



SurfacePrep

DELIVERING RESULTS BEYOND THE SURFACE

COATED, BONDED & NON-WOVEN ABRASIVES



METAL WORKING SOLUTIONS - GRINDING

File Belts
 Narrow Belts
 Wide Belts
 Resin Fiber Discs
 Film Discs
 Cloth Discs
 Paper Discs
 Quick Change Discs
 Grinding Discs

Grinding Wheels
 Grinding Segments
 Shop Rolls
 Cartridge Rolls
 Spiral Bands
 Flap Bands
 Carbide Burrs
 Wire Wheels

METAL WORKING SOLUTIONS - FINISHING

Hand Pads
 Shop Rolls
 Polishing Belts
 SCM Belts
 Flap Brushes
 Flap Wheels

Interleaf Flap Wheels
 SCM Discs
 Quick Change Discs
 Buff & Blend Discs
 Flex Drums
 Mounted Points
 Unitized Wheels
 Convolute Wheels
 Felt Products
 Buffs & Buff Wheels
 Buffing Compounds

WOOD WORKING SOLUTIONS

PSA Discs
 Hook-and-Loop Discs
 Net & Mesh Discs
 Foam-Backed Discs
 Wide Belts
 Edge Belts

Pump Sleeves
 Sanding Sponges
 Sanding Sheets
 Sanding Blocks
 Sanding Rolls
 Sanding Stars



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TOOLS, MACHINERY & SANDING ACCESSORIES

Air Tools
Grinding Machinery
Polishing Equipment
Buffing Equipment
Electric Tools
Deburring Brush System
Center-Less Grinders
Belt Finishers

Stroke Sanders
Wide Belt Sanders
Back Up Pads
Contact Wheels & Arms
Mandrels
Inflatable Drums
Rubber Expander Wheels
Arbor Adapters

Mounting Plates
Air Tool Oil
Grease Sticks
Air Hose
QC Couplings
Swivel Fittings
And More!



Guidelines for Belt Speed Recommendations (SPFM) Based of Work Piece Material

Aluminum	4500 - 5000	Nickel/Chrome	2500 - 3000
Brass/Bronze	5000 - 6000	Plastics	2000 - 2500
Copper	4000 - 5000	Hard Rubber	6000 - 10000
Fiberglass	5000 - 7000	Mild/Carbon Steel	4000 - 5000
Glass	2500 - 3500	Stainless Steel	4000 - 5000
Grey Cast Iron	4000 - 5000	Titanium	2000 - 2500
Inconel	3000 - 4000	Tool Steel	4000 - 5000

Wide Belt Tension Guidelines

Belt tension pressure should be between 3 and 5 bar:

- 45-55 PSI for paper-backed
- 55-65 PSI for regular cotton cloth-backed
- 65-75 PSI for polyester-backed

Too much pressure shortens belt life:

- Fiction, heat, excessive wear

Not enough pressure shortens belt life:

- Flopping, folding, breaking

Conversion Chart

1 BAR	14.5 PSI
1 PSI	0.0689 BAR
1 ATM	14.7 PSI
1 PSI	.068 ATM

Stainless Steel Mill Finishes

#2B	A mill cold-rolled finish. No abrasive used.
#3	A 2B finish processed with #100 aluminum oxide sanding belt.
#4	Dairy or food service finish. A 2B finish processed with #100.
#6	A #4 finish which has been buffed. A fine satin finish.
#7	A #4 finish followed by #180 then #240 aluminum oxide belts, then cut-buffed, then finally color-buffed to a reflective finish. A bright finish.
#8	A #4 finish followed by #180, 240, 320, and 400 aluminum oxide, followed by cut-buffing, followed by color-buffing to a mirror finish. No grit lines. A convolute or similar wheel may be used instead of the cut-coloring buffing steps if acceptable.

Air Sander Guidelines

90 PSIG (6.2 bar) is the required operating air supply pressure:

- Check the air pressure at the sander while it is running. Confirm that the tool is running at the rate "Free Speed" RPM.
- On an average, a 10,000 RPM non-vacuum sander will run at 9,500 RPM
- A 12,000 RPM non-vacuum sander will run at 11,500 RPM.
- A vacuum sander normally will run at 11,500 RPM.

Inspect the balancer bearing (pad bearing).

Check air filter and oil as needed.

Air Sander Guidelines

Belt tension pressure should be between 3 and 5 bar:

- 3/8" (10 mm) for aggressive sanding
- 3/16" (5 mm) for general sanding
- 3/32" (2 mm) for ultra-fine finishing