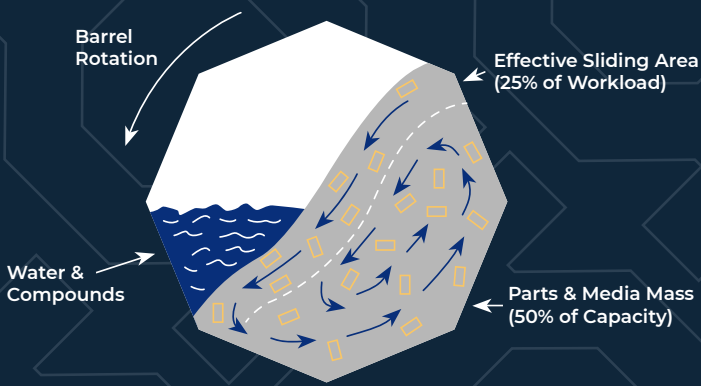


## HOW BARREL TUMBLE FINISHING WORKS

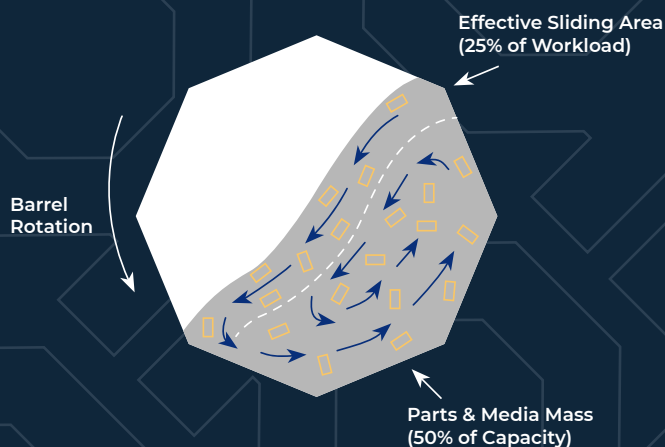
# Step-by-Step Through the Tumble Finishing Process

Barrel finishing is a cost- and time-efficient surface-finishing process. The method is completed by tumbling parts in a rotating barrel, creating a rolling action between the materials. Let's take a look at how wet and dry barrel tumbling works.



### Wet Tumbling

1. Wet tumbling uses horizontal and oblique steel barrels filled up to about half its capacity with parts and media.
2. Enough water is added to the barrel to cover the load. The lower the water level, the faster the cut. The more water, the finer the finish.
3. The compound is then put into the barrel. Depending on the amount of material to be removed in a deburring process, the tumbling process is typically 1-4 hours. A polishing process is often 2-3 times that length.
4. Once the cycle is complete, the parts should be rinsed and dried thoroughly.



### Dry Tumbling

1. Dry tumbling typically uses horizontal barrels filled up to about half its capacity with parts and media.
2. Abrasive or polishing media is tumbled with the parts. Dry tumbling is done with both treated and untreated organic media such as Hardwood Media, Walnut Shell Grit, and Corn Cob Grit.
3. Dry tumbling requires a longer cycle time depending on the process being performed and the type of material being tumbled.
4. After tumbling, the parts generally just need to be blown clean or wiped down. Minimal cleaning is necessary.

Many factors come into play when deciding on the best tumble finishing technique. Media, barrel load, abrasive compounds, speed, slide, and slope all play a factor in determining which process is best for your product. Our Barrel Finishing Guide gives a comprehensive look into various tumbling techniques and tips. For more information on barrel tumbling, contact the experts at Kramer Industries.