

Wagner is pleased to offer for your use the same quality polishing belts, buffs and compounds used in our own manufacturing processes. The cotton buff is used for brightening. The sisal buff is for removing minor marks.



BUFFS

Size	Hole Size	Material	Part Number
8" x 1/2"	5/8"	Cotton	PPCB
8" x 1/2"	5/8"	Sisal	PPSB



NON WOVEN ABRASIVE HAND PADS

Packages of 10

Size	Part Number
6" x 9", Maroon	PPHP



POLISHING COMPOUND

Standard bars are 2 3/4 pounds each

- PP35** A medium greasy, fast cutting compound suitable for buffing and coloring out the work in one operation. Our most popular grade for a large variety of work.
- PP45** A very dry grade intended for use on work that has a good starting surface such as light stampings and moldings. Can be used as a coloring compound to bring out a mirror bright luster after polishing lines have been removed using a more aggressive compound. Light green in color.
- PP47** Wagner's most aggressive steel compound. Sharp abrasives produce an extra fast cutting action. Ideal for buffing out light tool marks or scratches. Its use may reduce or eliminate the need for finer belt operations.



MECHANICAL FINISH DESIGNATIONS

#3 Finish

Also called *Grinding, Roughing or Rough Grinding*

These finishes are coarse in nature and usually are a preliminary finish applied before manufacturing. An example would be grinding gates off of castings, deburring or removing excess weld material. It is coarse in appearance and applied by using 36-100 grit abrasive.

When the finish is specified as #3, the material is polished to a uniform 60 - 80 grit.

#4 Architectural Finish

Also called *Brushed, Directional or Satin Finish*

A #4 Architectural Finish is characterized by fine polishing grit lines that are uniform and directional in appearance. It is produced by polishing the metal to a 120 - 180 grit belt or wheel finish and then softened with an 80 - 120 grit greaseless compound or a medium non woven abrasive belt or pad.

#4 Dairy or Sanitary Finish

This finish is commonly used for the medical and food industry - almost exclusively used on stainless steel. This finish is much finer than a #4 Architectural Finish. Great care should be taken in removing the surface defects in the metal - like pits - that could allow bacteria to grow. A #4 Dairy or Sanitary Finish is produced by polishing to a 180 - 240 grit belt or wheel finish and softened with 120 - 240 grit greaseless compound or a fine non woven abrasive belt or pad.

#6 Finish or Fine Satin Finish

This finish is produced by polishing to a 220 - 280 grit belt or wheel finish and softened with a 220 - 320 greaseless compound or very fine non woven abrasive belt or pad. Polishing lines should be soft and less reflective than a #4 Architectural Finish.

#7 Finish

A #7 finish is produced by polishing to a 280 - 320 belt or wheel finish and sisal buffing with a *cut and color* compound. This is a semi-bright finish that will still have some polishing lines but they should be very dull. Carbon steel and iron are commonly polished to a #7 finish before chrome plating. A #7 finish can be made bright by color buffing with coloring compound and a cotton buff. This is a good way to keep polishing costs down when a part needs to be shiny but not flawless.

#8 Finish or Mirror Finish

This finish is produced by polishing to at least a 320 grit belt or wheel finish. Care should be taken in making sure all surface defects are removed. The part is sisal buffed and then color buffed to achieve a mirror finish. The quality of this finish is dependent on the quality of the metal being polished. Some alloys of steel and aluminum cannot be brought to a mirror finish. Castings that have slag or pits will also be difficult - if not impossible - to polish to a #8.



POLISHING BELTS

½" x 24", Packages of 10

Belt Description	Part Number
50 Grit Ceramic	PP50GRRLPC
80 Grit Zirconium	PP80GRZIR
120 Grit	PP120GR
120 Grit Zirconium	PP120GRZIR
240 Grit	PP240GR
320 Grit	PP320GR
400 Grit	PP400GR
Coarse Non Woven Abrasive	PPCRS
Medium Non Woven Abrasive	PPMED
Fine Non Woven Abrasive	PPFINE



FINISHING PULLEY

Part Number

PP1

REPLACEMENT PARTS

Description	Part Number
Disk	PP1A
Hub	PP1B
Rubber Ring	PP1C
6 Disks and Rings	PP1D



Finishing Pulley in use with 6000 RPM, 9" Grinder, 15 amp.

During normal use, the **Finishing Pulley Disk** will develop sharpened edges. Replace these disks immediately upon noticing any hazardous edges.



Stan • Inventory Control

SATIN FINISHING ROUND TUBE, PIPE OR BAR

For round tube, pipe or bar that require a #4 Satin Finish.

Note: When polishing, be sure to wear proper safety attire including a dust mask and safety glasses.

1. Grind out any welds and any deep gouges in the material. Always be careful not to over grind or under cut the welds. Feather any gouges carefully.
2. Attach the **Wagner Finishing Pulley – PP1** – to a disk grinder as shown below.
3. Spot rope any ground welds and repaired gouges and deep scratches with a 50 grit belt. Be sure to put a twist in the belt as shown in the photo to keep the grit portion of the belt from damaging the finishing pulley. Only do this step if your material has bad spots that require this aggressive process. You will only want to be as aggressive in finishing as you need to be. If in doubt, go to step 4.
4. Rope with an 80 grit belt.
5. Rope with a 120 grit belt.
6. For final clean-up and finish, rope with a medium non woven abrasive belt.

Always handle material with care. Even stainless steel surfaces will nick and scratch when handled improperly.

In the case of stainless steel, avoid as much contact between it and ferrous material as possible. Always use new belts. Do not use any tools or belts that were used on any other materials – especially steel. Otherwise you run the risk of contaminating the stainless steel with imbedded ferrous particles that will cause it to rust.

When polishing is completed, immediately wrap the finished material to avoid contamination from ferrous particles prior to installation.

Stainless Steel Preventive Maintenance Suggestions

- Inspect the installation on a frequent schedule taking note of discoloration and stains. Discoloration can and should be removed by cleaners recommended for stainless steel.
- Ongoing maintenance consisting of a fresh water wash and wiping with a clean cloth is recommended to minimize deterioration. In all but the most severe cases, this regular washing will eliminate the need for refinishing.
- Never use steel wool or harsh abrasive elements.



LIDO-LUSTRE™ METAL POLISH CREAM

May be used to remove tarnish from brass, bronze, aluminum and stainless steel. Leaves a silicone film for longer protection.

Description	Part Number
6.33 ounce tube	14663

BRACKETS

WELD FITTINGS

ELBOWS

FLANGES

SPHERES CAPS

SLIP-ON FITTINGS