

Instructions for Deburring in the Ultra- Vibe Industrial Vibratory Tumblers

The bowl should be filled about 2/3 full with plastic or ceramic media. Start the tumbler while the media dry. Immediately add a small amount of water (a few splashes) until the media pieces are wet, but not saturated.

Add a few drops of soap or detergent until very light foam begins to form. If foam does not form, add little more water. On the other hand, if the foam becomes too heavy, the work pieces will be cushioned and the cutting action will be decreased. A heavy foam means there is too much soap or detergent or too much water in the mixture and the entire mass of media should be rinsed out and started again.

Once the mixture is correct add the work pieces - about 5 parts media to 1 part work pieces. If the work pieces are shaped so that they will tend to hook together, make the ratio 10 parts media to 1 part work pieces. In the initial run, the load should be watched carefully to determine the cycle time for that particular part. The normal cutting time is between 20 minutes and 6 hours.

For the longer runs, a splash of water should be added every 45 minutes to 1 hour to restore the action as the water will evaporate and the slurry will build up as the work is being done causing the cyclonic action to begin to slow. This procedure will keep the action going for a while, but eventually the whole mass may have to be rinsed and started again until the desired finish is reached.

To determine the end of the cycle, inspect the work pieces to be sure all of the pits and scratches have been removed and there is a uniform finish over the entire part. Most of the work will be done on the outside edges of the parts as they are more exposed to the moving media. The flat surfaces will be scrubbed, but very deep scratches cannot be removed by this method.

Taken from Ultra Vibe Tumbler Instructions
Thumlers Tumbler

Epoxy Deburring Media (Stock # 600 & 601)

3/8" Triangles (#600) & 1/2" Triangles (#601) are medium cut triangular shaped media. This media is used for deburring non-ferrous metal parts.

Instructions for Polishing Brass in the Ultra- Vibe Industrial Vibratory Tumblers

Fill the bowl with approximately 3 lbs. of #518 media for the (UV-10) or 6 lbs. of #518 media the (UV18).

While the Ultra Vibe is running, add the brass or metal objects to be cleaned. Up to 125 rifle or up to 400 pistol cases (depending on caliber) may be added to the Ultra-Vibe 10. Check the brass or metal objects periodically until the desired finish is attained.

Brass Polish Media (Stock # 518)

Use Treated crushed Corn Cob for use in a Vibratory Tumbler. This media removes only tarnish and oxidation without scratching. When used in a vibratory tumbler, it will bring metal objects to a gleaming finish in just an hour or two. Media is reusable. When action becomes too slow to be effective, replace 25% of media with new. Also works well in rotary tumblers.