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## **Raytech Media Use Tips**

For general use... round, oval and cylindrical media shapes are preferred.

Round surface media wears well and has less chance to become lodged in the workpiece.

Finishing times are longer for small media polishing because small media requires gentler processing.

Small media has more contact with the workpiece and produces a smoother, more attractive finish.

Small media should be used with fragile workpieces.

Small sized media ( under  $\frac{3}{4}$ " ) offers a slower cut and a finer finish.

Large sized media produces a rougher surface but lends well to aggressive grinding action on the workpiece.

Large media provides faster removal of burrs and is more effective for radiusing sharp edges.

Large media gives a more rapid cut but offers a coarser surface and more rounding of the edges.

\*\*\*\*\* Always rinse your media and workpieces after 3 hours.

## **SHAPES**

**Cones** are designed to deburr in remote areas without lodging in the workpiece. A good media for a workpiece with holes.

**Angle cut cylinders** improves the finish and can reach into remote areas of the workpiece. Use this shape to burnish, polish, lightly deburr and to remove loose abrasives on the workpiece. Best to use on concave surfaces, rounded areas and workpieces with holes.

**Pyramids** provide the best cutting action. Will reach into holes and slots on a workpiece.

**Triangles** are a general purpose mildly abrasive media. The shape allows maximum surface contact and almost no lodging of media into the workpiece. Excellent for slotted areas /reaching into corners of a workpiece. Provides a uniform effective finish.

**Polyhedrons ( 5 sided triangle pyramid)** This media offers excellent wedging characteristics that reduce or eliminate lodging. This shape will wear slower and is a very efficient media shape.

**V Cut Cylinders** A unique shaped efficient media that eliminates many lodging problems. Will reach hard to finish corners, slots, and angles on the workpiece.

#### **The workpiece and the proper media**

- Deburring ...use Ceramic
- Polishing ....use Walnut Shells or Porcelain balls
- Achieve a dull finish .....use Ceramic
- Smooth and shiny finish ....use Plastic
- Remove that *orange peel* look ....use Ceramic with a very aggressive tumbling process
- On Stainless Steel/Steel/Cast Iron.... use Ceramic
- On Aluminum/Brass/Soft Metals/Plastic pieces...use Plastic Media

#### **Plastic Media Cut- requires a one to two hour break in period before use on a workpiece**

- White Plastic Triangle Media gives a Very Fine least aggressive cut
- Green Plastic Triangle Media gives a Light mid cut
- Brown Plastic Triangle Media gives a Medium more aggressive cut

