

## Vibratory Tumblers

### Tumble-Vibe 5

This popular economical and versatile unit is a favorite of hobbyists and is used commercially as well. The .05 cubic foot 8-inch bowl with solid lid holds 25 ring castings with media or will process about four pounds of rock. Shipping weight 6 pounds; shipping volume 1.05 cubic feet. CE



TV-5 (115V, 60 Hz) . . . . .	23-001
TV-5 (230V, 50 Hz) . . . . .	24-106
Base w/Motor (115V, 60 Hz, 1.0 amp) . . . . .	30-251
Base w/Motor (230V, 50 Hz, 0.5 amps) . . . . .	30-290
Bowl & Lid . . . . .	23-005
Main Post/Shaft. . . . .	8094230
Rubber Well Nut. . . . .	23-004
Washer . . . . .	03238

### Dri-Polisher

The Dri-Polisher features a 10-inch diameter bowl with a capacity of .12 cubic feet. All Dri-Polishers come with a free charge of Dri-Shine III, a Raytech exclusive universal polishing media. Shipping weight 8 pounds; shipping volume 1.05 cubic feet. CE



Dri-Polisher (115V, 60 Hz) . . . . .	23-012
Dri-Polisher (230V, 50 Hz) . . . . .	24-102
Base w/Motor (115V, 60 Hz, 1.0 amp) . . . . .	8077030
Base w/Motor (230V, 50 Hz, 0.5 amps) . . . . .	8077040
Bowl & Lid . . . . .	23-013
Rubber Well Nut. . . . .	23-004
Main Post/Shaft. . . . .	8094230
Washer. . . . .	03238

### Tumble-Vibe 10

The industrial model TV-10 has heavy duty drive and suspension combined with a tough, cross-linked polyethylene 10-inch bowl. Bowl capacity is .10 cubic feet (35 to 40 rings), has a noise reducing lid and a liquid drain. The machine is equipped for use with Raytech's FT-20 compound rinsing system. Do not run steel shot in this machine; doing so will void the warranty. Shipping weight 12 pounds; shipping volume 1.05 cubic feet. CE



TV-10 (115V, 60 Hz) . . . . .	23-009
TV-10 (230V, 50 Hz) . . . . .	24-108
Base w/Motor (115V, 60 Hz, 1.0 amp) . . . . .	30-252
Base w/Motor (230V, 50 Hz, 0.5 amps) . . . . .	30-291
Bowl & Lid . . . . .	23-010
Main Post/Shaft. . . . .	8094380
Wing Nut . . . . .	8033450
Strainer Assembly . . . . .	23-114
Washer (on bowl) . . . . .	8077300
Hex Nut (on bowl) . . . . .	8033900
Washer (on lid) . . . . .	03243
Wing Nut (on lid) . . . . .	8033450

### Adjusta-Vibe 18

The AV-18 has a capacity of .18 cubic feet. It has adjustable amplitude and is designed for heavy duty use with all medias. The 12-inch bowl is equipped with drains. This model has many features of our larger machines for processing metal parts, whether for deburring or polishing. Shipping weight 13 pounds; shipping volume 2.13 cubic feet. CE



AV-18 (115V, 60 Hz) . . . . .	23-024
AV-18 (230V, 50 Hz) . . . . .	24-113
Replacement Bowl & Lid . . . . .	23-036

See Model AV-25SS for balance of parts.

### Adjusta-Vibe 25SS

This machine is specifically designed for use where steel or stainless steel media processing is required although all medias can be used. It is designed with a heavy duty drive and suspension system and has adjustable amplitude. The AV-25SS has all the features of our larger machines and is a popular size for small production lots. The 14-inch bowl has a discharge port for easier unloading and a capacity of .22 cubic feet. Steel or S/S media capacity is 50 pounds. Shipping weight 22 pounds; shipping volume 2.13 cubic feet. CE



AV-25SS (115V, 60 Hz) . . . . .	23-019
AV-25SS (230V, 50 Hz) . . . . .	24-112
Replacement Motor (115V, 60 Hz, 1.5 amps) . . . . .	30-253
Replacement Motor (230V, 50 Hz, 0.75 amps) . . . . .	30-292
Replacement Bowl & Lid (SS Model) . . . . .	23-018
Strainer Assembly . . . . .	23-114
T-Handle Assembly (25SS Model) . . . . .	07816
Shaft. . . . .	07737
Lid Hold Down Nut . . . . .	07358
Motor Plate . . . . .	07361
Motor Plate Pad . . . . .	07362
Fixed Eccentric . . . . .	07324
Adjustable Eccentric . . . . .	07323
Springs (4) . . . . .	07325
Rubber Well Nuts . . . . .	07345
Rubber Feet (3) . . . . .	07342

The above spare parts also are for the AV-25 (23-016)

(See page 6 for bowl information and page 15 for media capacities)

### Adjusta-Vibe 40

Model 40 vibratory machines are compact, yet have a capacity of .35 cubic feet and are equipped with amplitude adjustment, inlet and outlet ports for compound rinsing systems and heavy duty cross-linked 17-inch polyethylene bowl. Noise reducing lids are standard. When steel burnishing is required, see Model 40SS below. Shipping weight 51 pounds; shipping volume 5.06 cubic feet. CE



- AV-40 (115V, 60 Hz) . . . . . 23-026
  - AV-40 (230V, 50 Hz) . . . . . 24-114
  - Replacement Motor (115V, 60 Hz, 2.0 amps) . 30-255
  - Replacement Motor (230V, 50 Hz, 1.0 amp) . 30-293
  - Replacement Bowl & Lid (40 & TD-40) . . . . . 23-032
  - Shaft Assembly . . . . . 07967
- See AV-75 for balance of parts.

**CAUTION:** The machines and tools described in this catalog are potentially dangerous if improperly used. Please be sure to operate them only at recommended speeds with proper guards installed and while wearing adequate eye protection

### Adjusta-Vibe 40SS

This machine is specifically designed for use where steel or stainless steel media processing is required although all medias can be used. The AV-40SS has all the features of the AV-40 described above and in addition, its 17-inch bowl is equipped with a discharge port for easier unloading. Steel or S/S media capacity is 100 pounds. Shipping weight 51 pounds; shipping volume 5.06 cubic feet. CE



- AV-40SS (115V, 60 Hz) . . . . . 23-027
  - AV-40SS (230V, 50 Hz) . . . . . 24-116
  - Replacement Bowl & Lid (40SS) . . . . . 23-045
  - T-Handle Assembly (40SS) . . . . . 07816
- See AV-40 and AV-75 for balance of parts.

## Vibratory Tumblers

### Adjusta-Vibe 75

The AV-75 is a .75 cubic foot capacity machine that offers increased productivity over other Raytech models. The machine is equipped with a heavy duty drive system that includes amplitude adjustment and the same features as the AV-40. 21-inch diameter bowl. Shipping weight 61 pounds; shipping volume 9.18 cubic feet. CE



- AV-75 (115V, 60 Hz) . . . . . 23-040
- AV-75 (230V, 50 Hz) . . . . . 24-121
- Replacement Motor (115V, 60 Hz, 2.0 amps) . 30-255
- Replacement Motor (230V, 50 Hz, 1.0 amp) . 30-293
- Replacement Bowl & Lid . . . . . 23-046
- Strainer Assembly . . . . . 23-114
- Shaft Assembly . . . . . 07965
- Lid Hold Down Nut . . . . . 07943
- Motor Plate . . . . . 07773
- Rubber Pads (5) . . . . . 07779
- Counter Weight Assembly . . . . . 07972
- Rubber Feet (3) . . . . . 07882
- Spring Grommets (12) . . . . . 07942
- Washer 5/16 USS STD (12) . . . . . 03243
- Compression Springs . . . . . 07941
- T-Handle Assembly . . . . . 07824

### Adjusta-Vibe 75DC

This machine is the same as the standard AV-75 but offers a discharge port for easier unloading when combined with our Manual Separating Screen Set (see page 9). Shipping weight 68 pounds; shipping volume 9.18 cubic feet. CE



- AV-75DC (115V, 60 Hz) . . . . . 23-038
  - AV-75DC (230V, 50 Hz) . . . . . 24-119
  - Replacement Bowl & Lid (75-DC) Model . . . . . 23-047
- See AV-75 for balance of parts.



## Vibratory Tumblers

### Tumble-Dump™ 40, 75 & 75 DC

For fast, easy unloading, the best choice would be Raytech's Tumble-Dump models 40, 75 or 75DC. These models incorporate all the features of the Adjusta-Vibe models with one addition: Raytech's patented Tumble-Dump tilting plate. Discharge port on TD-75DC only. Shipping weights and volumes are as follows: TD-40, 56 pounds, 5.06 cubic feet; TD-75 & TD-75DC, 68 pounds, 9.18 cubic feet. CE

TD-40 (115V, 60 Hz) .....	23-031
TD-40 (230V, 50 Hz) .....	24-115
TD-75 (115V, 60 Hz) .....	23-044
TD-75 (230V, 50 Hz) .....	24-122
TD-75DC (115V, 60 Hz) .....	23-042
TD-75DC (230V, 50 Hz) .....	24-124
B-40 Bowl and Lid (AV/TD-40) .....	23-032
B-75 Bowl and Lid (AV/TD-75) .....	23-046
DC-75 Bowl and Lid (AV/TD-75DC) .....	23-047
Shaft Assembly (TD-40) .....	07968
Tilting Plate (TD-40) Model .....	08377
Shaft Assembly (TD-75) Model .....	07966
Tilting Plate (TD-75) Model .....	07933

See AV-75 for balance of parts.



Tumble-Dump 40, 75 & 75DC  
 Displaying its patented, easy and fast tilt feature.

### Sound Dampening Cover

The Sound Dampening Cover fits models AV-75, AV-75DC, TD-75 and TD-75DC. It dampens noise levels (db) 20 to 25%. Access for compound rinsing is provided in the lower cover. Cover fits over the bowl and will not restrict airflow and has an easy on/off feature. Shipping weight 10 pounds.

Sound Dampening Cover ..... 23-092



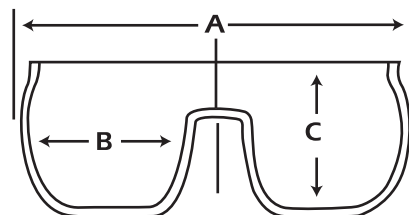
### Spare & Replacement Bowls

Except for the TV-5 and Dri-Polisher, all Raytech bowls are made from tough cross-linked polyethylene and are equipped with liquid drains. Noise reducing lids are standard. Spare bowls are recommended for more than one media-process step, eliminating time-consuming clean-outs. Bowl models BS-20 and BS-33 are designed specifically for use with steel media and have Raytech's exclusive Discharge Chute. All other medias can be run as well. See each model for specific bowl item numbers.



### Spare & Replacement Bowl Chart

Model	A	B	C
5	8"	4"	3.75"
10	10"	3.5"	5"
18	12"	4"	4.25"
40, TD & SS	17"	4.25"	7"
75 & TD-75	21"	7"	9.5"



## Finishing Systems

### AVT-250

The Raytech AVT-250 Fast Finisher will handle a myriad of applications including deburring, descaling, flash removal, cleaning, polishing, and burnishing. It has a capacity of 2.5 cubic feet. When combined with the optional media separator, the system truly offers a portable mass finishing work center that makes it ideally suited to cellular manufacturing. See page 8 for MS-75 details.

**Cabinet Construction:** 14 gauge formed, reinforced and welded steel; complete sound insulation with cover to keep noise level below 80 db.

**Tub Construction:** Continuous welded tub of 11 gauge steel with one-quarter inch steel angle reinforcements; 80-90 durometer urethane lining of one-half inch minimum up to one inch in wear areas; 5-inch urethane discharge chute; easily changed 2.5 x 5-inch drain.

**Drive System:** 1-inch steel shaft with high energy counterweight; heavy duty bearings for continuous use; quick change amplitude; enclosed shaft housing; vibration absorbing, self-aligning belts.

**Electrical System:** 1 hp motor; 3450rpm motor allows the use of a high-energy shaft to impart greater action to the tub; water tight cord connection; water tight electrical box; single phase.

**Internal Compound System:** Self-contained recirculating system, which cuts down on water usage and waste disposal; easily converted to permanent installation with room underneath for plumbing for full flow-through operation. Shipping weights and volumes are AVT-250 – 500 pounds, 15 cubic feet; AVT-250 System – 633 pounds, 32.75 cubic feet.

AVT-250 (115V, 60 Hz, 13.0 amps) . . . . .	23-056
AVT-250 (230V, 50 Hz, 7.0 amps) . . . . .	24-126
AVT-250 System (115V, 60 Hz, 13.0 amps) . .	23-140
AVT-250 System (230V, 50 Hz, 7.0 amps) . .	24-130
Replacement Lid. . . . .	09340
Tub Drain . . . . .	09349
Tub Springs. . . . .	09359
Set of drive belts (2). . . . .	09377

**Overall dimensions (AVT-250 Only):**

A = 42", B = 22 3/4", C = 27 1/4", D = 26 1/4"

**Tub dimensions:**

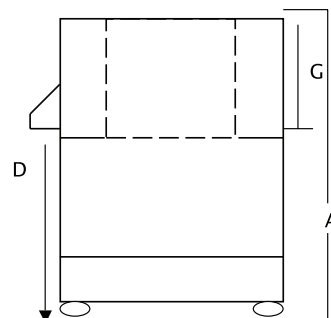
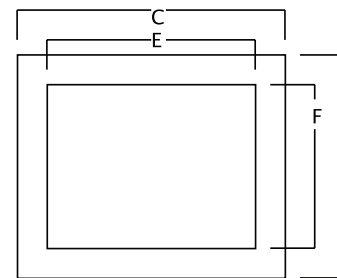
E = 19 3/4", F = 15 1/4", G = 15"



◀ AVT-250



◀ AVT-250 System





## Finishing Systems & Oblique Tumblers

### System 75

The Raytech System 75 is a common sense approach to a totally compact mass finishing operation that incorporates components of the Raytech product line. The System 75 saves labor, space and is easy to install. Both the System 75 and the 75P include the .75 cubic foot Tumble Dump Tumbler, MS-75 separator, and a compounding rinsing system for streamlined mass finishing productivity. Separator screens are optional and must be ordered individually. See MS-75 for screen information. For 230V/50 Hz operation, components must be ordered separately. Shipping weight 251 pounds; shipping volume 33.65 cubic feet consisting of 3 cartons. CE

**System 75, Gravity feed with timer . . . . . 23-129**  
**System 75 P, Recirculating pump with timer . 23-131**

### MS-75 Media Separator

The MS-75 Media Separator eliminates tedious hand separating of finished parts from either wet or dry media. It automatically sorts media and parts into two 70-pound capacity tote boxes. A variety of quick change screens are available. Overall machine dimensions are 36" x 20" x 26" at discharge side. Shipping weight 133 pounds; shipping volume 17.94 cubic feet. **NOTE:** Optional Screens must be ordered separately.

**MS-75 (115v, 60Hz, 4.0 amps). . . . . 23-115**  
**MS-75 (230V, 50Hz, 2.0 amps). . . . . 24-171**

### MS-75 Optional Separating Screens

**9/64" Round . . . . . 23-143**  
**9/32" Round . . . . . 23-147**  
**5/16 x 1/2" Obround . . . . . 23-150**  
**3/8 x 3/4" Obround . . . . . 23-160**  
**3/8" Round . . . . . 23-167**  
**1/2" Round . . . . . 23-169**  
**5/8" Round . . . . . 23-171**  
**3/4" Round . . . . . 23-175**  
**1" Round . . . . . 23-180**

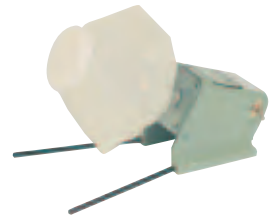
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## Oblique (Open End) Tumblers

### Model 500

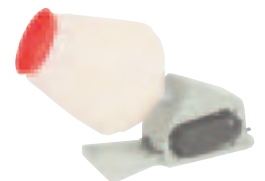
The smaller of the two open end tumblers, the Model 500 can hold a load of up to 5 pounds with a speed of 33rpm. The tumbler barrel is made of heavy duty polypropylene that measure 5 1/2" x 7". This machine will accomplish a myriad of applications at a reasonable price. Shipping weight 8 pounds; shipping volume .75 cubic feet. CE



**115V, 60 Hz. . . . . 22-901**  
**230V, 50 Hz. . . . . 24-180**  
**Spare Bowl & Lid. . . . . 22-914**

### Model 1000

The larger of the two open end tumblers, the Model 1000 can hold a load of up to 15 pounds with a speed of 40rpm. The tumbler barrel is made of heavy duty polypropylene and measures 10" x 10". It will accomplish a myriad of applications in no time. Shipping weight 17 pounds; shipping volume 2 cubic feet. CE



**115V, 60 Hz. . . . . 22-905**  
**230V, 50 Hz. . . . . 24-185**  
**Spare Bowl & Lid. . . . . 22-918**

**FT-20**

This unit incorporates a flow-through design for compound rinsing and comes with a dispensing tank that allows metering of the solution up to 5 hours with a needle valve control. The integral 0 to 6 hour timer control panel allows a tumbler to be directly plugged into the base. Use with tumbler models TV-10, AV-18, and AV-25SS. Shipping weight 26 pounds; shipping volume 2.46 cubic feet. CE

115V, 60 Hz .....	23-104
230V, 50 Hz .....	24-150

**FT-75**

This unit incorporates a flow-through design for compound rinsing and comes with a 32 quart tank that allows up to 8 hours of compound dispensing utilizing a needle valve control for metering. The integral 0 to 6 hour timer control panel allows a tumbler to be directly plugged into the base. Recommended for jewelry and precious metals. Use with tumbler models AV-40, AV-40SS, TD-40, AV-75, AV-75DC, TD-75DC. Shipping weight 59 pounds; shipping volume 7.67 cubic feet. CE

115V, 60 Hz .....	23-105
230V, 50 Hz .....	24-151

**RP-75**

Identical to the FT-75 except instead of a solution container, the RP-75 contains an integral, non-maintenance recirculating pump submerged in the tank. It requires less operator attention since the 32 quart container is eliminated. Recommended for coins and industrial use. Can be used with models AV-40, AV-40SS, TD-40, AV-75, TD-75, AV-75DC, TD-75DC. Shipping weight 50 pounds; shipping volume 7.67 cubic feet. CE

115V, 60 Hz .....	23-106
230V, 50 Hz .....	24-155
RP-75 Pump Only .....	23-113

**Manual Separating Screens**

Screens for manually separating parts from media are 14 1/2 inches in diameter x 2 1/2 inches deep (approximately .25 cubic feet). They are also useful for separating undersize media from usable media. Made of high impact polymer with integral screen, one-piece molding eliminates problems with parts and media sticking at the joints of two-piece screens. Screens nest for storage.

1/4" Screen .....	23-205
3/8" Screen .....	23-207
1/2" Screen .....	23-209
3/4" Screen .....	23-211
1" Screen .....	23-213
Set of 5 (1 of each size) .....	23-217
Set of 5 with Container .....	23-222

**Compound Rinsing System**  
Save Labor And Produce Cleaner, Brighter Parts



◀ **Flow-Thru 20**  
Allows up to 5 hours of compound dispensing.



▶ **Flow-Thru 75**  
Allows up to 8 hours of compound dispensing.



◀ **Recirculating Pump 75**  
Requires less operator supervision.



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## Magnetic Finishers

### What Is A Centrifugal Magnetic Finisher?

The machine is a direct drive, fan cooled design. Its magnetic disk is made up of many powerful magnets that are precisely placed in a cast disk. The alternating polarity is constantly changing, thereby allowing the media to move freely in a liquid solution that constantly changes its makeup. This, combined with centrifugal force, allows for super quiet and fast time cycles.

**Magnetic Finishing** presents itself as the pinnacle of methods to efficiently burnish and polish small non-ferrous metals. With stainless steel pins as small as .010 in diameter and .250 in length, they are able to work in areas such as undercuts, recesses, slots, etc, where no previous method has been found suitable. Centrifugal magnetic finishing is quiet by comparison to many other forms of finishing. On soft non-ferrous metals, the finishing cycle can be as low as 30 minutes. This alone assures faster turnaround time on parts when compared to any other method. Centrifugal magnetic tumbling as an automated process addresses the most intricate and detailed parts imaginable in finishes where others fail. It should be noted that on large, smooth or flat surfaces the finish will appear frosted and a slight buffing or a dry finish is recommended.

### Raytech Flex-System

Only with Raytech's Flex-System can you utilize 3 types of medias. Raytech models 410, and 610 utilize three types of media. (Models 400, 900 and 1200 use wet burnishing pins only.)

Model	HP	Pin Capacity (Grams)	Ring Capacity	Forward/Reverse Function	Variable Speed	Bowl Diameter		Timer	Voltage Available		Shipping Weight
						In	mm		115V 60 Hz	230V 50 Hz	
CMF-400	1/32	100	8-12	No	No	4	100	Mechanical	Yes	Yes	17 lbs
CMF-410	1/32	100	8-12	Yes	Yes	4	100	Programmable	Yes	Yes	17 lbs
CMF-610	1/12	200	30	Yes	Yes	6	150	Programmable	Yes	Yes	25 lbs
CMF-900	1/3	400	100	Yes	Yes	9	230	Programmable	Yes	Yes	55 ls
CMF-1200	1/3	800	225	Yes	Yes	12	300	Programmable	No	Yes 50/60 Hz	85 lbs

### CMF-400

Raytech's smallest capacity magnetic finisher has a 4-inch (100mm) diameter chamber that finishes the equivalent of 8 to 10 rings. It comes complete with an ample amount of 5mm pins and compound (use one drop). Pin capacity is 100 grams. The CMF-400 has a fixed speed with mechanical timer and molded bowl and cover. Not for use with dry or wet bowls. 1/32 hp motor. Shipping weight 17 pounds; shipping volume 1.0 cubic feet.

- 115V, 60 Hz, 2.0 amps ..... 23-048
- 230V, 50 Hz, 1.0 amp ..... 24-139
- Spare Bowl..... 23-064
- Parts Holder..... 23-088



- Wet Burnishing Pins:**
- 1) Heat treat scale removal
  - 2) High luster burnishing
  - 3) Edge smoothing/light radiusing

- Abrasive (wet):**  
*CBW bowls required*
- 1) Surface refinement
  - 2) Edge radiusing
  - 3) Uniform surface quality

- Dry Processing:**  
*CBD bowls required*
- 1) Bright finish
  - 2) Bright, refined and uniform buff-like, high luster quality

Change and rinse as frequently as required to keep the process clean.



### CMF-410

Same size as the CMF-400, except this upgraded model has programmable functions similar to the CMF-610. Spare bowls as above. 1/32 hp motor. Shipping weight 17 pounds; shipping volume 1.0 cubic feet.

- 115V, 60 Hz, 2.0 amps ..... 23-049
  - 230V, 50 Hz, 1.0 amp ..... 24-140
  - CBD Dry Bowl ..... 23-084
  - CBW Wet Bowl ..... 23-085
- See CMF-400 for balance of parts

## Magnetic Finishers



### CMF-610

This model is designed to integrate programmable functions. Variable speed, forward/reverse. Timer functions are easily programmed to suit your cycle times. The CMF-610 has a 6-inch (150mm) molded bowl with cover with a pin capacity of 200 grams and parts equivalent to 20 to 30 rings. 5mm pins and compound included. 1/12 hp motor. Shipping weight 25 pounds; shipping volume 2.13 cubic feet.

- 115V, 60 Hz, 2.5 amps ..... 23-051
- 230V, 50 Hz, 1.25 amps ..... 24-142
- Spare Bowl ..... 23-057
- CBD Dry Bowl ..... 23-086
- CBW Wet Bowl ..... 23-087
- Parts Holder ..... 23-089



◀ **CMF 610 - Parts Holder**  
Designed to hold heavy ring shaped objects.



### CMF-900

This model is designed to meet the needs of the larger size manufacturers. The bowl is 9-inches (230mm) and has a pin capacity of 400 grams and parts equivalent of 100 rings. Pins are purchased separately. The CMF-900 is fully programmable and features variable speed and forward and reverse functions. 1/3 hp motor. Shipping weight 55 pounds; shipping volume 5.06 cubic feet.

- 115V, 60 Hz, 4.0 amps ..... 23-052
- 230V, 50 Hz, 2.0 amps ..... 24-143
- Spare Bowl ..... 23-068



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## Magnetic Finishers

### CMF-1200

Raytech's largest capacity magnetic finisher has a 12-inch (300mm) diameter bowl with a pin capacity of 800 grams. The CMF-1200 is fully programmable and features variable speed and forward/reverse functions. 1/3 hp motor. Shipping weight 85 pounds; shipping volume 9.18 cubic feet.

230V, 50/60 Hz, 2.0 amps . . . . . 24-145  
 Spare Bowl . . . . . 23-072



### Magnetic Separators

Easy parts separation at your fingertips for any Magnetic Finisher. This exclusive Raytech design eliminates the tedious separation of parts from media. Raytech Magnetic Separators can even be placed in water to separate parts. There is no need to drain water as separator will not rust.

Magnetic Separator 400/600 . . . . . 23-081  
 Mates with CMF-400/410 & CMF-600/610

Magnetic Separator 900/1200 . . . . . 23-083  
 Mates with CMF-900 & CMF-1200



### Replacement Part Numbers - Magnetic Finishers

DESCRIPTION	115 VOLT MACHINES					230 VOLT MACHINES				
	400	600	610	900	1200	400	600	610	900	1200
BOWL	23064	23057	23057	23068	23072	23064	23057	23057	23068	23072
BRUSHES (MOTOR)	08456	08463	08463	08487	08499	08456	08463	08463	08487	08499
COOLING FAN	08451	08467	08467	08510	08510	08451	08467	08467	08511	08511
FUSE	2 AMP	5 AMP	5 AMP	10 AMP	10 AMP	2 AMP	5 AMP	5 AMP	10 AMP	10 AMP
MAGNETIC CAST DISC	08516	08472	08472	08489	08500	08516	08472	08472	08489	08500
MAIN CONTROL MODULE	NA	NA	08474	08474	08474	NA	NA	08474	08474	08474
MOTOR	08452	08464	08464	08482	08494	08453	08465	08465	08483	08495
MOTOR CONTROL BOARD	NA	NA	08473	08473	08473	NA	NA	08485	08485	08485
ON/OFF SWITCH	08450	08462	08475	08475	08512	08450	08462	08475	08475	08512
PUSH BUTTON SWITCH	NA	NA	08476	08476	08513	NA	NA	08476	08476	08513
SPEED CONTROL	NA	NA	08502	08502	08502	NA	NA	08502	08502	08502
TIMER	08454	08468	NA	NA	NA	08454	08468	NA	NA	NA
TIMER KNOB	08455	08455	NA	NA	NA	08455	08469	NA	NA	NA
TOP PLATE	08501	08470	08470	08488	08496	08501	08470	08470	08488	08496

**Basic Guidelines For Successful Finishing**

1. Acceptable media to part ratio is approximately 70% media to 30% parts.
2. When running conventional medias that require a wet process, be sure to have the correct amount of water and compound. Too much water will hamper the vibratory action thus giving less than desired

3. The media and compound should just barely be wet with no standing water. It is recommended to use Raytech's compound rinsing system to ensure proper dispensing of water and compound.

Table 1. Media Processing Characteristics By Shape

Media Shape	Mobility	Surface Contact Area	Media Shape Retention	Surface Refinement	Process Time 1=long, 5= short	Total Versatility
V-Cut Cylinder	4	5	5	5	5	24
Cylinder	4	2	4	5	3	18
Cone	5	2	5	5	3	20
Polyhedron	4	5	4	5	5	23
Triangle	3	5	4	5	5	21
Pyramid	4	5	3	5	4	21
Porcelain Balls	5	1	5	5	5	21

Numerical Scoring: 1=low, 5=high. Efficiency is not rated by a high accumulated score. The total score is an indication of the media's all around versatility.

Table 2. Media Application Characteristics By Material.

Material	Cast	Fabricated	Light Stamping	Small Machining
Stainless Steel & Ferrous Metals	A, B, D	A, B, D	A, B, C, D	A, B, D
Non-Ferrous	A, B, C, D	B, C, D	B, C, D	A, B, C, D
Composites or Plastics	C	B, C	B, C	B, C

A=Ceramic, B=Ceramilite, C=Plastic, D=Porcelain Balls

**Ceramic**

Ceramic is the heaviest media and is also the fastest finisher. Bonded of the highest quality materials available, selected aluminum oxide abrasives produce constant quality. This durable, long-lasting media is extremely versatile for deburring machined, cast or fabricated parts. Density: 90 lbs/cu ft

- 5/16 x 7/8" Triangles – 20 pounds . . . . . 41-310
- 5/16 x 7/8" Triangles – 50 pounds . . . . . 41-313
- 3/8 x 7/8" Angle Cut Cylinders – 20 pounds . . 41-316
- 3/8 x 7/8" Angle Cut Cylinders – 50 pounds . . 41-319
- 3/8" Polyhedrons – 20 pounds . . . . . 41-328
- 3/8" Polyhedrons – 50 pounds . . . . . 41-331

**Ceramilite**

Clean-running light media that is between ceramic and plastic bonds. Metal removal is not quite as fast on bulk or dense materials as with ceramic, but measurably faster than plastic. Finish is finer than ceramic and brighter than the standard opaque finish produced by plastic. Density: 65 lbs/cu ft

- 5/8" V Cut Cylinders – 20 pounds . . . . . 41-340
- 5/8" V Cut Cylinders – 50 pounds . . . . . 41-343
- 5/16 x 3/4" Angle Cut Cylinders – 20 pounds . 41-346
- 5/16 x 3/4" Angle Cut Cylinders – 50 pounds . 41-349

See page 15 for media to bowl conversion

**Ceramic Media**



Triangles  
5/16" x 7/8"



Angle Cut Cylinders  
3/8" x 7/8"

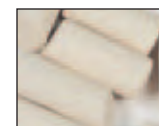


3/8"  
Polyhedrons

**Ceramilite Media**



5/8" V Cut  
Cylinders



Angle Cut Cylinders  
5/16" x 3/4"

**Plastic Media**



1/4" Brown  
Pyramids



1/4" White  
Pyramids



1/4" Green  
Pyramids



1/2" V Cut  
Cylinders



5/8" XF Cones



## Finishing Media

### Plastic

Formulated for very fine surface conditioning, low RMS finishes are commonly achieved. Plastic medias are widely used in the precision metal industries. Also due to the fine surface finishes achieved, parts are prepared for pre-plate, pre-anodize, or decorative polishing. Brown, V-Cut, Cone (medium cut), Green (light cut), and White (very fine cut).

Density: 55 lbs/cu ft

1/4" Brown Pyramids – 5 pounds	41-141
1/4" Brown Pyramids – 50 pounds	41-145
1/4" White Pyramids – 5 pounds	41-131
1/4" White Pyramids – 50 pounds	41-135
1/4" Green Pyramids – 5 pounds	41-119
1/4" Green Pyramids – 50 pounds	41-125
1/2" V Cut Cylinders – 20 pounds	41-322
1/2" V Cut Cylinders – 50 pounds	41-325
9/16" XF Cones – 20 pounds	41-334
9/16" XF Cones – 50 pounds	41-337

### Porcelain Balls

Porcelain balls are utilized to achieve bright finishes without the use of steel media. Because of its shape, it imparts a single point of contact resulting in a very fine finish to almost any area it can reach. Porcelain balls will not leave impingement marks that steel media produces on some softer metals and/or flat surfaces. Their lighter weight lessens the distortion potential for lighter work and wire forms. Very popular for delicate parts, fine edge blanking and precious metal burnishing. Use with Raytech's Compound D. Mixing the sizes is recommended for good vibratory action. Please note that a break-in period of 4 to 6 hours is required.

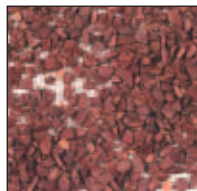


Density: 125 lbs/cu ft

1mm – 5 pounds	41-210
1mm – 15 pounds	41-211
2mm – 5 pounds	41-214
2mm – 15 pounds	41-215
3mm – 5 pounds	41-218
3mm – 15 pounds	41-219
4mm – 5 pounds	41-222
4mm – 15 pounds	41-223
6mm – 5 pounds	41-226
6mm – 15 pounds	41-227

### Dri-Shine I

Nutshell based media treated with Red Rouge. When allowed to run in excess of 5 hours in a vibratory tumbler, this irregular particle size media provides excellent coloring characteristics.



Density: 35 lbs/cu ft

15 pounds	41-154
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### Dri-Shine III

Corn cob based media treated with Raytech's proprietary polishing compound and is clean to use as rouge stain is eliminated. Performs equal to or better than Dri-Shine I. Density: 30 lbs/cu ft



15 pounds	41-266
30 pounds	41-277

### Ray-Cubes

Untreated 5mm hardwood cubes for use in rotary tumblers or vibratory machines.



Density: 40 lbs/cu ft

15 pounds	41-362
30 pounds	41-363

### Raytech Polish Paste

Use Polish Paste for final polish on plastics. Mix 1 teaspoon per 5 pounds of Ray-Cubes.

1 quart	41-365
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### Raytech Grinding Paste

Use with Ray-Cubes for smoothing, grinding and radius-ing on plastic parts prior to final polish. Mix 1 teaspoon per 5 pounds of Ray-Cubes.

1 quart	41-368
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### Turbo® Brite™

Use this additive with all treated or untreated Dri-Shine products and hardwoods to enhance polishing of metal. Also use with Ray-Cubes for final polish on metals. Works best on nonferrous metals. Directions on package.

5 ounces	7631358
20 ounces	7631361

### Tumble Soap

Recommended for fine finishing and burnishing precious metals, brass, bronze and similar materials with plastic, ceramic or metal media. Use approximately 1 teaspoon per pint of water.

1 pound	41-011
50 pounds	41-013

### Compound B

A liquid flo-thru concentrate, uniquely formulated for all metals and plastics. As a non-foaming compound, soils that can load the media and darken parts are quickly flushed from the processing channel, resulting in faster cycle times and cleaner parts. Mix 2% dilution for Flo-Thru.

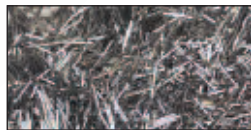
1 quart	41-006
1 gallon	41-008

### Compound D

Uniquely formulated liquid burnishing compound for use with steel shot. Also can be used as storage compound due to rust inhibitors in the formulation. Dilute 2% to water.

- 1 quart ..... 41-003
- 1 gallon ..... 41-004

### Stainless Steel Magnetic Pins (For CMF machines only)



- .3mm Turbo Pins – 250 grams ..... 41-372
- .3mm Turbo Pins – 1 kilogram ..... 41-374
- .5mm Turbo Pins – 250 grams ..... 41-376
- .5mm Turbo Pins – 1 kilogram ..... 41-378

**Important!** Under no circumstances should the pins be stored in the bowl on the machine. Doing so will cause the pins to magnetize, resulting in over-magnetizing of pins, thus lessening their effectiveness.

Through use, discoloration (darkening) of the pins is normal. They can be cleaned using a tri-sodium phosphate solution. TSP is available at your hardware store.

**\*\*\*NOTE:** As stated in our CMF Dry Bowl instructions, use only Dri-Shine VII or Dri-Buffer. Use of any other medias besides Dri-Shine VII or Dri-Buffer will void the warranty.

### Dri-Shine VII

A nut based media that can be used as a final polish in most applications, Dri-Shine VII was designed specifically for use with our CMF-410 and CMF-610 dry bowls. Fill to the media line on the bowl. Cycle times will run from 20 to 45 minutes depending on your application. Dri-Shine VII can be used for approximately 4 to 6 cycles and then reactivated with our new Dri-Shine VII Reactivator (below).



**NOTE:** It is very important that you alternate the media between cycles. In some cases, the media can overheat. To prevent condensation, change the media between cycles.

- 5 pounds ..... 41-290

## Finishing Media

### Dri-Shine VII Reactivator

Reactivate every 4 to 6 cycles to keep the Dri-Shine VII media active. Reactivator will work into the Dri-Shine VII in only a few minutes. Use 1/2 teaspoon of Reactivator in the CMF 410 Dry Bowl, and 1 teaspoon in the CMF 610 Dry Bowl.



- 1 pound ..... 41-292

### Dri-Buffer

A corn based media that will provide a mirror finish, Dri-Buffer can be used in our CMF Dry Bowls with cycles of approximately 30 to 40 minutes. As with the Dri-Shine VII, alternate the media between cycles to prevent overheating of the media.



**NOTE:** When using Dri-Buffer in our CMF-410 or CMF-610 finishers, run the machine at half speed.

- 4 pounds ..... 41-291

### How much media do I use?

To determine media capacities, multiply the media density (found with each individual media above) by the cubic foot capacity of the tumbler (found in each individual tumbler listing). Examples are listed below. Note this is total media capacity only and actual media amounts will vary in direct proportion to the amount of parts being tumbled. (See Basic Guidelines For Successful Finishing on page 13.)

- **Ceramic** (90 lbs/cu ft) in a TV-10 (.10 cu ft).  
90 x .10 = 9 pounds of media.
- **Porcelain Balls** (125 lbs/cu ft) in an AV-40 (.35 cu ft).  
125 x .35 = 43.75 pounds of media.
- **Stainless Steel Balls** (300 lbs/cu ft) in an AV-25SS (.22 cu ft).  
300 x .22 = 66 pounds of media.
- **Ceramalite** (65 lbs/cu ft) in a TV-5 (.05 cu ft).  
65 x .05 = 3.25 pounds of media.
- **Plastic** (55 lbs/cu ft) in an AV-75 (.75 cu ft).  
55 x .75 = 41.25 pounds of media.
- **Plastic** (55 lbs/cu ft) in an AV-18 (.18 cu ft).  
55 x .18 = 9.9 lbs.
- **Dri-Shine III** (30 lbs/cu ft) in a Dri-Polisher (.12 cu ft).  
30 x .12 = 3.6 pounds of media.

**CAUTION:** The machines and tools described in this catalog are potentially dangerous if improperly used. Please be sure to operate them only at recommended speeds with proper guards installed and while wearing adequate eye protection.