

**KIT CONTENTS:****910 SOAP POWDER (180-611) 1 lb.**

Powdered tumbling detergent used with plastic/ceramic media and steel shot for fine finishing and burnishing. Mix 1 tsp. per pint of water, or 3 ozs. per gal. Also available in larger package sizes

**GREEN PLASTIC PYRAMIDS (180-623) 2 lbs.**

$\frac{1}{4}$ " pyramid-shaped plastic media filled with fine silica cutting abrasive specially designed for jewelry finishing. Used during the Step 1. to smooth rough areas. Sold by the lb. in multiples of 10 lbs.

**WHITE PLASTIC PYRAMIDS (180-628) 2 $\frac{1}{2}$  lbs.**

$\frac{1}{4}$ " pyramid-shaped plastic media filled with very fine silica cutting abrasive. Used during Step 2 to produce a very fine bright matte finish. Sold by the lb. in multiples of 10 lbs.

**DRI SHINE III (180-650) 2 lbs.**

Fine, dry organic particles treated with a vehicle and polishing/coloring agents. Used in Step 3 (without water) to produce a high luster. Sold by the lb. in multiples of 10 lbs.

**MEDIA BREAK-IN PROCEDURE**

Plastic media must be broken-in to avoid scratching tumbled pieces. Place media in tumbler bowl. Mix 1 tsp. of 910 Soap Powder into 1 pint of water (or 3 ozs. into 1 gallon of water). Add only enough soap solution to the tumbler bowl to allow media to roll without difficulty. Tumble for 1-2 hours without jewelry or metal pieces. After media have been broken in, wash thoroughly (rinsing in a colander under running water works well). Clean the tumbler bowl as well. Store media in a closed plastic container.

*IF USING MEDIA RIGHT AWAY, USE  $\frac{1}{2}$  THE NORMAL AMOUNT OF SOAP SOLUTION.*

**ALSO AVAILABLE:****FLOW-THROUGH SYSTEM (180-567)**

Provides constant replenishment of soap solutions, avoiding problems caused by sludge and broken-down solutions. Fits our VFM40, VFM50, & VFM75 Vibratory Finishing Machines. Call for more information.

# MEDIA FINISHING KIT

Designed specifically for finishing jewelry castings and stampings, this 3-step system produces superior results on metals including silver, pewter, bronze, and brass. The included plastic pyramid media are filled with a fine silica cutting abrasive which is specially designed for jewelry finishing. Unlike silicon carbide and alumina powders, this abrasive will not impinge or impregnate metal surfaces and interfere with subsequent finishing steps.

**PREPARATORY SMOOTHING**

Successful vibratory finishing requires that pieces first be filed, sanded, or ground to smooth over any rough areas, and remove any remains of casting sprues and mold parting lines. *Attempting to finish jewelry parts without adequate preparatory finishing can result in very long cycles with excessive loss of detail and shape to the parts.* Metal parts can be suitably smoothed with any of the following:

1. A file (#2 cut or finer)
2. Emery cloth or paper (medium or fine grit)
3. Rubberized Abrasive Wheel (medium grit)

**FOLLOW MEDIA BREAK-IN PROCEDURE BEFORE USING PLASTIC PYRAMIDS**

**STEP 1: GREEN PYRAMIDS (CUTTING)**

Place pieces to be tumbled into the tumbler bowl along with an adequate amount of Green Pyramid Media (at least 10 parts media to 1 part of jewelry by volume). Mix 1 tsp. of 910 Soap Powder into 1 pint of water (or 3 ozs. into 1 gallon of water). Add only enough soap solution to the tumbler bowl to allow parts to roll without difficulty. Tumble until surface becomes smooth. If parts are removed prematurely, they will not achieve the proper finish in Step 2. Average time for this step is 3-8 hours, but will vary depending on the condition of the parts.

As the cutting step progresses, you will probably have to add a small amount of water to keep the media rolling well. As soon as appreciable sludge is produced by the cutting action (the soap suds will turn gray and the rolling action may slow down considerably) it is necessary to remove the soap solution and rinse the parts, media, and tumbler bowl before adding new soap solution. It is recommended that the soap solution be changed at least every three hours of operation to avoid discoloration of the parts due to sludge buildup. When you are satisfied that the cutting cycle is complete, clean out the bowl and rinse off the jewelry and media thoroughly. Store media in a closed plastic container.

**STEP 2: WHITE PYRAMIDS (PRE-POLISH)**

Place an adequate amount of White Pyramid Media, along with pieces to be tumbled and fresh soap solution into the tumbler bowl. As in Step 1, add only enough soap solution to allow parts to roll without difficulty. Depending on the pieces being processed, the pre-polish step should take from 2-5 hours. The cycle is complete when the surfaces of the parts have a bright finish.

Check the progress periodically, changing the soap solution if it becomes gray or the suds break down. When finished, clean out the bowl and rinse off the jewelry and media thoroughly. Store media in a closed plastic container.

**STEP 3: DRI SHINE III (FINAL POLISHING)**

Place pieces into the tumbler along with Dri Shine III Compound (this is a dry process, so no water is needed). Tumble until a high luster develops. If Step 2 was done well, the final luster may be expected in as little as 4-5 hours. Longer cycles may improve results. Because no maintenance is required, this step may be run overnight. Store media in a closed container to reduce evaporation of the polishing vehicle.

Media is normally effective for at least 200 hours of use and can be recharged with our Simichrome Polishing Paste (no. 520-103).