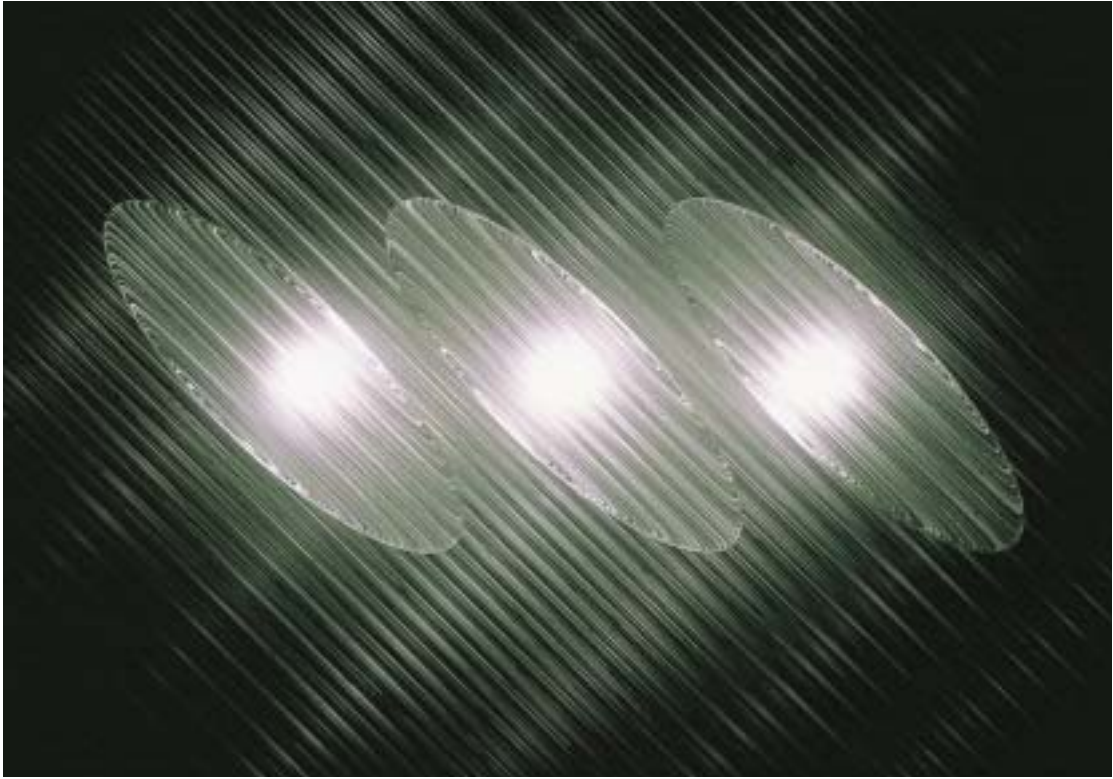




# BUFFING AND POLISHING COMPOUNDS



KOYO-SHA CO., LTD.

# KOYO POLISHING COMPOUNDS



## TRIPOLI COMPOUNDS

- 1 K-0
- 2 K-1
- 3 K-2
- 4 K-3
- 5 K-7
- 6 K-8
- 7 K-9
- 8 K-1000 B
- 9 K-2000
- 10 K-100 RED
- 11 K-100 WHITE
- 12 K-3000
- 13 T-264
- 14 T-266
- 15 T-281
- 16 T-316
- 17 T-325
- 18 T-360

## GREEN ROUGE

- 19 K-1
- 20 K-2
- 21 G-800
- 22 G-300 SOFT
- 23 G-375 \*
- 24 G-0 (WHITE) \*
- 25 G-546 K

\* for automatic machines

## SISAR / STAINLESS COMPOUNDS / LIME

- 26 SISAR No. 1
- 27 SISAR No. 9
- 28 SISAR No. 46
- 29 STAINLESS COMPOUND 1300
- 30 M-193
- 31 M-343
- 32 M-336 B
- 33 ROYAL RED
- 34 EVER LIME-Red Label
- 35 EVER LIME-Black Label
- 36 GREEN LIME
- 37 PRINCE LIME
- 38 ALOX No. 200
- 39 ALOX No. 5
- 40 ALOX No. 10
- 41 SUPER LIME No.100

## PLASTICS COLORING COMPOUNDS

- 42 DANDEE D-435
- 43 DANDEE D-419
- 44 DANDEE D-428
- 45 DANDEE KD (WHITE)
- 46 DANDEE KD (BLACK)
- 47 DANDEE D-460
- 48 DANDEE D-491

## COMPOUNDS FOR TITANIUM

- 49 TP-100
- 50 TP-200
- 51 TP-300
- 52 TP-400

## OTHER COMPOUNDS

- 53 GREASE STICK (WHITE) K
- 54 GREASE STICK AB (in paper cylinder)
- 55 SUNLITE KF-W
- 56 SUNLITE KFF-W
- 57 VALVE COMPOUND
- 58 SATINER K
- 59 LC-242 (WHITE) 10 LITRE/BOX
- 60 LC-138 (GREEN) 10 LITRE/BOX
- 61 LC-153 (BROWN) 10 LITRE/BOX

# FOR STEEL/STAINLESS STEEL

# FOR ALUMINUM/ZINC

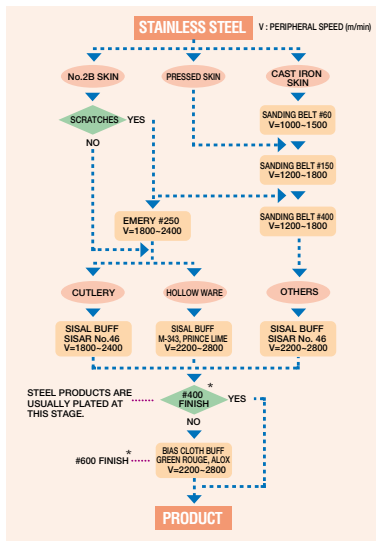
## BUFFING AND POLISHING COMPOUNDS FOR IRON AND STAINLESS STEEL

	SOLID COMPOUND			LIQUID COMPOUND			CHARACTERISTICS / APPLICATION
	PRODUCT NAME	COLOR	PCS/BOX	PRODUCT NAME	COLOR	LITRE/CAN	
CUTTING ↑	SISAR No. 1	BLACK	25	LC-194	GRAY	18 LITRE	ON SISAL BUFFS FOR CUTTING · GOOD FOR REMOVING SCRATCHES LEFT FROM #180-#240 BELT GRINDING OPERATIONS
	SISAR No. 46	PINK	25	LC-396	WHITE	18 LITRE	FOR SISAL BUFFS STAINLESS STEEL POLISHING
	STAINLESS COMPOUND 1300	IVORY	50	—	—	—	FOR SISAL BUFFS STAINLESS STEEL POLISHING
	M-193	GRAY	25	—	—	—	FOR SISAL BUFFS SUITABLE FOR #400 FINISH OF STAINLESS STEEL
	SUPER LIME 100	IVORY	25	—	—	—	FOR SISAL BUFFS
	ROYAL RED	IVORY	25	LC-132	WHITE	18 LITRE	FOR SISAL BUFFS
	SUPER LIME 200	WHITE	25	—	—	—	FOR SISAL BUFFS AND COTTON BUFFS
	PRINCE LIME	WHITE	25	LC-353	WHITE	18 LITRE	FOR SISAL BUFFS AND COTTON BUFFS FOR CUTTING AND COLORING
	SUPER LIME 300	WHITE	25	—	—	—	" "
	M-343	WHITE	25	LC-242	WHITE	18 LITRE	" "
	GREEN LIME	GREEN	25	—	—	—	" "
	GREEN ROUGE K-2	GREEN	50	—	—	—	USED WITH COTTON BUFFS, FOR COLORING
	M-336 B	WHITE	25	LC-711	WHITE	18 LITRE	" "
	GREEN ROUGE G-800	GREEN	50	LC-706	GREEN	18 LITRE	" "
	ALOX	WHITE	50	LC-710	WHITE	18 LITRE	" " NON-CHROMIUM COMPOUND
	ALOX No. 5	WHITE	50	—	—	—	" " NON-CHROMIUM COMPOUND
	GREEN ROUGE K-1	GREEN	50	LC-138	GREEN	18 LITRE	SUITABLE FOR #600 FINISH OF STAINLESS STEEL
	GREEN ROUGE G-300 SOFT	GREEN	50	—	—	—	GIVES MORE LUSTER THAN GREEN ROUGE K-1
COLORING ↓	GREEN ROUGE G-546	GREEN	50	—	—	—	GIVES THE SHEENIEST RESULT / FOR MIRROR FINISH

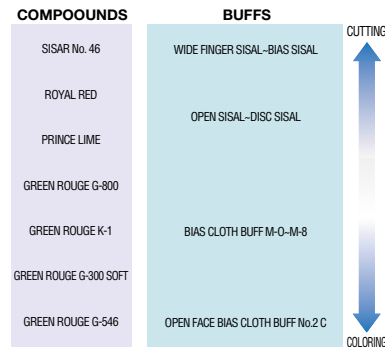
## BUFFING AND POLISHING COMPOUNDS FOR ALUMINUM AND ZINC

	SOLID COMPOUND			LIQUID COMPOUND			CHARACTERISTICS / APPLICATION
	PRODUCT NAME	COLOR	PCS/BOX	PRODUCT NAME	COLOR	LITRE/CAN	
CUTTING ↑	SISAR No. 100	BROWN	25	LC-341	WHITE	18 LITRE	ON SISAL BUFFS FOR CUTTING
	TRIPOLI T-360	BEIGE	25	—	—	—	CAN BE USED WITH BOTH SISAL BUFFS AND CLOTH BUFFS FOR BOTH CUTTING AND COLORING / HIGH CUTTING POWER
	TRIPOLI T-264 · T-266	BEIGE	25	LC-344	BEIGE	18 LITRE	FOR BOTH CUTTING AND COLORING / EASY CLEANING
	TRIPOLI K-2000	RED	25	—	—	—	FOR BOTH CUTTING AND COLORING
	TRIPOLI K-3000	RED	25	LC-153	RED	18 LITRE	FOR BOTH CUTTING AND COLORING / HIGH LUSTER
	SUPER LIME 100	IVORY	25	—	—	—	FOR BOTH CUTTING AND COLORING
	M-343	WHITE	25	LC-242	WHITE	18 LITRE	FOR BOTH CUTTING AND COLORING
	ALOX	WHITE	50	LC-710	WHITE	18 LITRE	ON CLOTH BUFFS FOR COLORING RESULT IS EQUIVALENT TO FINISH DONE BY GREEN ROUGE
COLORING ↓	GREEN ROUGE K-1	GREEN	50	LC-138	GREEN	18 LITRE	EXCELLENT FOR COLORING ON CLOTH BUFFS

### FLOW-CHART OF STAINLESS STEEL POLISHING PROCESS

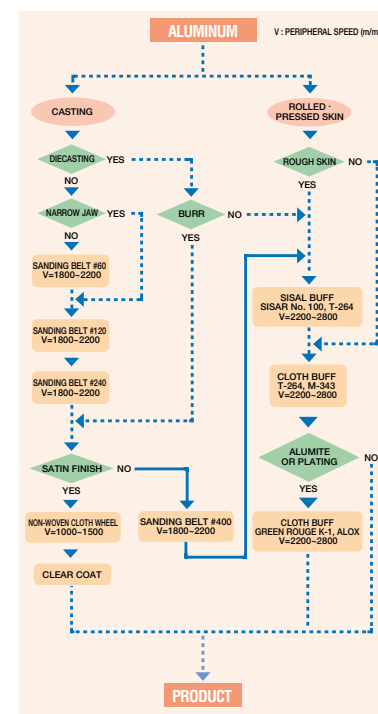


### BUFFING AND POLISHING COMPOUNDS & BUFFS

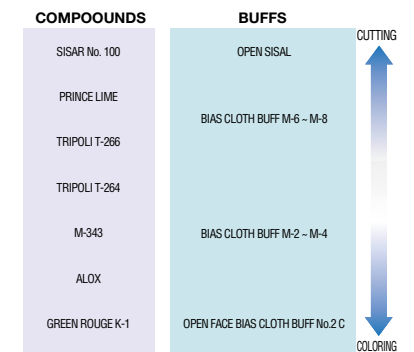


\* #400 FINISH (JIS) NO.6 (AISI)  
 #600 FINISH (JIS) NO.7 of (AISI)  
 JIS (Japanese Industrial Standards)  
 AISI (American Iron and Steel Institute)

### FLOW-CHART OF ALUMINUM POLISHING PROCESS



### BUFFING AND POLISHING COMPOUNDS & BUFFS

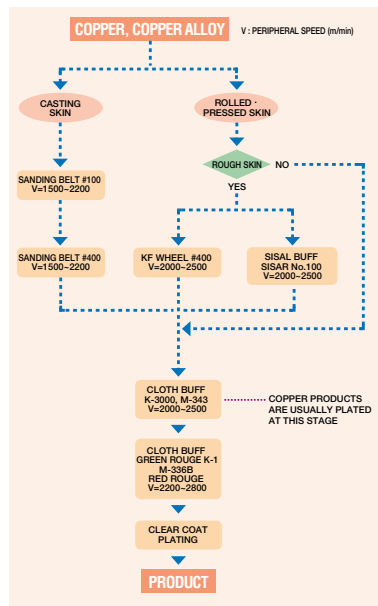


# FOR COPPER / BRASS

## BUFFING AND POLISHING COMPOUNDS FOR COPPER AND BRASS

	SOLID COMPOUND			LIQUID COMPOUND			CHARACTERISTICS / APPLICATION
	PRODUCT NAME	COLOR	PCS/BOX	PRODUCT NAME	COLOR	LITRE/CAN	
CUTTING ↑ ↓ COLORING	SISAR No. 100	BROWN	25	LC-341	WHITE	18 LITRE	CUTTING COMPOUND FOR SISAL BUFFS
	TRIPOLI K-2000	RED	25	---	---	---	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS
	TRIPOLI T-264	BEIGE	25	LC-344	BEIGE	18 LITRE	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS EASY CLEANING
	TRIPOLI K-1000 B	BEIGE	25	---	---	---	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS GIVES MODERATE LUSTER
	TRIPOLI K-3000	RED	25	LC-153	RED	18 LITRE	USE ON SISAL & CLOTH BUFFS / GIVES GOOD LUSTER / BEST FOR CUTTING AND COLORING / HAS MORE CUTTING POWER THAN T-264, 1000B, AND K-2000
	CROCUS COMPOUND	RED	25	---	---	---	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS
	PRINCE LIME	WHITE	25	LC-353	WHITE	18 LITRE	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS HAS MODERATE CUTTING POWER
	M-343	WHITE	25	LC-242	WHITE	18 LITRE	CUTTING AND COLORING COMPOUND FOR SISAL OR CLOTH BUFFS BEST FOR FINISHING BEFORE PLATING
	M-336 B	WHITE	25	LC-711	WHITE	18 LITRE	COLORING COMPOUND FOR CLOTH BUFF / LESS BUFF STREAK
	RED ROUGE R-36	RED	50	---	---	---	USE ON CLOTH BUFFS EXCELLENT COLORING COMPOUND WHICH GIVES REDDISH LUSTER
	ALOX 10	WHITE	50	---	---	---	USE ON CLOTH BUFFS / BEST FOR FINISHING BEFORE COATING
	GREEN ROUGE K-1	GREEN	50	LC-138	GREEN	18 LITRE	USE ON CLOTH BUFFS EXCELLENT FINISHING COMPOUND WHICH GIVES DARK LUSTER

## FLOW-CHART OF COPPER AND BRASS POLISHING PROCESS



## BUFFING AND POLISHING COMPOUNDS & BUFFS

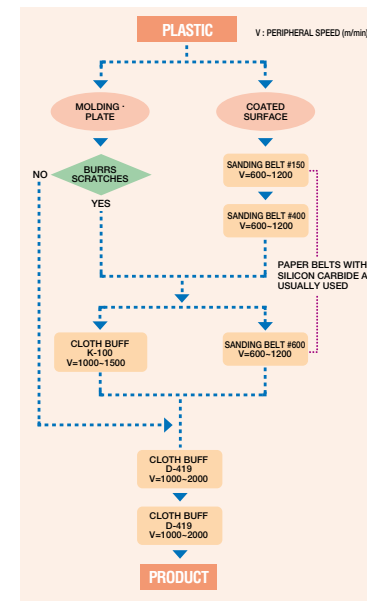
COMPOUNDS	BUFFS	
SISAR No.100	OPEN SISAL	CUTTING ↑ ↓ COLORING
TRIPOLI K-3000	BIAS CLOTH BUFF M-6 - M-8	
M-336B	BIAS CLOTH BUFF M-0 - M-2	
GREEN ROUGE K-1	BIAS CLOTH BUFF M-0 - M-2	
RED ROUGE R-36	OPEN FACE BIAS CLOTH BUFF No.2 C	

# FOR PLASTICS / COATED SURFACES

## BUFFING AND POLISHING COMPOUNDS FOR PLASTICS AND COATED SURFACES

	SOLID COMPOUND			LIQUID COMPOUND			CHARACTERISTICS / APPLICATION
	PRODUCT NAME	COLOR	PCS/BOX	PRODUCT NAME	COLOR	LITRE/CAN	
CUTTING ↑ ↓ COLORING	TRIPOLI K-100 RED	RED	25	---	---	---	GOOD FOR CUTTING ON CLOTH BUFF M-0 OR M-4 (K-100 WHITE IS SPECIALLY DESIGNED FOR WHITE-COLORED OBJECTS)
	K-100 WHITE	BEIGE	25	---	---	---	
	TRIPOLI K-3000	RED	25	LC-153	RED	18 LITRE	"
	DANDEE D-419	GRAY	50	---	---	---	GOOD FOR CUTTING AND COLORING ON CLOTH BUFF M-0 OR M-4
	DANDEE D-428	GRAY	50	---	---	---	"
	DANDEE KD WHITE	BEIGE	50	LC-118	BEIGE	18 LITRE	GOOD FOR COLORING ON OPEN FACE BIAS CLOTH BUFF No.2 C (KD WHITE IS SPECIALLY DESIGNED FOR WHITE-COLORED OBJECTS)
	BLACK	BLACK	50	---	---	---	
	DANDEE D-460	YELLOW	50	LC-372	WHITE	18 LITRE	ON FLANNEL BIAS CLOTH BUFF FOR COLORING
	DANDEE D-491	WHITE	50	LC-808	WHITE	18 LITRE	ON FLANNEL BIAS CLOTH BUFF FOR COLORING ESPECIALLY SUITABLE FOR ACRYL

## FLOW-CHART OF PLASTICS / COATED SURFACES POLISHING PROCESS



## RUBBING COMPOUND (FOR PLASTICS AND COATED SURFACES)

PRODUCT NAME	COLOR	ROUGHNESS	PCS. / BOX
SUNLITE KC-R	ROSE	COARSE	0.2 LITRE = 24 CANS / BOX
SUNLITE KM-R	ROSE	MEDIUM	0.4 LITRE = 12 CANS / BOX
SUNLITE KF-R	ROSE	FINE	1 LITRE = 12 CANS / BOX
SUNLITE KC-W	WHITE	COARSE	4 LITRE = 4 CANS / BOX
SUNLITE KM-W	WHITE	MEDIUM	18 LITRE = 1 CAN
SUNLITE KF-W	WHITE	FINE	(PLEASE USE WHITE ONES FOR WHITE OBJECTS)
SUNLITE KFF-W	WHITE	VERY FINE	

## SUNLITE

SUNLITE IS A COMPOUND FOR SYNTHETIC RESIN (PLASTIC) AND COATED SURFACE. PUT SUNLITE ON SURFACES OF OBJECTS, AND THEN POLISH BY BONNET BUFF ATTACHED TO A POLISHER. FOR FINISHING OF TINY PARTS OR REMOVING FINE SCRATCHES, HAND POLISH WITH A SUNLITE-APPLIED-PIECE OF CLOTH IS SUITABLE.

## BUFFING AND POLISHING COMPOUNDS & BUFFS

COMPOUNDS	BUFFS	
TRIPOLI K-100 WHITE or RED	BIAS CLOTH BUFF M-0 - M-4	CUTTING ↑ ↓ COLORING
TRIPOLI K-3000	OPEN FACE BIAS CLOTH BUFF No. 2 C	
DANDEE D-435		
DANDEE D-419		
DANDEE D-428		
DANDEE KD WHITE or BLACK	BIAS FLANNEL BUFF	
DANDEE D-460		
DANDEE D-491	CONVENTIONAL FLANNEL LOOSE BUFF	

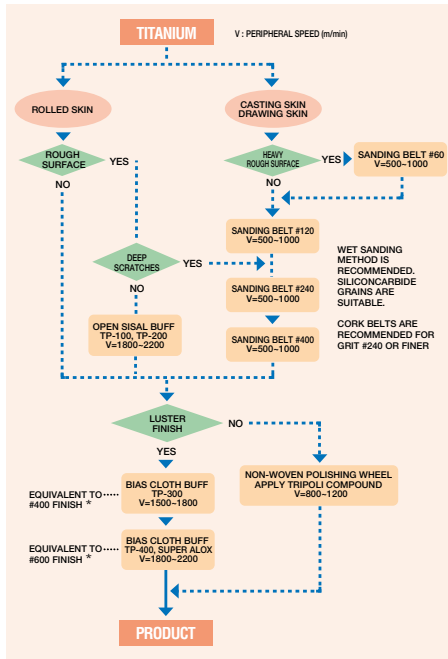
# FOR TITANIUM

## BUFFING AND POLISHING COMPOUNDS FOR TITANIUM

SOLID COMPOUND			CHARACTERISTICS / APPLICATION
PRODUCT NAME	COLOR	PCS/BOX	
TP-100	BLACK	25	FOR CUTTING ON SISAL BUFFS / HIGH CUTTING POWER GOOD FOR REMOVING WAVES AND SCRATCHES OF MATERIALS
TP-200	GRAY	25	SUITABLE FOR CUTTING AND COLORING ON SISAL BUFFS GOOD BALANCE OF CUTTING AND COLORING MAKES A SURFACE WITHOUT PIN HOLES
C-800	BLACK	50	ON SISAL BUFFS FOR CUTTING AND COLORING HAS GOOD CUTTING POWER / SUITABLE FOR SISAL FINISH
TP-300	BEIGE	50	ON CLOTH BUFFS FOR CUTTING AND COLORING / REMOVES SISAL MARKS CAN OBTAIN A SURFACE EQUIVALENT TO #400 FINISH OF STAINLESS STEEL
TP-400	WHITE	50	ON CLOTH BUFFS FOR COLORING / REMOVES PIN HOLES AND BUFF SCRATCHES, AND GIVES A LUSTROUS SURFACE EQUIVALENT TO #800 FINISH OF STAINLESS STEEL
SUPER ALOX	YELLOW	50	ON CLOTH BUFFS FOR COLORING / REMOVES PIN HOLES AND BUFF SCRATCHES, AND GIVES A LUSTROUS SURFACE EQUIVALENT TO #800 FINISH OF STAINLESS STEEL (ESPECIALLY FOR TITANIUM ALLOY, SUPER ALOX CREATES MORE LUSTROUS SURFACE THAN TP-400)

CUTTING  
↑  
↓  
COLORING

### FLOW-CHART OF TITANIUM POLISHING PROCESS



\* #400 FINISH (JIS) NO.6 (AISI)  
#600 FINISH (JIS) NO.7 of (AISI)  
JIS (Japanese Industrial Standards)  
AISI (American Iron and Steel Institute)

### FOR SISAL BUFF

IT PREVENTS WORKS FROM HAVING BURN MARKS, THAT ARE EASILY BROUGHT ABOUT DURING A CUTTING PROCESS, AND MADE IT POSSIBLE TO HAVE EFFICIENT POLISHING. IT SHOWS THE GREATEST EFFECT WHEN USED WITH OPEN SISAL BUFFS.

#### TP-100

A POLISHING COMPOUND WHICH IS DESIGNED BY ATTACHING GREATER IMPORTANCE IN HIGH CUTTING POWER, AND IT SHOWS MUCH EFFECT IN A PROCESS OF REMOVING SCRATCHES AND WAVES OF MATERIALS. BY USING TP-200 COMPOUND AFTER THIS STAGE, CLOTH BUFF FINISH WILL BE EASIER.

#### TP-200

A POLISHING COMPOUND OF GOOD BALANCE OF CUTTING AND COLORING. IT IS CONSIDERED AS A STANDARD PRODUCT FOR SISAL BUFF. SUITABLE FOR CUTTING AND COLORING TO GET A SMOOTH SURFACE WITHOUT PIN HOLES.

### FOR CLOTH BUFF

TITANIUM WHICH WAS SAID TO BE DIFFICULT TO HAVE A LUSTER FINISH CAN EASILY BE FINISHED UP TO SURFACE EQUIVALENT TO #400 AND #600 FINISH OF STAINLESS STEEL.

#### TP-300

AN INDISPENSABLE POLISHING COMPOUND FOR A PROCESS OF LUSTER FINISH. IT REMOVES SISAL PATTERNS SMOOTHLY, AND A LUSTER SURFACE EQUIVALENT TO #400 FINISH OF STAINLESS STEEL CAN BE OBTAINED.

#### TP-400

IT PREVENTS WORKS TO HAVE PIN HOLES AND BUFF SCRATCHES DURING A "GREEN ROUGE COMPOUND FINISH" PROCESS, WHILE POLISHING AT HIGH LOAD. BY USING TP-400, A LUSTER SURFACE WITH A HIGH REFLECTION RATE EQUIVALENT TO #600 FINISH OF STAINLESS STEEL CAN BE OBTAINED.

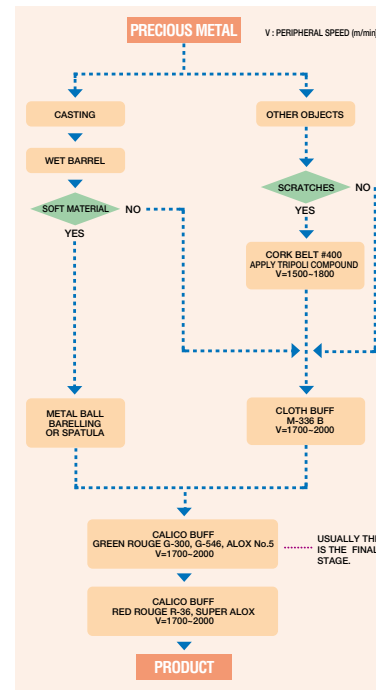
# FOR PRECIOUS METAL

## BUFFING AND POLISHING COMPOUNDS FOR PRECIOUS METAL

SOLID COMPOUND			LIQUID COMPOUND			CHARACTERISTICS / APPLICATION
PRODUCT NAME	COLOR	PCS/BOX	PRODUCT NAME	COLOR	LITRE/CAN	
TRIPOLI K-3000	RED	25	LC-153	RED	18 LITRE	ON COTTON CLOTH BUFFS ( M-TYPE, C-TYPE, FEATHER, CALICO, AND FLANNEL ) OR FELT BUFFS
GREEN ROUGE G-800	GREEN	50	LC-706	GREEN	18 LITRE	
GREEN ROUGE G-0 WHITE	GRAY	50	---	---	---	
M-336 B	WHITE	25	LC-711	WHITE	18 LITRE	
ALOX	WHITE	50	LC-710	WHITE	18 LITRE	
GREEN ROUGE K-1	GREEN	50	LC-138	GREEN	18 LITRE	
ALOX NO. 5	WHITE	50	---	---	---	
GREEN ROUGE G-300 HARD	GREEN	50	---	---	---	
GREEN ROUGE G-300 SOFT	GREEN	50	---	---	---	
RED ROUGE R-36	RED	50	---	---	---	
SUPER ALOX	YELLOW	50	---	---	---	BEST ONES FOR GOLD AND SILVER OBJECTS

CUTTING  
↑  
↓  
COLORING

### FLOW-CHART OF PRECIOUS METAL POLISHING PROCESS



### BUFFING AND POLISHING COMPOUNDS & BUFFS

COMPOUNDS	BUFFS
TRIPOLI K-3000	CONVENTIONAL CLOTH LOOSE BUFF M
GREEN ROUGE G-800	CONVENTIONAL CLOTH LOOSE BUFF C
GREEN ROUGE G-0	
M-336 B	
ALOX	CONVENTIONAL FLANNEL LOOSE BUFF
GREEN ROUGE K-1	
RED ROUGE R-36	

CUTTING  
↑  
↓  
COLORING

# LUBRICANTS - DELUSTERING COMPOUNDS

## BUFFING AND POLISHING COMPOUNDS FOR PREVENTION OF BURNING

SOLID COMPOUND			CHARACTERISTICS / APPLICATION
PRODUCT NAME	COLOR	PCS/BOX	
GREASE STICK WHITE K	IVORY	40	POPULAR ITEM USED ON EMERY BUFFS, GRINDING STONES, OR NON-WOVEN WHEELS FOR LUBRICATION OR PREVENTION OF BURNING.
GREASE STICK AB	LIGHT BROWN	40	GOOD ON ABRASIVE BELTS OR KF WHEELS FOR LUBRICATION OR PREVENTION OF BURNING (IT IS A LITTLE STICKY). KEPT IN A PAPER CYLINDER
TRIPOLI K-1	RED	25	IT HAS EFFECTS OF LUBRICATION AND PREVENTION FROM BURNING, AND AT THE SAME TIME, THE GRAINS INSIDE TRIPOLI COMPOUNDS GIVE YOU A SMOOTHER SURFACE BY REDUCING THE EMERY BUFFS' (OR BELTS' AND WHEELS') SHARP AND POWERFUL CUTTING ABILITY.
TRIPOLI K-2	BEIGE	25	
TRIPOLI K-0	RED	25	
TRIPOLI Y-3	RED	25	

## COMPOUNDS FOR SATIN FINISH

### SATINER (GREASELESS COMPOUND)

SATINER, ALSO CALLED AS GREASELESS COMPOUND OR SATIN FINISH COMPOUND, IS A KNEADED COMPOUND WHICH IS MADE BY DISPERSING ABRASIVE GRAINS INTO WATER-SOLUBLE BOND SUCH AS GLUE. IT IS SPECIALLY DESIGNED FOR SATIN FINISH, AND USED BY APPLYING TO BUFF SURFACES SAME AS BUFFING AND POLISHING COMPOUNDS. SINCE THIS COMPOUND HAS LESS ADHERENCE TO BUFFS COMPARE TO OTHER POLISHING COMPOUNDS, THRUST SATINER TO A FACE OF A SPINNING BUFF UNTIL SATINER IS SOFTENED UP. ONCE SATINER GETS SOFT, MOVE IT ON THE BUFF SURFACE AND APPLY. THEN, BEFORE POLISHING, SPIN THE BUFF FOR 30 - 60 SECONDS UNTIL SATINER IS HARDENED AND STABILIZED. CONVENTIONAL CLOTH LOOSE BUFF C-TYPE AND CALICO BUFF ARE USUALLY RECOMMENDED FOR THIS COMPOUND. THIS COMPOUND SHOULD BE KEPT IN A REFRIGERATOR OR COOL PLACE. IT EASILY GETS TOO DRY AND TOO HARD TO BE APPLIED TO BUFFS, SO KEEP IT TIGHTLY SEALED IN A VINYL BAG.

## TYPES AND APPLICATIONS

NAME	GRIT	GRIT SIZE	COLOR	PCS/BOX	APPLICATION
SATINER K	A	80	BROWN	25PCS.	FOR SATIN FINISH OF STAINLESS STEEL AND NON-FERROUS METAL SUCH AS COPPER PLATED SURFACES, BRASS OR BRONZE. MORE ADHERENT TO BUFFS THAN SILICON CARBIDE TYPE (C) OF SATINER.
SATINER J		100	"	"	
SATINER H		220	"	"	
SATINER L		280	"	"	
SATINER S		320	"	"	
SATINER I	C	100	BLACK	"	FOR SATIN FINISH OF STAINLESS STEEL. HIGHER GRADE FINISHING SURFACES CAN BE OBTAINED COMPARE TO ALUMINA TYPE (A) OF SATINER.
SATINER A		150	"	"	
SATINER M		220	"	"	
SATINER PU					AUXILIARY AGENT (FOR UNDERCOAT)

\*SATINER PU\* ENHANCES THE ENDURANCE OF OTHER SATINERS (K,J,H,L,S,I,A). THERE IS NO NEED TO APPLY \*SATINER PU\* TO BUFFS EVERY TIME. APPLY IT ONCE IN A FEW TIMES BEFORE YOU APPLY OTHER SATINERS.

## RECOMMENDED PERIPHERAL SPEED

WORKS	WHEEL SPEED (m/min)
STAINLESS STEEL	1200 - 1800
COPPER ALLOY	900 - 1500
DIECASTING	1300 - 1700
COPPER PLATE	1300 - 1700
NICKEL PLATE	1200 - 1300
CHROME PLATE	700 - 1000

## TABLE OF PERIPHERAL SPEED OF BUFFS

LATHE REVOLUTION (rpm)	BUFF OUTSIDE DIAMETER (mm)							
	100	150	200	250	300	350	400	450
	PERIPHERAL SPEED IN METER PER MINUTE							
800	251	377	503	628	754	880	1,005	1,131
900	283	424	565	707	848	990	1,131	1,272
1,000	314	471	628	785	942	1,100	1,257	1,414
1,100	346	518	691	864	1,036	1,209	1,382	1,555
1,200	377	565	754	942	1,130	1,319	1,508	1,696
1,300	408	613	817	1,021	1,225	1,429	1,634	1,838
1,400	440	660	880	1,100	1,319	1,539	1,759	1,979
1,500	471	707	942	1,178	1,413	1,649	1,885	2,121
1,600	503	754	1,005	1,257	1,507	1,759	2,011	2,262
1,700	534	801	1,068	1,335	1,601	1,869	2,136	2,403
1,800	565	848	1,131	1,414	1,696	1,979	2,262	2,545
1,900	597	895	1,194	1,492	1,790	2,089	2,388	2,686
2,000	628	942	1,257	1,571	1,884	2,199	2,513	2,827
2,100	660	990	1,319	1,649	1,978	2,309	2,639	2,969
2,200	691	1,037	1,382	1,728	2,072	2,419	2,765	3,110
2,300	723	1,084	1,445	1,806	2,167	2,529	2,890	3,252
2,400	754	1,131	1,508	1,885	2,261	2,639	3,016	3,393
2,500	785	1,178	1,571	1,964	2,355	2,749	3,142	3,534
2,600	817	1,225	1,633	2,042	2,449	2,859	3,267	3,676
2,700	848	1,272	1,696	2,121	2,543	2,969	3,393	3,817
2,800	880	1,319	1,759	2,199	2,638	3,079	3,518	3,958
2,900	911	1,366	1,822	2,278	2,732	3,189	3,644	4,100
3,000	942	1,414	1,885	2,356	2,826	3,299	3,770	4,241
3,100	974	1,461	1,948	2,435	2,920	3,409	3,895	4,382