



SCHÖNBERGER EBONITE
MANUFAKTUR GMBH

Ebonite Finishing

When mirror polished is achieved, Ebonite gets an incredible gloss, which varies by the finesse of the ebonite or hard rubber material used. When buffing, the following step should be taken into consideration:

In order to achieve this glossy look, all surfaces must be prepared to reduce any imperfections from the material caused by the pressing and vulcanization process. To do so, the surface shall be sanded down in steps starting from 240 grit sand paper and incrementing to 320 grit, 600 grit and 1000 grit.

Note: When complete smoothness is required, but critical factors such as normal heat caused by the buffing process could alter the part, then it may be possible to reach up to 5000 grit depending on the application without the use of the polishing wheel. Nonetheless; it may not have such glossy tone to it.

Better results can be achieved when using wet-sanding paper and water during the sanding process.

Please be sure to keep an evenly stroke while sanding the surface. This will allow having a better finish.

A buffing drum may be used to reach small areas when dealing with small parts such as pipe stems, saxophone mouthpieces and others.

The whole process has 4 clear steps:

1. Pumicing, dressing or pre-sanding
2. Buffing "Cutting": This step is done right after the sanding process in order to cut the imperfections of the sand paper.
3. Buffing "polishing": Done after cutting to achieve mirror glossy finish.
4. Cleaning: Mild soap is used with cold water. Never use Alcohol or any types of solvents as in time will remove the glossy finish of the surface.

Note: When buffing the surface normal heat is created. This of course should be avoided at all times since it will degrade the results. Therefore; the surface shall be prepared as mentioned above.

Lastly depending on the size of the part, various buffing machines are available. Generally speaking machines with 800 to 2000 rpm's are common use for this applications. Various buffing compounds and wheels ranging from 100 mm, 400mm and 800 mm are often used by professionals when buffing hard rubber compound. Make sure you consult us and we will direct you to the right machine for your purpose.

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1.	Pumicing or prepolishing The disc consists of: 1 disc inlay 1 disc muslin 2 interlayers with a diameter of approx. 150 mm This order continues, until the desired disc width is reached. The recommended polishing paste is 113 GZ color: brown produced by Menzerna, Karlsruhe.
2.	Polishing The disc consists of: 2 discs barracan 4 interlayers with a diameter of approx. 150 mm This order continues, until the desired disc width is reached. The recommended polishing paste is P 175 color: yellow produced by Menzerna, Karlsruhe.
3.	Expiration The disc consists of: 2 discs barracan 6 interlayers with a diameter of approx. 150 mm Without any polishing paste or wax, just with fatfree discs.

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