

Buffing My Way

by Jack Hanley

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Basic Guidelines

For Wheels

- ❖ Mark direction of travel on wheel (and always run in that direction).
- ❖ Mark grit size or name on wheel (and always use the same grit or wax)
- ❖ Run lathe fast – up to vibration point is OK
 - ◆ Particularly for carnauba wax (it is very hard and needs to be melted)
- ❖ Apply grit and wax (separate wheels) liberally and often

For Bowl Buffs

- ❖ Mark direction on reverse of buff
- ❖ Mark grit size on reverse of buff
- ❖ Use draw bar to keep buff in headstock – remember – do not use draw-bar any longer than needed, it could whip and damage you
- ❖ Run lathe as fast as is safe – it will still be too slow (see speed table)
- ❖ Apply grit and wax to separate bowl buffs

Understanding Wheel Speed

| | Speed | | |
|-----------------------|-----------------|-----------------|-----------------|
| | <u>1000 RPM</u> | <u>2000 RPM</u> | <u>3000 RPM</u> |
| Wheel Size | | | |
| 8" | 2,000 ft/min | 4,000 ft/min | 6,000 ft/min |
| 6" | 1,500 ft/min | 3,000 ft/min | 4,500 ft/min |
| | | | |
| Bowl Buff Size | | | |
| 3" | 250 ft/min | 800 ft/min | 1,100 ft/min |
| 4" | 500 ft/min | 1,000 ft/min | 1,600 ft/min |
| 5" | 600 ft/min | 1,300 ft/min | 1,900 ft/min |

Prepare Wheel for Lathe Operation

- ❖ Assemble in this order:
 - 3' x 3/8' coarse thread bolt
 - 1" outside diameter washer
 - 2 – 2 1/2" o. d. washer
 - buffing wheel
 - 2 – 2 1/2" o. d. washer
 - 1" o. d. washer
 - 3/8" nut
 - 3/8" hexagonal connecting nut

- ❖ Use appropriate chuck jaws to grip connecting nut

Buffing Sequence

❖ Generally followed:

- Sand to 400 grit or more
- Green - optional
- Tripoli – red rouge, etc.
- White diamond
- Carnauba wax

❖ My way:

- Sand to 280 grit or so
- 555 polish (see sources page)
- Carnauba wax

◆ or

- Sand
- 555 polish
- Finish – oil, etc.
- 555 polish
- Carnauba wax

Sources

❖ **Brownells:** 1 (800) 741-0015

www.brownells.com

200 South Front Street

Montezuma, Iowa 50171

Catalog - \$5 (refunded with first order)

555 Polish white 080 555 002 15.59

1" thick loose muslin wheel, 1/2 " arbor
8" x 1" 032 081 500 16.84

❖ **Craft Supplies USA** 1 800 551 8876

www.woodturnerscatalog.com

1287 E. 1120 S.

Provo, Utah 84606

Carnauba wax 019-1108 5.99

Muslin buffing wheel – 8" 35 ply 9.99
for polish - slow speed "soft flexible buff"

Flannel buffing wheel – 8" 30 ply 9.99
for wax - high speed "more aggressive buffing action"