



COMPOUND M (#41005R)

COMPOUND M is a liquid burnishing solution designed for use in Raytech Centrifugal Magnetic Finishing equipment. It will maintain the color and polish of magnetic stainless steel media along with enhancing shine and color of processed parts. We recommend using **COMPOUND M** to clean “new” stainless steel magnetic pins to remove any residue on the pin surface from the manufacturing process. This will ensure optimal results when processing parts. Although formulated for burnishing of brass, copper and other copper alloys, can also be used for burnishing aluminum, silver and gold.

PHYSICAL PROPERTIES (Typical)

COLOR:	Blue, clear	PH (2% solution):	3.9-4.3
ODOR:	Faint, acidic	WATER SOLUBILITY:	Complete
LBS./GAL:	9.4	FREEZE TEMP.:	32-38°F
PH (conc.):	3.7-4.1	FOAM CHARACTER:	Moderate to High

USE DIRECTIONS

- To initially clean magnetic stainless steel pins, add the appropriate volume of **COMPOUND M** mixture (see equipment use directions) diluted to a 2-4% (by volume) solution and process pins (no parts) for 1-2 10 minute intervals, changing the solution after the first 10 minutes if the solution appears dark or murky. Rinse after processing. The media is now ready to be processed.
- Use a dilution of 1-2% when processing parts in the centrifugal magnetic finishing unit. Cycle time will vary based on desired finish.
- **COMPOUND M** can also be in conventional vibratory and tumble finishing. Can also be used with carbon steel/stainless steel finishing media as well as ceramic (polishing) and porcelain medias. When used in a flow through application, recommend a concentration of 1% (by volume). Media should be rinsed after use. If carbon steel media is being used, increase concentration of **COMPOUND M** to 2-3% before stopping the vibratory unit. The higher concentration will help in preventing media corrosion. For long term storage, a proper rust inhibitor should be used.

PROCESS EQUIPMENT

- Raytech Centrifugal Magnetic Finisher
- Open tumbling barrel (not recommended for use in closed tumbling barrel due to possible gas buildup)
- Vibratory Finishing – Bowl/Tub with flow through
- Centrifugal Disc Finishing

PACKAGING: 1 gallon bottles

SAFETY/DISPOSAL: Refer to current Safety Data Sheet (SDS) before using this product.

The suggestions and data in this bulletin are based on information we believe to be reliable. They are based on good faith, but offered without guarantee, as conditions and methods of use of our product(s) are beyond our control. **January 2018**

