



AIRWAY BUFF SAFETY GUIDE

- Be sure arbor hole is correct for shaft being used.
- Be sure that end flanges are sturdy and can exert adequate pressure to clamp the buffs securely.
- Be sure that end flanges are sufficient in diameter to extend to the outer tips of the metal clinch ring.
- **DO NOT USE AN END FLANGE SMALLER THAN THE CLINCH RING!**
- Be sure thread on arbor shaft is in good condition, that nut can be screwed on freely, and that threaded portion of shaft is sufficient to allow firm clamping of buff with end flanges.
- Tighten shaft nut securely with an adequate wrench. Be sure nut remains tight. Re-tighten occasionally if necessary.
- If spacers are used between buff sections:
 - A) Outside diameter of spacer must be large enough to cover outside tips of clinch ring.
 - B) If spacer supports buff center, be sure that support area is the correct diameter and gives support to the entire inside diameter of the clinch ring.
 - C) Be sure that flange areas of spacer will securely clamp the buff and are not designed so that support area or interlock portions prevent flange pressure on buff.
- **BUFF MUST NOT SPIN ON SPACER OR HUB. THIS CAN CAUSE CLINCH RING TO BREAK.**
- Observe maximum recommended R.P.M. DO NOT use on machines that exceed these limits.
- Be sure buffing wheel is adequately guarded. See machine manufacturer's recommendations.
- Proper holding devices should be used for small and irregular shaped parts.
- NEVER reach (or permit clothing or hair to get) between rotating buff and machine or work piece fixture.
- DO NOT leave running machine unattended.

- Observe all safety recommendations of machine manufacturer, compound supplier, and your own safety Engineering Dept, including precautions on clothing, hair, etc.
- If excessive vibration occurs, shut machine down immediately.

***** NOTICE *****

Bufs should never be run at speeds exceeding those shown on the chart below.
 (Save wheel speeds when properly clamped with recommended end flanges.)

MAXIMUM SPEEDS IN REVOLUTIONS PER MINUTE

Buff Diameter	3" center	5" center	7" center	9" center
6" – 8"	3600 rpm			
9" – 10"	3450 rpm			
11" – 12"	3000 rpm	3450 rpm		
13" – 15"	*	2700 rpm	3000 rpm	
16" – 18"	*	1800 rpm	2400 rpm	2400 rpm
19" – 20"		1200 rpm	2000 rpm	2000 rpm
21" – 24"		*	1500 rpm	1800 rpm

(* - Special construction for 'slow RPM' machines only.)

Diagram #1 –

