



# 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.

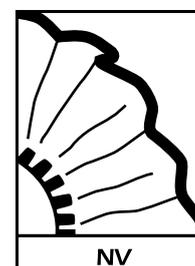
- **ventilated buffs:** for all polishing, bright/mirror finish and satin finish operations of flat and shaped pieces on manual and automatic machines. They can be made up of natural and treated cotton cloth, woollen cloth, Rodiflex, sisal+cotton and sisal cloth with or without impregnations.

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 soon metal rings



- **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.

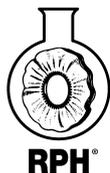
Corrugated buffs are recommended when it is necessary to work with a single wheel, which does not open out.

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



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# IMPREGNATIONS

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 choice 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	<b>YELLOW</b>	all metals	rigid and dry
V/3	<b>GREEN</b>	all metals	medium-rigid
B/50	<b>ORANGE</b>	all metals	dry and not very flexible
B/30	<b>GREY</b>	all metals	dry and flexible
VIOLA	<b>VIOLET</b>	all metals	dry and medium-flexible
B	<b>BLUE</b>	all metals	dry and very flexible
B/L	<b>LIGHT BLUE</b>	all metals	dry and extremely flexible
RV/100 e RV/200	<b>RED</b>	all metals	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	<b>BROWN</b>	stainless steel	soft and sticky
TPLL	<b>LIGHT BROWN</b>	stainless steel	very soft, sticky and flexible

## TREATMENTS FOR COTTON BUFFS

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