

Technical Notes

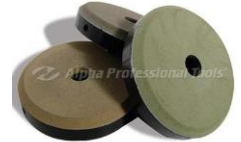
Twincur EB

Alpha Professional Tools® recognizes the continued growth of the engineered stone/quartz surfacing market and the increased need for abrasives designed for use on automated machinery. Alpha® also recognizes the popularity of the full bullnose edge treatment and the need for an abrasive to accomplish this design feature. To fulfill this need in the industry, Alpha® introduces Twincur EB, a set of abrasives specifically developed to polish bullnose edges on engineered stone using automated edge polishing machines. Twincur EB fits on the 5" snail lock adapter commonly used on single- and multiple-head machines. Fabricators of engineered stone will appreciate the ease of operation and the fast, consistent results they will achieve with these abrasives. Twincur EB is designed for high quality performance and longevity. If you work with engineered stone/quartz surfacing and automated

edge polishing equipment, Twincur EB is the abrasive for you. Twincur EB can be used for straight edge polishing when you enable the Micro-oscillating option on your machine.

Sections:

- How to Use
- Frequently Asked Questions (FAQs)
- Helpful Hints
- Reference



Part No.	Size	Maximum RPM	Recommended For	Grit	Color	Bond Type
EB40200R	4"	3,400	Eng. Stone/Quartz Surface	200	Yellow	Resin
EB40500R	4"	3,400	Eng. Stone/Quartz Surface	500	Red	Resin
EB41000R	4"	3,400	Eng. Stone/Quartz Surface	1000	Dark Green	Resin
EB42000R	4"	3,400	Eng. Stone/Quartz Surface	2000	Light Green	Resin
EB43000R	4"	3,400	Eng. Stone/Quartz Surface	3000	Brown	Resin
EB50200R	5"	2,000	Eng. Stone/Quartz Surface	200	Yellow	Resin
EB50500R	5"	2,000	Eng. Stone/Quartz Surface	500	Red	Resin
EB51000R	5"	2,000	Eng. Stone/Quartz Surface	1000	Dark Green	Resin
EB52000R	5"	2,000	Eng. Stone/Quartz Surface	2000	Light Green	Resin
EB53000R	5"	2,000	Eng. Stone/Quartz Surface	3000	Brown	Resin
EB51000LC	5"	2,000	Eng. Stone/Quartz Surface	1000	Dark Green	LC Resin
EB52000LC	5"	2,000	Eng. Stone/Quartz Surface	2000	Light Green	LC Resin
EB60200R	6"	2,000	Eng. Stone/Quartz Surface	200	Yellow	Resin
EB60500R	6"	2,000	Eng. Stone/Quartz Surface	500	Red	Resin
EB61000R	6"	2,000	Eng. Stone/Quartz Surface	1000	Dark Green	Resin
EB62000R	6"	2,000	Eng. Stone/Quartz Surface	2000	Light Green	Resin
EB63000R	6"	2,000	Eng. Stone/Quartz Surface	3000	Brown	Resin
SFAT-5/8	5"	2,000	5/8"-11	-	-	Snail Lock Adapter

3 Types of Polish Available from Twincur EB

Regular	High Gloss	Snake Skin
EB50200R	EB50200R	EB50200R
EB50500R	EB50500R	EB50500R
EB50500R	EB51000R	EB50500R
EB51000R	EB52000R	EB51000LC
EB52000R	EB53000R	EB52000LC

Twincur EB abrasives use 2.2-2.5 BAR pressure; LC abrasives may be used up to 3.0 BAR pressure.

How to Use

FOR AUTOMATIC POLISHING MACHINES

1. Consult your operations manual for the proper setup procedures.
2. Choose the correct size diameter of Twincur EB for your machine specifications.
3. Setup the stone on your single-head edge polishing machine.
4. Use a metal bond shaping wheel to create the bullnose shape on the material. Do not attempt use Alpha® Twincur EB wheels to create the Bullnose edges as they are designed only for the polishing stages.

FOR SINGLE-HEAD (C-Frame Polishers)

1. Attach the first Twincur EB grit onto the spindle of the machine. Make sure the Hard Stop/Mechanical Stop is disengaged when using the Twincur EB wheels.
2. Adjust the movable Cross-Travel Flags so the edge of the material is about ½ way between the edge of the Twincur EB wheel and its center water hole.
3. Adjust the head pressure setting to the desired setting most suitable for the selected grit.
4. Set traverse speed.
5. Provide water and proceed with the polishing stages of Twincur EB.

FOR MULTIPLE-HEAD

1. Attach Twincur EB (5" or 6") wheels on your multi-head line polisher in the correct polishing sequence. (#200, #500, #1000, #2000 and #3000 grits)
2. Center the heads with the material being polished. (See equipment manual for details).
3. Adjust the head pressure setting to the desired setting most suitable for the selected grit.
4. Adjust the belt speed to 1 foot per minute. (12 inches, 30.48cm or 304.8mm per minute)
5. Provide appropriate water flow to each Twincur EB wheel.

Frequently Asked Questions (FAQs)

What is the recommended RPM for the Twincur EB wheels?

- o Twincur EB 4" wheels is 3,400 RPM
- o Twincur EB 5" and 6" wheels is between 900 and 3,400 RPM

What is the recommended BAR pressure?

Recommended BAR pressure is as follows

- o Twincur EB 4" wheels is 40 PSI.
- o Twincur EB 5" and 6" wheels is between 2.2 – 2.5 BAR.
- o Twincur EB 5" LC- Series abrasives is up to 3.0 BAR.

What is the recommended Traverse Speed?

Recommended traverse speed is as follows:

- o Twincur EB 4" - 100 feet per minute
- o Twincur EB 5" and 6" wheels - 12 inches, 30.48cm or 304.8mm per minute.

Can Twincur EB used on Granite?

Twincur EB can be used to polish granite; however, Twincur EB performs best when used for polishing engineered stone.

Can I use Twincur EB for flat edge polishing?

Twincur EB 5" and 6" can be used for flat edge polishing only if the polishing machine has a "Micro-Oscillation" feature. The micro-oscillation feature creates a small radius on the flat edge of the material which is necessary for the Twincur EB to successfully polish. Alpha® recommends using our Alpha® Twincur ES Series for true straight edge & bevel polishing.

I was informed that your competitors' abrasives require a "Break in Period" before the abrasives start to perform; is there a break in period for the Twincur EB?

No. Each Alpha® Twincur EB wheel is calibrated and dressed at our factory to guarantee it's polishing performance the first time it's placed on the machine. Other manufactures abrasives on the market today require a "Break in Period" during which fabricators need to run scrap stone through the machine in order to break-in these abrasives prior to using them on the actual work piece.

How many steps do you have in your polishing sequence?

Alpha® has five polishing steps: #200, #500, #1000, #2000 and #3000.

How do I ID the grits of the Twincur EB wheels?

Since each wheel looks similar to one another, Alpha® inserted color ID plugs with grit indication on the backside of each wheel.

Yellow – 200 Grit

Red – 500 Grit

Dark Green – 1000 Grit

Light Green – 2000 Grit

Brown – 3000 Grit

What size adapter does Twincur EB use?

All Twincur EB wheels use a snail lock adapter (SFAT).

What does the EB in Twincur EB stand for?

EB is the identification of these particular wheels. EB stands for "Engineered Stone/Bullnose".

What are the recommended Miter settings using Twincur EB 4" for use on a C-Frame polisher?

No. At this time the Twincur EB will only create high-gloss finishes on engineered material.

Can I use the Twincur EB for hand applications?

No. Twincur EB resin wheels are to be used for machine applications only. The resin abrasives of these wheels are designed to wear using consistent BAR pressures.

Can I use these 4" Twincur EB on my multi-head line polisher?

No. Multi-head line polishers are not mechanically designed for the use of 4" (100mm) abrasives. All functions of these polishers are setup for use of either 5" (125mm) or 6" (150mm) abrasives.

Can I use these 5" or 6" Twincur EB on my single-head polisher?

Yes. 5" or 6" Twincur EB can be used on single-head polishers. They will require a 5" snail lock adapter for mounting purpose. (Alpha® Part Number: SFAT-5/8)

What are the recommended Miter settings using Twincur EB 4" for use on a C-Frame polisher?

This will depend on the thickness of the material and the type of single-head line polisher in your shop. (Consult the machine's operation manual for these settings).

When using my multi-head polisher, the material didn't polish the very beginning or end of the material, why?

The belt speed may be too fast which will cause the spindle head holding the polishing wheel not to make contact with the material quickly enough. One suggestion is to run a dummy piece before and after the work piece to assure the polishing wheels are making proper contact for the allocated polishing time. Some of the new multi-head polishers on the market today can adjust the timing of the spindles activation, please contact or view your machine manufacturer owner's manual.

I understand Alpha® offers three different polishing sequences for use of 5" Twincur EB wheels?

Our wheels can perform the following three polishes when you use the correct wheel in sequence: Regular Polish, High Polish and Snake-Skin Polish.

Helpful Hints

- Consult your operation manual for proper setup of tooling.
- Wet use only.

- Twincur EB “LC” (#1000 grit and #2000 grit) are required to create the “Snake Skin” appearance on the bullnose edge.

Reference

For more product information, visit us on the web at www.alpha-tools.com.

Product Page: <http://www.alpha-tools.com/Product.aspx?PageCode=880>