



**FINISHING COMPOUNDS**

**APPLICATION & PRODUCT GUIDE**



## FINISHING APPLICATION GUIDE

- "Cutting" Type Compounds should be used on heavy duty, aggressive cloth buffing wheels to generate rapid stock removal. Since a film normally results from this operation, it should be followed by a "color" operation using a soft cloth buffing wheel combined with the appropriate "color" compound to achieve a clean, lustrous surface.
- "Cut and Color" procedures are compromises intended to generate acceptable finishes in one operation where dictated by economy. Types of buffing wheels may vary for these uses.
- Buffing wheels should be reserved for each type of compound. Different types of compounds should not be applied to the same wheel.

TYPE OF COMPOUND	USUAL USE
<b>COLORING</b>	To create high lustre on metals and plastics.
<b>EMERY PASTE</b>	Use on rolls, set-up wheels, wire wheels and tampico wheels
<b>GREASELESS</b>	To polish, deburr or create satin finish
<b>GREASE STICK</b>	Lubricant for polishing wheels and abrasive belts
<b>STEEL CUT</b>	The name implies the use, use to cut steel
<b>TRIPOLI</b>	To cut and color non-ferrous metals, plastics, and wood
<b>WHITE POLISH</b>	To cut and color aluminum, brass, bronze, copper, celluloid die castings, hard rubber, plastics and wood

## BUFFING COMPOUND APPLICATION GUIDE

CUT	CUT & COLOR	COLOR
<b>ALUMINUM</b>		
<b>TRIPOLI COMPOUNDS</b> 75 Med. hard, Med. dry 2010 Med. hard, Med. dry	<b>TRIPOLI COMPOUNDS</b> 1571 Hard, very dry 100% Saponifiable	<b>COLORING COMPOUNDS</b> 862 Soft, dry 1062 Med. hard, med. dry 1979 Very hard, dry 2222 Med. hard, dry, pink, extra bright lustre 2382 Hard, dry, yellow
<b>GREASELESS COMPOUNDS</b> Use when more cut is required	<b>WHITE POLISH COMPOUNDS</b> 16 Med. hard, dry 621 Hard, dry	
<b>BRASS AND BRONZE</b>		
<b>TRIPOLI COMPOUNDS</b> 75 Med. hard, med. dry 2010 Med. hard, med. dry 2364 Hard, med. dry	<b>TRIPOLI COMPOUNDS</b> 1571 Hard, very dry 100% Saponifiable	<b>COLORING COMPOUNDS</b> 1062 Med. hard, med. dry 1979 Very hard, dry 2222 Med. hard, dry, pink, extra bright lustre
	<b>WHITE POLISH COMPOUNDS</b> 16 Med. hard, dry 621 Hard, dry	
<b>CHROMIUM PLATE</b>		
<b>STEEL CUTTING COMPOUNDS</b>	<b>COLORING COMPOUNDS</b> 2318WD Med. hard, med. dry	<b>COLORING COMPOUNDS</b> 1062 Med. hard, med. dry 1965 Hard, med. dry
<b>COPPER</b>		
<b>TRIPOLI COMPOUNDS</b> 75 Med. hard, Med. dry	<b>TRIPOLI COMPOUNDS</b> 1571 Hard, very dry 100% Saponifiable	<b>COLORING COMPOUNDS</b> 862 Soft, dry 1062 Med. hard, med. dry 1979 Very hard, dry 2222 Med. hard, dry, pink, extra bright lustre
	<b>WHITE POLISH COMPOUNDS</b> 16 Med. hard, dry 621 Hard, dry	
<b>LEAD PEWTER, WHITE METAL</b>		
<b>TRIPOLI COMPOUNDS</b> 1571 Hard, very dry 2010 Soft, med. dry 2318WD Med hard, med. dry	<b>WHITE POLISH COMPOUNDS</b> 621 Hard, dry	<b>COLORING COMPOUNDS</b> 862 Soft, dry <b>ROUGE</b> 2113WD Med. hard, dry, water dispersible

NUMBER	GRIT SIZES	ABRASIVE TYPE	USE
<b>GREASELESS COMPOUNDS (BURRITE)</b>			
9	150	Aluminum Oxide	Polishing, Deburring
19	180	Aluminum Oxide	Polishing, Deburring, Satin
26	240	Aluminum Oxide	Polishing, Deburring, Satin
62	Very Fine	Aluminum Oxide	Extra Fine Finishes

NUMBER	CHARACTERISTIC	USE
<b>TALLOW OR GREASE STICK</b>		
1	White-Firm	Abrasive belts, fine grit polishing wheels
99	Yellow- Soft, Sticky	Grinding wheels, coarse grit polishing wheels
1892	White-Hard	Abrasive belts, fine grit polishing wheels
1935	White-Firm	Abrasive belts, fine grit polishing wheels

CUT	CUT & COLOR	COLOR
<b>PLASTICS AND HARD RUBBER</b>		
<b>TRIPOLI COMPOUNDS</b> 1010 Med. hard, med. dry 112 Med. hard, med. dry	<b>WHITE POLISH COMPOUNDS</b> 16 Med. hard, dry 621 Hard, dry	<b>COLORING COMPOUNDS</b> 71 Med. hard, med. dry 862 Soft, dry 2045 Soft, med. hard (Anti-static)
	<b>MISC. COMPOUNDS</b> 2040 Med. hard, greasy	
<b>NICKEL SILVER, SILVER &amp; GOLD</b>		
<b>TRIPOLI COMPOUNDS</b> 1494 Hard, med. dry 1571 Hard, very dry Both 100% Saponifiable	<b>CROCUS COMPOUND</b> 7 Hard, dry	<b>ROUGE</b> 2113WD Med. hard, dry, water dispersible
	<b>COLORING COMPOUNDS</b> 1062 Med. hard, med. dry	<b>COLORING COMPOUNDS</b> 2222 Med. hard, dry, pink, extra bright lustre
<b>STEEL AND STAINLESS STEEL</b>		
<b>STEEL CUTTING COMPOUNDS</b> 271 Med. hard, med. dry Med. 2330 Hard, med. dry 7218	<b>COLORING COMPOUNDS</b> 1062 Med. hard, med. dry 2318WD Med hard, med dry	<b>COLORING COMPOUNDS</b> 1979 Very hard, dry 2181 Green hard, dry 2222 Med. hard, dry
<b>WOOD</b>		
<b>TRIPOLI COMPOUNDS</b> 1571 Hard, very dry 112 Med. hard, med. dry	<b>WHITE POLISH COMPOUNDS</b> 16 Med. hard, dry	<b>COLORING COMPOUNDS</b> 1954 Med hard, med. dry 1979 Very hard, dry

NOTE: Successful performance of these recommended compounds will be adversely affected if basic procedures are not observed.



Contact your local MOCO distributor for help selecting the right MOCO Buffing Compound for your application.





**BUFFING COMPOUNDS**



MFR #2113WD



MFR #75



MFR #1571



MFR #621



MFR #862



MFR #2222



MFR #271



MFR #2318WD



MFR #2181



MFR #1062



MFR #1979

DESCRIPTION	COLOR	APPLICATION	MFR #
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**FOR FINISHING BRASS & ALUMINUM**

ORANGE TRIPOLI		<ul style="list-style-type: none"> <li>• Medium hard/medium dry</li> <li>• Most aggressive cut</li> </ul>	75
BROWN TRIPOLI		<ul style="list-style-type: none"> <li>• Hard/very dry</li> <li>• Medium cut &amp; color</li> <li>• Water dispersible for easy cleaning</li> </ul>	1571
BEIGE TRIPOLI		<ul style="list-style-type: none"> <li>• Hard/dry</li> <li>• Finer cut &amp; color</li> </ul>	621
WHITE		<ul style="list-style-type: none"> <li>• Soft/dry</li> <li>• Fine finish/bright color</li> </ul>	862
LIGHT PINK		<ul style="list-style-type: none"> <li>• Fine/medium hard/dry</li> <li>• Extra bright lustre</li> </ul>	2222
RED ROUGE		<ul style="list-style-type: none"> <li>• Medium hard/dry</li> <li>• Water dispersible red rouge for easy cleaning</li> <li>• Will give high lustre</li> </ul>	2113WD

**FOR FINISHING CHROME, STEEL & STAINLESS**

BLACK / DARK GREY		<ul style="list-style-type: none"> <li>• Medium hard/medium dry</li> <li>• Most aggressive cut for steel &amp; stainless steel</li> </ul>	271
GREY		<ul style="list-style-type: none"> <li>• Medium hard/medium dry</li> <li>• Excellent cut &amp; color for chrome, steel &amp; stainless</li> <li>• Water dispersible for easy cleaning</li> </ul>	2318WD
WHITE		<ul style="list-style-type: none"> <li>• Medium hard/medium dry</li> <li>• Versatile cut &amp; color compound</li> </ul>	1062
GREEN		<ul style="list-style-type: none"> <li>• Hard/dry</li> <li>• Will give high lustre finish on chromium, carbon, stainless, and nickel steels</li> </ul>	2181
WHITE		<ul style="list-style-type: none"> <li>• Very hard/dry</li> <li>• Fine color compound</li> </ul>	1979
LIGHT PINK		<ul style="list-style-type: none"> <li>• Fine/medium, hard/dry</li> <li>• Extra bright lustre</li> </ul>	2222



# FINISHING COMPOUNDS



## LAPPING COMPOUNDS



MFR #GN-5



MFR #S-220

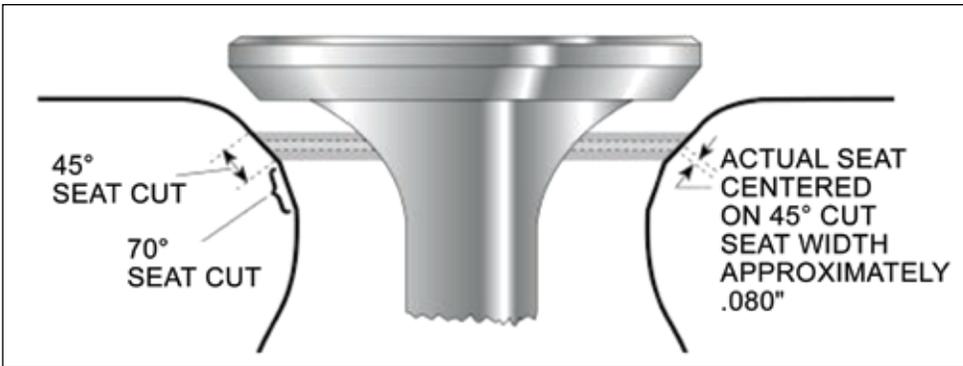


MFR #WA-5

APPLICATION	MESH SIZE	MICRON SIZE	MFR #
<b>GN- GARNET ABRASIVE FOR NON-FERROUS METALS</b>			
<ul style="list-style-type: none"> <li>• Medium hard</li> <li>• Very friable, non-charging abrasive</li> <li>• Ideal for lapping brass, bronze &amp; silverplate</li> </ul>	500	25	GN-5
	1600	10	GN-16
	4000	4	GN-40
<b>S - SILICON CARBIDE ABRASIVE FOR FERROUS METALS</b>			
<ul style="list-style-type: none"> <li>• Hard</li> <li>• Sharp, brittle abrasive</li> <li>• Very effective for lapping abrasive types of metal, such as cast iron as well as stainless</li> </ul>	120	—	S-120
	150	—	S-150
	180	—	S-180
	220	—	S-220
	280	42	S-2
	320	36	S-3
	400	26	S-4
	500	21	S-5
	600	16	S-6
	800	12	S-8
1000	10	S-10	
1600	9	S-16	
2600	7.5	S-26	
<b>WA - WHITE, CRYSTALLINE ALUMINUM OXIDE ABRASIVE FOR HARDENED STEELS &amp; CHROMIUM</b>			
<ul style="list-style-type: none"> <li>• Hard</li> <li>• Friable abrasive</li> <li>• Very effective for lapping hardened steels and chromium plates</li> </ul>	500	22	WA-5
	600	16	WA-6
	900	12	WA-9



## VGC II VALVE LAPPING COMPOUND



- TIGHTER TOLERANCES
- FINER finish
- PRECISION graded
- Laps FASTER
- EASY CLEANUP
- BEST POSSIBLE SEAL

- For the hard to lap metals of high performance engines.
- Specially formulated: tacky at first to stick to valve and seat, but thins out during lapping to carry abrasive across surfaces.

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