



Standard and Heavy-Duty Tumbler Systems

Part #43204 and 13384

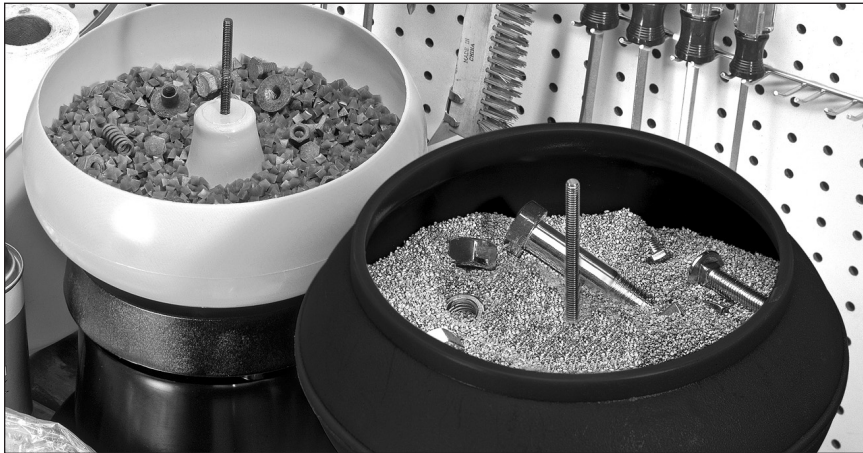


Instructions

Description

Your new Vibratory Tumbler(s) will be useful for a wide variety of finishing operations. The following are a few samples:

- Removing rust from pieces of hardware without losing details or rounded edges.
- Removing burrs from hardware and stampings.
- Polishing difficult to reach surfaces to a high shine.
- Rapid parts degreasing using Eastwood Metal Wash (10120).



IMPORTANT HEALTH AND SAFETY CAUTIONS

Please read all information and follow directions carefully.

- **DO NOT** cover the machine with anything (such as a blanket or a box) to dampen the noise as this could cause overheating and become a potential fire hazard.
- **DO NOT** overfill/overload bowl with media and parts. Bowls should not be filled more than half way. **Overfilling will damage motor and void the warranty.**
- **DO NOT** use any solvents in the tumbler bowls.
- Always connect the machine to a power source that has been properly grounded to prevent any possible electrical shock.
- Your tumbler is designed not to “walk” during normal operation. We recommend that the machine be placed on a solid floor away from moisture and combustible materials. If the machine is used on a bench, it should be blocked in to prevent any accidents.
- Never attempt to operate or experiment with other than recommended media and compounds. **These machines are not designed for use with ceramic media.**

Inside with your **Standard Vibratory Tumbler (43204)**, for parts up to **4” long**, you will find the following:

- #43204F Tumbler Base with 6’ 110 VAC Power Cord
- #43204A One 2-1/2 lb. bag of Green Pyramid Rust Cutting Media
- #43204B One 2 lb. bag of Corncob DryShine® Media Mix
- #43204C One 8” Wet/Dry Tumbler Bowl and Lid Assembly
- #43204D One 10” Dry Tumbler Bowl and Lid Assembly
- #43204E Rubberized Bowl and Lid Retaining Nut
- #43204Q Instructions

Inside with your **Heavy-Duty Vibratory Tumbler (13384)**, for parts up to **6” long**, you will find the following:

- #13384 Heavy-Duty Wet/Dry Media Tumbler Base with 6’ 110 VAC Power Cord
- #13386 Two 12” Wet/Dry Bowls and Lids
- #13184C One 8 lb. bag of Green Pyramid Rust Cutting Media
- #13184D One 5 lb. bag of DryShine® Media
- #43204Q Instructions

General Instructions

For The Standard Vibratory Tumbler System (43204)

Your Standard Eastwood Vibratory Tumbler has been supplied with 2 bowl and lid assemblies. The smaller bowl is used for Wet/Dry polishing operations with the Green Rust Cutting Media (#43204A) and DryShine® Media (#43204B). The larger 10” bowl is used for the final dry polishing operation with the DryShine® media (#43204B).

To install the bowl, place it over the threaded stud in the base. Place the appropriate lid on top of the bowl and hand tighten the rubberized nut provided (wide base down) until rubber body slightly bulges. It is essential that this nut be tightened properly so that the bowl will not vibrate loose.

The working capacity of the Standard Eastwood Vibratory Tumbler with the 8” bowl is approximately .05 cubic feet or three pints, capacity with the 10” bowl is approximately double. **The total weight capacity is about 3 pounds for the 8” bowl, 6 pounds for the 10”.** These capacities include both media and the work pieces.

NOTE: Overloading the bowls will damage motor and void warranty.

Your tumbler features overload protection. This will shut off the tumbler should an unsafe operating condition arise, and after a cool-down cycle, restart. If this happens, remove some parts from the bowl.

For The Heavy-Duty Vibratory Tumbler System (13384)

Your Heavy-Duty Eastwood Vibratory Tumbler has been supplied with 2 general-purpose 12" bowls used for wet or dry polishing operations with the Green Rust Cutting Media (#43204A) and DryShine® Media (#43204B).

To install the bowl, place it over the threaded stud in the base, place rubber faced washer over stud (rubber face down) and gently tighten nut. Install the lid and tighten the large wing nut properly so that the lid will not vibrate loose.

The total working capacity of the Heavy-Duty Vibratory Tumbler is approximately .18 cubic feet, 10 pints, or 11 pounds. The capacity includes both the media and the work pieces (maximum 6" long).

NOTE: Overloading the bowls will damage motor and void warranty.

Your tumbler features overload protection. This will shut off the tumbler should an unsafe operating condition arise, and after a cool-down cycle, restart. If this happens, remove some parts from the bowl. The unit starts when you plug it into a 110VAC outlet and turns off when you pull the plug.

Determine A Starting Point

Inspect condition of parts to be cleaned. Parts should be free of paint before placing in the tumbler. Paint can be removed by soaking parts in a metal container of Eastwood DEKOTE (#10411) or XXX Finish Stripper (#21657ZP). **Do not under any circumstances put paint remover or solvents in the Tumbler bowl.**

Parts can be degreased by soaking in a solution of Metal Wash (#10120) (See package for directions). Or for faster degreasing add about 1-2 teaspoons of Metal Wash concentrate (#10120) to the Green Rust Cutting Media (#43204A) and add enough water to wet the parts. For the Standard Vibratory Tumbler, use the small wet tumbler bowl to degrease parts. Rinse cleaned parts in water and allow to dry. For best results sort parts to be tumbled by approximate weight and condition.

Do not overload tumblers.

Place Tumbler on a clean dust and grit free surface. The Tumbler rubber feet are designed to prevent the Tumbler from "walking" during normal operation. We recommend that the machine be placed on a solid floor, away from any combustible materials. If machine is to be operated on a bench, it should be blocked in to prevent any accidents. Always connect machine to a properly grounded outlet to prevent electrical shock.

NOTE: Plating may be eroded away by Green Rust Cutting Media. To shine plated parts without removing plating use DryShine® Media. Refer to Producing a High Shine section and check parts frequently to assure desired results.

Removing Rust

NOTE: For the Standard Vibratory Tumbler (43204), rusty parts should be placed in the 8" Small Bowl (#43204C). Add entire 2 1/2 lbs. of Green Rust Cutting Media (#43204A) to the parts to be cleaned. Note: For the Heavy-Duty Vibratory Tumbler, add entire 8 lbs. of Green Rust Cutting Media to parts to be cleaned. The ideal ratio for best tumbler action is 70% media to 30% parts. Add enough water to wet the parts and media, but not so much that standing water is visible. If degreasing is necessary add a small amount (about 1 or 2 teaspoons of Metal Wash (#10120) to the bowl. Excessive water will dampen the vibratory action while too little water will impede proper action.

Place lid over central mounting stud. Thread Rubberized Retaining Nut (larger diameter end down) onto the stud until the body of the nut bulges slightly. As before, only hand tightening is necessary.

NOTE: For the Heavy-Duty Vibratory Tumbler (13384), place the lid over the central mounting stud, install the rubberized flat washer and hand tighten wing nut properly so that the lid and bowl will not vibrate loose.

Plug Vibratory Tumbler into properly grounded 110 VAC outlet. Tumbler will start vibrating as soon as it is plugged in. If tumbler doesn't start, press switch on tumbler platform. Typical processing times range from 3 to 7 hours. It is recommended to check periodically to see if the desired finish has been achieved. Actual time to achieve this appearance may vary from 1 hour to several hours depending on condition of media and degree of rust on parts to be cleaned.

For many parts no further surface conditioning is needed. If this is the case, make sure Tumbler is unplugged. Remove lid and tumbler bowl assembly. Tip tumbler bowl, with lid slightly ajar, to drain out wastewater in appropriate drain. In most cases water can be poured down any convenient drain.

Once water is drained, pour entire contents of tumbler bowl onto a paper towel or cloth. Use a magnet to remove steel parts from media or manually sort through to pick out cleaned parts. Dry parts with a hair dryer or heat lamp. Allow media to air dry and return to container of unused media for future use.

NOTE: The Green Rust Cutting Media has abrasive throughout its cross section. The smaller worn particles of media will help clean tighter radius areas.

Put hardware back into service or paint/plate as desired to improve corrosion resistance.

Producing A High Shine

To impart a highly reflective shine to the tumbled parts proceed next to the DryShine® Media (#43204B). For the Standard Vibratory Tumbler, this media is used in either the larger 10" Tumbler Bowl (#43204D) or the 8" Small Tumbler Bowl (#43204C). Note the large tumbler bowl is attached in the same manner as the smaller bowl. Place parts to be polished in the larger tumbler bowl and add entire 2 lbs. of Dry Shine Media (#43204B) to the parts. There is no need to add any water or polishes as this media is already treated with a polish.

DryShine® Media (#43204B) should be tumbled with the parts for at least 6 hours. Tumbling for longer periods will yield a higher shine. Remember to use a ratio of 70% Media to 30% Parts. This dry media will not remove an appreciable amount of material, however it will remove dirt, and stain residues. Typical running time for this media is 6 to 24 hours.

Protect the shine with Eastwood Diamond Clear for Bare Metal (#10200Z Aerosol 11 oz.) or the Eastwood Tin-Zinc Electroplating System (#10049Z). For the longest lasting finish protection use the Eastwood HotCoat™ Powder Coating System (#10198).

Maintenance

The following maintenance should be performed every 100 hours of use:

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

To optimize media use:

1. Allow wet media to thoroughly dry before returning to unused media container
2. Continue to use media until it no longer cuts in a reasonable amount of time.
3. Continue to use all medias until they become a useless dust as the abrasive/polishing treatments permeate the entire cross section.

Troubleshooting

Problem	Possible Cause: Corrective Action
Parts Too Dull	<ul style="list-style-type: none">• Not in tumbler long enough: Allow more time.• Skipped steps: Follow all steps for quickest results.
Bowls Wearing Too Quickly	<ul style="list-style-type: none">• Using wrong media: For Standard Vibratory Tumblers, use wet media in 8" wet or dry bowl.• Parts too big for tumbler: Works best on parts smaller than 3".• Too many parts: Ideal ratio is 30% parts, 70% media.• Too much or too little water when using Green Rust Cutting Media: Use just enough water to wet media.
Heavy Deposits In Recesses	<ul style="list-style-type: none">• Parts not properly degreased before using Green Rust Cutting media: Degrease or add 1 teaspoon of Metal Wash to bowl.• Not enough water added to Green Rust Cutting media: Add more water or rinse periodically during processing.

Media and Related Products

- #43204A 2-1/2 lb. Bag of Green Pyramid Rust Cutting Media
- #13184C 8 lb. Bag of Green Pyramid Rust Cutting Media
- #43204B 2 lb. Bag of DryShine® Mix
- #13184D 5 lb. Bag of DryShine® Mix
- #13450 15 lb. Bag of DryShine® Mix
- #19794 5 lb. Bag Hardwood Cubes, 5mm
- #19795 15 lb. Bag Hardwood Cubes, 5mm

- #21913 2-1/2 lb. Brown Pyramid Media, 1/4"
- #13452 8 lb. Brown Pyramid Media, 1/4"
- #13451 15 lb. Brown Pyramid Media, 1/4"

- #19797 Hardwood Chip Tumbler Paste, 1 qt.
- #19796 Tumbler Polish Paste, 1 qt.
- #13454 Compound B Media Rinse Agent, 1 qt.
- #21912 Compound D Liquid Burnishing Compound, 1 qt.

- #13192 Tumbler Media Sifter
To filter media.
- #43032 40 Piece Master Rethreading Set
To chase all hardware and restore and clean threads,.
- #10200Z Diamond Clear, Aerosol 11 oz.
To protect highly polished parts from tarnishing.
- #100049Z Tin Zinc Plating System
To produce a protective cad-like coating.
- #10238Z Metal Blackening System with Diamond Clear
To produce a non-dimensional black oxide coating.
- #10198 HotCoat Powder Coating System
Produces the most durable chip resistant finish available.

If you have any questions about the use of this product, please contact
The Eastwood Technical Assistance Service Department:
1-866-759-2131 email: techelp@eastwood.com



The Eastwood Company

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