

Dry-barreling for cellulose acetate



TCN offers a complete range of polishing pastes for a dry-barreling process, especially efficient on cellulose acetate material.

Our **grinding, smoothing, polishing and brightening pastes** allow a perfect finish with several successive steps by barreling.

The choice of material, size and shape of the pegs is an essential element for an optimal final result.

Below, the usual process applied on CA items.

2896C600 smoothing paste

2896C600 smoothing paste has a medium abrasive powder.

It is convenient for :

- 1st operation on items requiring a small removal of material.
- Intermediary operation between grinding step with pumice + oil and polishing.
- Preparation of cellulose acetate and polyamide pieces before varnishing.

cut -  +
shiny -  +

605AN polishing paste

605AN polishing paste contains fine abrasive powder providing glossy finishes on several materials. Longer the barrel runs, better the result will be. It is recommended when high quality is required and for items which will be dip-dyed.

605 base allows to prepare the good adhesion of the paste onto the wooden cubes.

cut -  +
shiny -  +

BS3208 brightening paste

BS3208 brightening paste (technical bulletin n° 18 PO 23) contains self-polishing waxes which allow a perfect finish on parts after a polishing or a dyeing operation.

It brings gloss, color depth and also waterproof and antisoiling protection to the treated parts.

cut -  +
shiny -  +

INSTRUCTIONS FOR USE

Preparation of the barrel :

Prepare three compartments of a barrel with 2896C600, 605AN and BS3208 pastes having selected beforehand the appropriated size and shape of the wooden pegs.

For a first cycle, add about 500 g of paste / 25 kg of dust-free pegs and run the barrel.

Use :

Add the parts to be polished in the 2896C600 prepared and run between 12 and 24 hours.

An ultrasonic cleaning of the parts is required between each stage of polishing.

Then, continue the cycle by a 605AN polishing operation then BS3208 brightening operation.

Add 50 to 150 g of paste for each new cycle.

Standard packaging

Metallic pail : 20 kg

Stockage

1 year in tightly original closed packaging in usual storage conditions.

Keep away from heat.



RELATED PRODUCTS FOR DRY-POLISHING

Pegs

Wooden and nylon pegs for grinding.

Wooden beech cubes for polishing : cube 4 - 6 - 8 - 10 - 12 - 15
lozenge 6 - 8 - 10

Plastic medias

CPA15 cones (technical bulletin n° 19 PO 40) allow the surface treatment of hard-to-polish plastics. Their high abrasive power is particularly effective on parts from 3D printing items from powder sintering.

They generate a thin and smooth surface.

SNS accelerator

Process oil in addition to pastes or for dust removal.

Abrasive powders

Pumices of different sizes.

Detergents

The **detergent 6170**, used at 10 ml/l, eliminates in ultra-sound cleaning, the residues of greasy substances on the grinding parts and the **detergent 6179** the residues resulting from polishing. **TP8002 detergent** is an alkaline detergent, effective in eliminating burns caused by laser engraving.