

# menzerna



ALUMINIUM  
PRODUCT RANGE

PERFECTION IN POLISHING

## RECOMMENDATIONS FOR POLISHING ALUMINIUM

- Use buffing speeds of 50-60 m/s
- Avoid pronounced surface heating >> otherwise the aluminium lattice structure changes >> negative impact on the result after anodising.
  - » Use **Menzerna high-performance polishing compounds**:
    - Optimised bond
    - Better adhesion to the buffing wheel
    - Effective heat dissipation
- For hard alloys: use more greasy compounds
- For soft alloys: use drier compounds
- Avoid oversized particles in polishing products >> polishing defects only visible after anodising >> high scrap rates
  - » Use **individually developed Menzerna Top-Cut polishing compounds with an adjusted grain size**
- Sanding must not be too coarse >> material preservation >> shorter polishing times

### NOTICE:

Aluminium dust is hazardous to health. An effective extraction system is essential. Aluminium polishing waste is susceptible to spontaneous combustion.



**Menzerna emulsions** are developed for industrial use. In centrally supplied production lines of bulk consumers, liquid pastes ensure maximum process security, speed and quality.



**Menzerna solid compounds** are suitable for manual workstations as well as fully automated polishing systems. In large and small series, they set consistent surface quality standards with a wide variety of work piece geometries.

### MENZERNA FOR GLOSS:


- |                          |                        |
|--------------------------|------------------------|
| + Automobile body trim   | + Furniture components |
| + Cookware               | + Lamps                |
| + Door and window frames | + Picture frames       |
| + Door handles           | + Plates/plain sheets  |
| + Engineering parts      | + Rims                 |




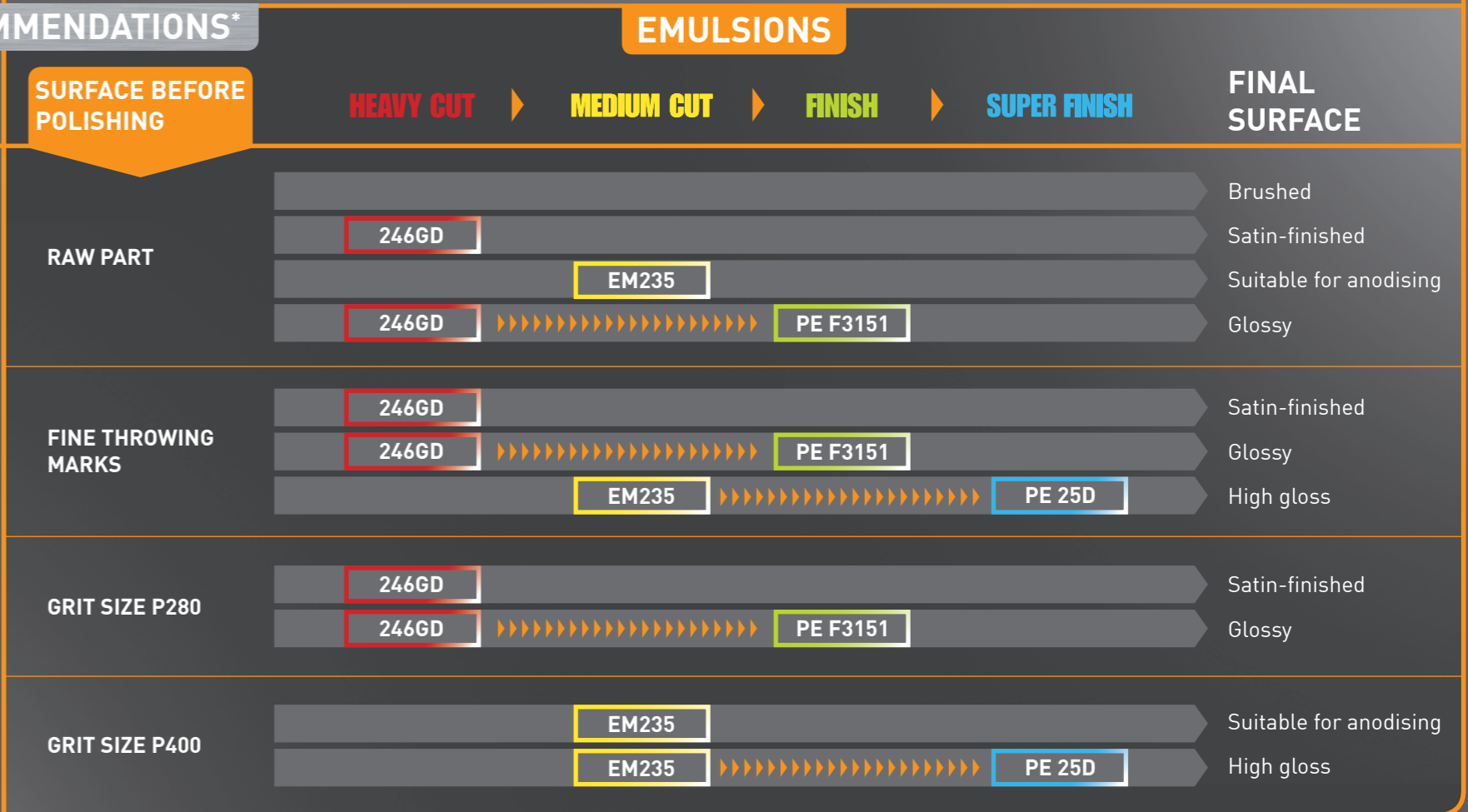
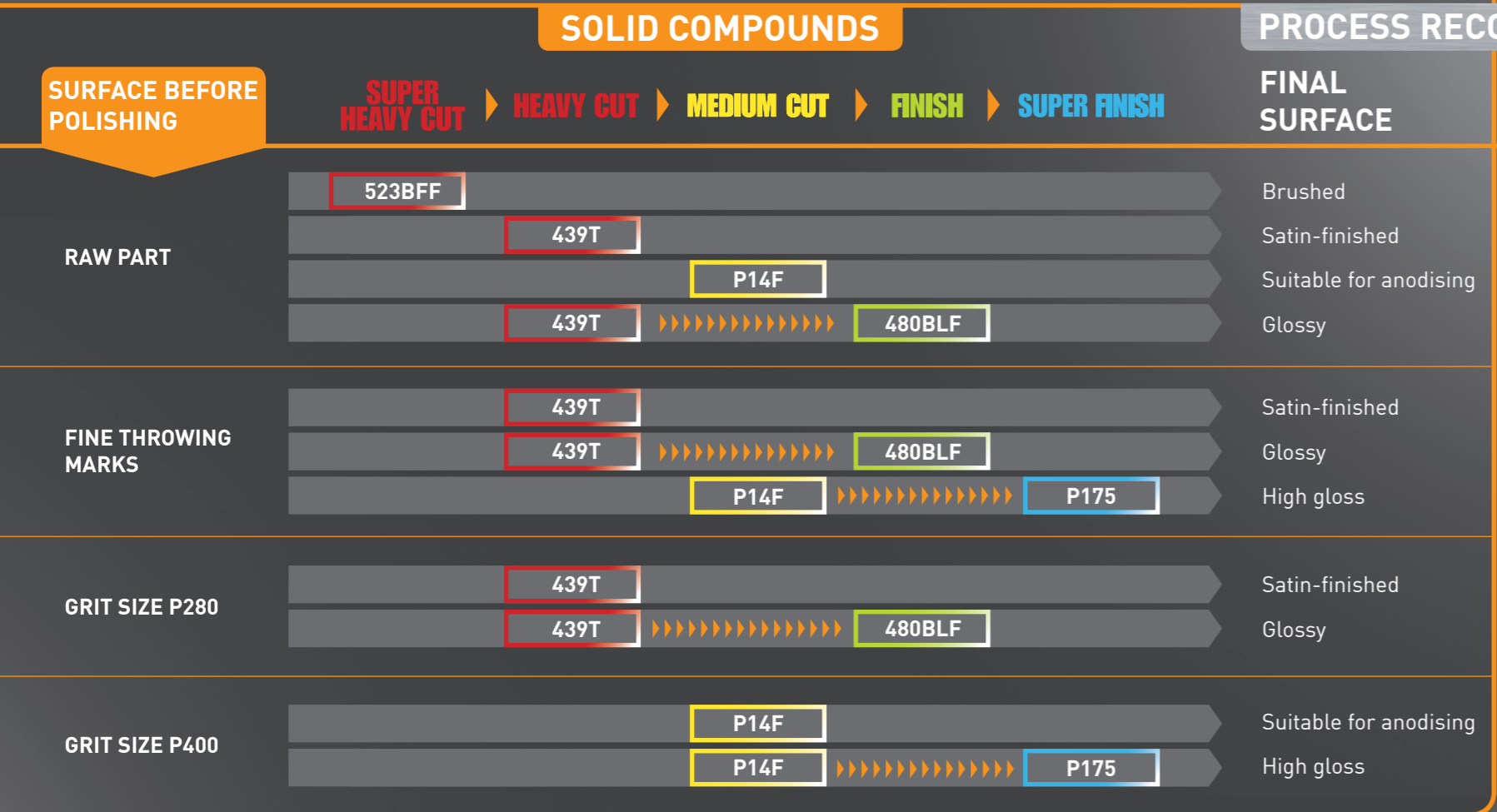
### About Menzerna

Menzerna develops and produces polishing compounds and emulsions for industrial applications. With our consulting services, we assist industrial customers with the optimisation of polishing processes. We cover all aspects of industrial polishing with a wide variety of innovative formulations and complete polishing systems. Menzerna gives premium brands their gloss. **Menzerna - Perfection in Polishing. Made in Germany. Since 1888.**

# MENZERNA ALUMINIUM POLISHING COMPOUNDS

SOLID COMPOUNDS	SUPER HEAVY CUT	HEAVY CUT	MEDIUM CUT	FINISH	SUPER FINISH
	<b>523BFF</b> is a high-performance brush compound with a high grease content. It works very quickly with a high cutting rate. A consistently fine, matt surface is the result.	<b>439T</b> is a universal, fast-acting pre-polishing compound suitable for a broad range of applications. Quickly removes throwing marks, orange peel and sanding marks.	<b>P14F</b> is a fast-acting polishing compound with a good cut and broad field of application. Produces cut and high gloss in one step.	<b>480BLF</b> is a finishing compound developed especially for aluminium surfaces, producing a high gloss and fine mirror finish.	<b>P175</b> is a superfine, high-gloss compound that is versatile in application. It produces a surface free of lines with a premium deep mirror gloss.
<b>Container size (art. no.)</b>	approx. 1.2 kg (01012.050.001)	approx. 1.1 kg (07001.050.001)	approx. 1.3 kg (07163.050.001)	approx. 1.2 kg (07009.050.001)	approx. 1.2 kg (07984.050.001), approx. 560 g (07984.074.001)
<b>Polishing wheel:</b>	Fibre, sisal, cotton	Sisal, cotton	Cotton	Cotton	Soft buffing wheel
<b>Colour:</b>	Dark grey	Green	White	Blue	Yellow
<b>Grease content:</b>	Greasy	Greasy	Greasy	Medium	Dry
<b>Suitable for:</b>	Aluminium, brass/non-ferrous metals	Aluminium, brass/non-ferrous metals, stainless steel	Aluminium, brass/non-ferrous metals, stainless steel	Aluminium, brass/non-ferrous metals	Aluminium, brass/non-ferrous metals, stainless steel, coatings, plastic
<b>Result:</b>	Brushed, deburred and satin-finished surface.	Fast and thorough removal of defects/sanding marks.	Consistent surface with no deep scratches.	Mirror finish surface.	Brilliant surface with a deep gloss.

EMULSIONS	HEAVY CUT	MEDIUM CUT	FINISH	SUPER FINISH
	<b>EM 246GD</b> is a reliable pre-polishing compound with high cutting performance and easy degreasing.	<b>EM 235</b> was developed especially for single-stage, robot-assisted aluminium polishing. Features outstanding heat dissipation. Very quickly creates a surface suitable for anodising, with minimum dust and dirt formation.	<b>PE F3151</b> is a proven, high-quality emulsion for fine buffing. Clean-up time is minimised thanks to an optimum proportion of solids and an optimised bond.	<b>PE 25D</b> produces a mirror finish that is absolutely free of lines and meets the highest quality standards.
<b>Container size (art. no.)</b>	Hobcock, 30l Container, tapered bottom, 700l Container, IBC, 1000l (20879.220.001) (20879.506.001) (20879.515.001)	Hobcock, 30l Container, tapered bottom, 700l Container, IBC, 1000l (20949.220.001) (20949.506.001) (20949.515.001)	Hobcock, 30l Container, tapered bottom, 700l Container, IBC, 1000l (20015.220.001) (20015.506.001) (20015.515.001)	Hobcock, 30l Container, tapered bottom, 700l Container, IBC, 1000l (20472.220.001) (20472.506.001) (20472.515.001)
<b>Polishing wheel:</b>	Sisal, cotton	Cotton	Cotton	Soft buffing wheel
<b>Colour:</b>	Rose	White	Beige	White
<b>Suitable for:</b>	Aluminium, stainless steel	Aluminium, coatings, plastic/composites	Aluminium	Aluminium, brass/non-ferrous metals, stainless steel
<b>Result:</b>	Fast and thorough removal of defects/sanding marks.	Fast, thorough removal of defects, simultaneously producing a consistent surface with no deep scratches.	Mirror finish surface.	Brilliant surface with a deep gloss.



\*The process recommendations provided here were prepared based on our best knowledge. They cover most common practical applications. Additional products are available for other applications.