

# RAYTECH TUMBLERS

## Operating Instructions

### Models

AV-18



AV-25



AV-25SS



Your new Raytech Finishing machine is useful for a wide variety of finishing operations. The following are a few examples:

- Deburring metal stampings and machined parts.
- Descaling metal castings.
- Cutting radii on sharp edges of metal parts.
- Polishing metal and plastic parts.
- Grinding and polishing “baroque” gemstones from rough chips.
- Smoothing and polishing preformed cabochons and small slabs.
- Polishing seashells.

Each type of product finishing requires its own sequence of steps with appropriate abrasives, polishes and medias. These instructions include a general outline of methods and materials required. Consult your distributor for recommended media and compounds.

### Raytech Industries

*A Division of Lyman Products*

475 Smith Street, Middletown, CT 06457

Tel (860) 632-2020

[www.raytech-ind.com](http://www.raytech-ind.com)

Instruction #04276R 05/22



## General Instructions

Your new Raytech Tumbler comes with a motorized base, one bowl and one cover. If the tumbler will be used for polishing as well as for cutting, always reserve one bowl strictly for the polishing step so that it will be free from embedded cutting grit.

To install the bowl, place it over the threaded stud in the base and screw on the nut provided.

**Note: It is essential that this nut be tightened securely so that the bowl will not vibrate loose.**

## Maintenance

The following maintenance should be performed after every 500 hours of use:

1. Check tightness of all hardware.
2. Inspect interior of bowl to ascertain any premature wear.

## Health & Safety Cautions

1. Do not cover the machine with anything (such as a blanket or a box) to insulate the noise as this could cause overheating and become a fire hazard.
2. Always connect the machine to a power source that has been properly grounded to prevent any possible electrical shock.
3. Models 25 and 25SS are designed not to “walk” during normal operation. We recommend that the machine be placed on a Compound Rinsing System or on a solid floor away from any combustible materials. If the machine is used on a bench, it should be blocked in to prevent any accidents. Do not bolt or attach these units to a workbench by any means, as this will void warranty.
4. Prior to any adjustments to the eccentric weight assembly, disengage the machine from its electrical power source.
5. Never attempt to operate or experiment with other than recommended media and compounds.
6. Do not dispose of grits down drain. Remove as much grit as possible by straining.
7. Always use ear protection in the work area while the machine is running. Machine noise level at maximum conditions is 82 dB. Noise levels can be less depending on media applications.

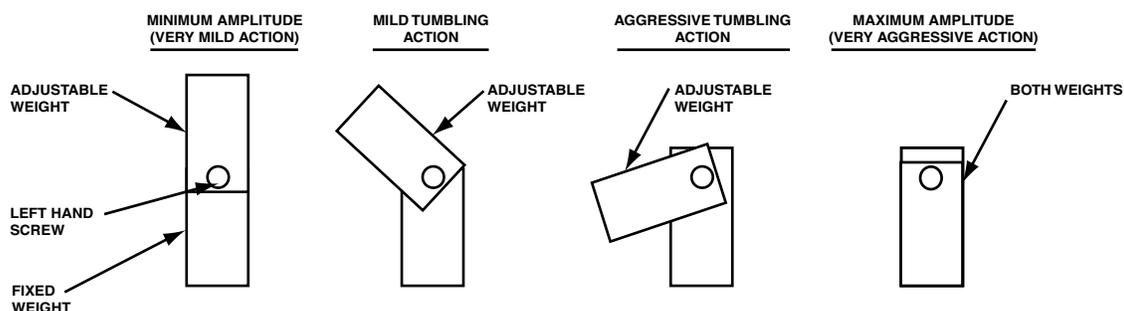
## Adjusta-Vibe Amplitude Adjustment

The amplitude (the amount of movement of the bowl) determines the force with which the tumbling media will act upon the workpieces. The greater the amplitude, the more aggressive the tumbling action will be. The Adjusta-Vibe makes it possible to adjust the amplitude of the tumbler to match the job to be done. The adjustable weight system will produce a tumbling action that ranges from mild to aggressive.

## To Change Amplitude

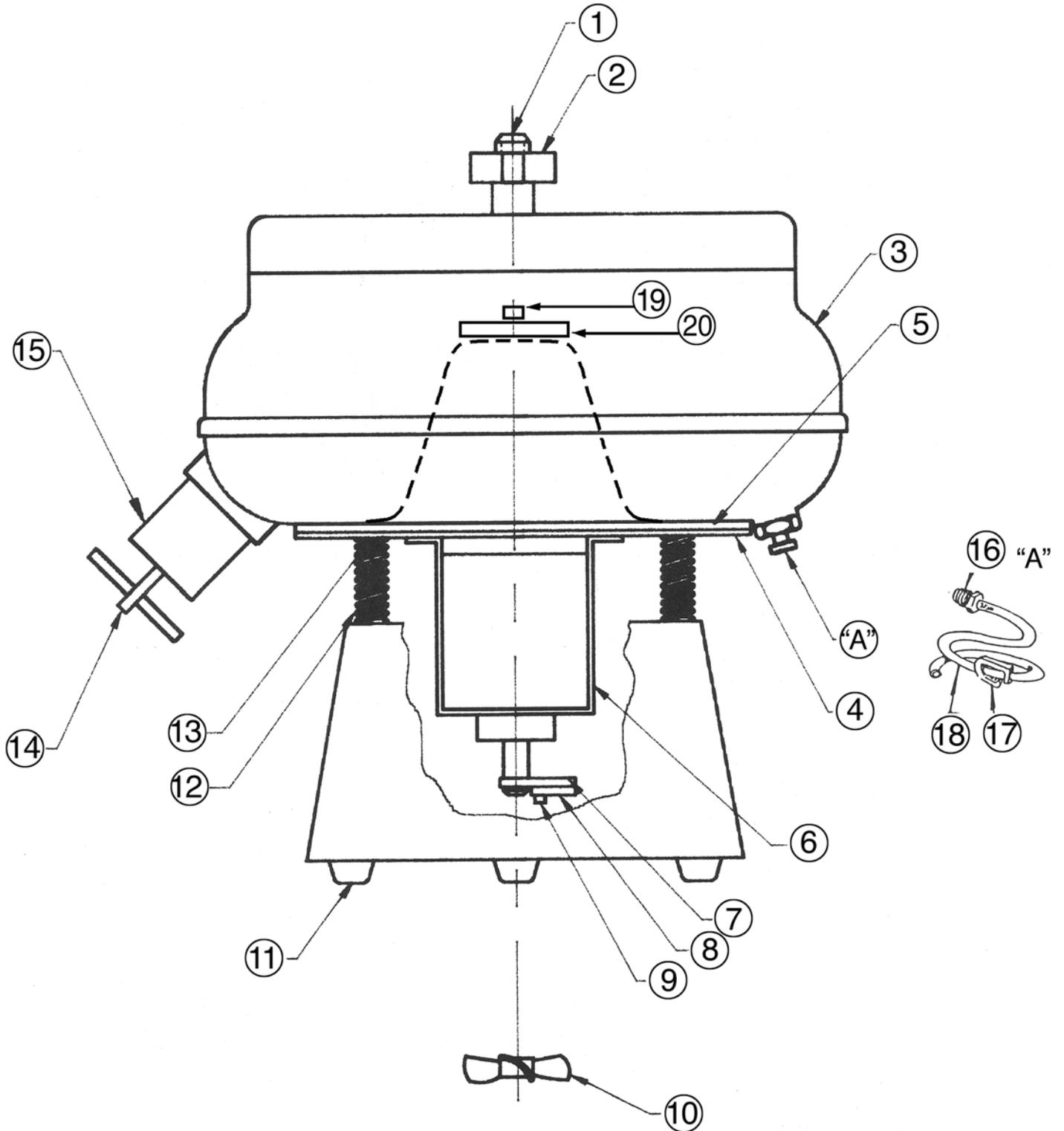
Unplug the machine and turn it upside down and remove the cover at the bottom of the base. To change weight position loosen screws by turning them clockwise. Rotate the adjustable weight to the desired position (see diagram) and turn the screw counterclockwise to lock it in position. After the amplitude is selected, replace the bottom cover, tighten and turn the tumbler to the upright position.

**Note: With the adjustable weight in the maximum position, and the bowl empty, the tumbler will jump and walk when operated. It is strongly advised to load the bowl with the media before starting the tumbler when the weight is in the maximum amplitude position.**



# Parts List

Models AV-18, AV-25, & AV-25SS



# Parts List

Models AV-18, AV-25, & AV-25SS

Item	AV-18 Part#	AV-25 & 25SS Part #	Description	Qty
1	07988R	07737R	Shaft	1
2	07358R	07358R	Lid Hold Down Nut	1
3	23036R	23017R	B-18 or 25 Bowl & Cover	1
3	N/A	23018R*	BS-20 Bowl & Cover (SS)	1
4	07361R	07361R	Motor Plate Only	1
5	07362R	07362R	Motor Plate Pad	1
6	30253R	30253R	AV-25 Motor 110V	1
6	30292R	30292R	AV-25 Motor 220V	1
7	07360R	07360R	Fixed Eccentric	1
8	07359R	07359R	Adjustable Eccentric	1
9	03080R	03080R	LH Thumb Screw	1
11	07342R	07342R	Rubber Feet	3
12	07325R	07325R	Springs	4
13	8094090P	8094090P	Rubber Well Nuts	4
14	N/A	07816R*	T-Hand Assy-(SS) Model	1
15	N/A	05819R*	Discharge Tube	1
16, 17, 18	23114R	23114R	Tumbler Strainer Assembly	1
19	03353R	03353R	3/8" Nut	1
20	8095570	07812R	Bowl Hold-Down Plate	1

\* Note: For SS Models Only