisal cloth with or without impregnations.

Ventilated buffs made up of thin sisal cloth produce a semi-bright finish. If they are made up with sisal lined with cotton (with many stitches to strengthen), they have an higher retention of the compound.

By modifying the compound used, they are suitable for any type of material: stainless steel, aluminium, brass, alloys, plastic, etc.

The hardness of the ventilated buffs is controlled by:

■ internal bore

■ number of layers: for cotton buffs 12, 16, 20, 24

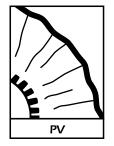
for sisal+cotton buffs 2, 4, 6

for sisal buffs 4, 6, 8

number of pleats

■ type of ventilation: PV light ventilation

NV normal ventilation
MV heavy ventilation







- **pleated buffs:** for all polishing and bright finishing operations, suitable for "immersion" polishing of shaped and small pieces. They can be made up of natural and treated cotton cloth, sisal and sisal+cotton with or without impregnation. In this case too, by modifying the type of compound, they are suitable for all metals: stainless steel, aluminium, brass, alloys, plastic, etc.

Each single layer is folded in a "Z" shape (pleated - see the picture below) and then arranged around the centre:

- in "standard" style: the buff is more rigid
- in "spiral" way: the buff is more flexible

A particular making consists of a mini-pleated structure (folded in very small "Z" shape) that makes the buffs suitable for "immersion" polishing of small work pieces (handles, tap knobs, etc.): the buff is named art. 1086 mini-pleated made up of cotton type MA.

There are two types of pleated buffs:

a) with metal rings (see below): external diameter 250-500 mm. standard and spiral

b) with big diameter: external diameter 700-960-1600 mm. spiral, with cardboard reduction and







- **stitched cotton buffs:** simple sections buffs with spiral stitchings, width from 8 to 20 mm. For manual and automatic polishing machines.
- **stitched sisal buffs:** for rough cutting and heavy removal rates. For manual and automatic polishing operations. They can be made up of sisal or sisal+cotton with or without impregnation.
- stitched "in segments": in spiral form with average width of 5-20 mm. The sisal cloth is cut in segments, i.e. in triangles, with the fibres arranged at 45° to reduce fraying to a minimum and to ensure uniform wear. They can be impregnated.
- **stitched** "all bias weave": they are suitable for all metals that call for heavy removals and roughing operations. They are normally submitted to impregnations.
- **corrugated buffs:** for roughing works and polishing operations (stainless steel, iron, chrome). Thanks to this particular corrugation of the cloth (sisal+cotton with or without impregnation, natural and treated cotton) one obtains a very aggressive effect without however overheating the work piece. Through appropriate impregnations, the hardness and life are improved.

Corrugated buffs are recommended when it is necessary to work with a single wheel, which does not open out.

- plaited sisal buffs: the main features of these buffs are the extreme flexibility and softmess, which make possible the polishing of complicated shapes. Various impregnations can be applied to increase life-time.



ASSEMBLY



- the 45° cloth weave cut on the circumference of the buffs minimises wear and dust production.
- the flexibility or stiffness of the mop is conditioned by:
 - number of layers
 - sizes of folds or corrugations
 - relation between the internal bore and the external bore
 - width of the stitching
- the centre can be either a removable metal ring (strongly suggested) or a fixed centre, made of cardboard or plastic.
- the buffs are manufactured with high attention and care to guarantee a correct balance.

SAFETY INFORMATION

Polishing buffs and mops spin on machines at high speeds.

It is necessary to protect the workers and operators making frequent check and adopting some precautions:

- all buffs should run on stable non vibrating spindles;
- the side mounting flanges of the buffs on the spindles must have the correct sizes (up to 40% of the buff should be covered, the metal ring must always be completed covered).
- safety hoods on the machinery should cover the buffs as they are running.
- the operator should wear the personal protection: head-protection, safety glasses and gloves. Polishing buffs can break up and fly apart, when incorrectly mounted and used.

Product Safety Data Sheet are available on request.

TABLE OF PERIPHERAL SPEED IN METERS/SECOND

outside diameter in mm.

	1															
RPM	100	125	150	175	200	250	300	350	400	450	500	600	750	960	1000	1600
300													11,7	15,0	15,7	25,1
400													15,6	20,0	20,9	33,5
450													17,6	22,5	23,5	37,6
500													19,5	25,0	26,1	41,8
550													21,5	27,5	28,7	46,0
600								11,0	12,6	14,1	15,7	18,8	23,4	30,0	31,4	50,2
700													27,4	35,0	36,6	-
800						10,5	12,6	14,6	16,7	18,8	20,9	25,1	31,3	40,0	41,9	-
900													35,2	45,0	47,1	-
1000													39,1	50,0	52,4	-
1100													43,1	-	-	-
1200													46,9	-	-	-
1300													50,8	-	-	-
1400			11,0	12,8	14,7	18,4	22,0	25,6	29,2	33,0	36,6	44,0				
1600			12,6	14,7	16,8	20,9	25,1	29,3	33,4	37,6	41,9	50,2				
1800		12	14,2	16,5	18,9	23,5	28,2	33,0	37,6	42,4	47,1	56,4				
2000	10	13	15,7	18,4	21,0	26,1	31,4	36,4	41,8	47,1	52,4					
2200	12	14	17,2	20,0	23,0	28,8	34,5	40,3	46,0	51,8	57,6					
2400	13	15	19,0	22,0	25,1	31,4	37,6	44,0	50,0	56,5						
2600	14	17	20,4	23,8												
2800	15	18	22,0	25,6	29,3	36,6	43,9	51,3	58,4							
3000	16	20	23,8				47,0									





The impregnation of the buffs increases their wear resistance, being them made of sisal fibre, tampico or cotton; it improves the compounds adhesion and enhances the cutting effects. The result is a longer life of the buff. The choise of the suitable impregnation depends on the application, on the customer requirement and our experience too.

All our impregnations are worked out in respect for the environment.

IMPREGNATIONS FOR SISAL BUFFS

impregnation code	colour	application	density
G/2 V/3 B/50 B/30 VIOLA B B/L RV/100 e RV/200	YELLOW GREEN ORANGE GREY VIOLET BLUE LIGHT BLUE RED	all metals	rigid and dry medium-rigid dry and not very flexible dry and flexible dry and medium-flexible dry and very flexible dry and extremely flexible used to harden stitched sisal mops; the number that follows the mark RV indicates the
			hardness degree.

IMPREGNATIONS FOR SISAL AND TAMPICO BUFFS

impregnation	colour	application	density		
TP	BROWN	stainless steel	soft and sticky		
TPLL	LIGHT BROWN	stainless steel	very soft, sticky and flexible		

TREATMENTS FOR COTTON BUFFS

treatment	colour	application	density		
Golden GG	GOLDEN YELLOW	steel, aluminium, brass, alloys	rigid, hard, dry and very resistant		
Golden GB	WHITE	steel, aluminium, brass, alloys	3		
Royal Blu	BLUE	steel, aluminium, brass, alloys	flexible and resistant		
Nap Verde	GREEN	steel, aluminium, brass, alloys	medium-rigid on soft cloth		
Red	RED	steel, aluminium, brass, alloys	flexible and resistant, on cloth of high quality		