

Technical Notes

Twincur GB

Alpha Professional Tools® recognizes the popularity of the full bullnose edge treatment for kitchen countertops. Since granite is one of the most popular choices today, the need for abrasives designed for use on automated machinery is growing. To fulfill this need in the industry, Alpha® introduces Twincur GB, a set of abrasives specifically developed for this task. Twincur GB is available in 4" and 6" and fits on the common 4" and 5" snail lock adapters commonly used on single- and multiple-head machines. Fabricators of stone will appreciate the ease of operation and the fast, consistent results they will achieve. Designed for high quality performance and longevity, Twincur GB is the best choice for all fabricators.

Sections:

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Part No.	Size	Maximum RPM	Recommended For	Grit	Color	Bond Type
GB40200R	4"	3,400	Granite	200	Yellow	Resin
GB40500R	4"	3,400	Granite	500	Red	Resin
GB41000R	4"	3,400	Granite	1000	Dark Green	Resin
GB42000R	4"	3,400	Granite	2000	Light Green	Resin
GB43000R	4"	3,400	Granite	3000	Brown	Resin
GB60100R	6"	3,400	Granite	100	Blue	Resin
GB60200R	6"	3,400	Granite	200	Yellow	Resin
GB60500R	6"	3,400	Granite	500	Red	Resin
GB61000R	6"	3,400	Granite	1000	Dark Green	Resin
GB62000R	6"	3,400	Granite	2000	Light Green	Resin
GB63000R	6"	3,400	Granite	3000	Brown	Resin
SFAT-5/8	5"	2,000	Snail Lock Adapter	5/8"-11	-	-
SFAT-M18	5"	2,000	Snail Lock Adapter	M18	-	-

How to Use

FOR SINGLE HEAD AUTOMATIC POLISHING MACHINES:

1. Consult your operations manual for the proper set-up procedures.
2. Set up stone on your single-head edge polishing machine.
3. Use a metal bond shaping wheel to create the bullnose edge shape on the material. Do not attempt use the Alpha® Twincur GB wheels to create the bullnose; they are designed only for the polishing stages.
4. Attach the first Alpha® Twincur GB grit onto the spindle of the machine. Make sure the Hard Stop/Mechanical Stop is disengaged when using the Twincur GB wheels.
5. Adjust the movable Cross-Travel Flags so the edge of the material is about ½ way between the edge of the Twincur GB wheel and its center water hole.
6. Adjust the head pressure setting to the desired setting most suitable for the selected grit.
7. Set traverse speed

8. Provide water and proceed with the polishing stages of Twincur GB.

Always review the machine's operation manual for the proper setup procedures.

Frequently Asked Questions (FAQs)

What is the recommend RPM for the 4" Twincur GB wheels?

We recommend using them at 3,400 rpm.

What is the recommended BAR pressure?

The recommended BAR pressure for use of Twincur GB is 35 PSI.

What is the recommended Traverse Speed?

We recommend using the 4" Twincur GB at a speed of 100 feet per minute.

What is the recommended Miter settings using 4" Twincur GB?

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.)

Can the 4" Twincur GB used on Engineered Stone?

No. The 4" Twincur GB is intended for granite use only; they are not recommended for engineered Stone. Alpha® recommends using our 4" Twincur EB for polishing engineered stone material.

Can I use 4" Twincur GB for flat edge polishing?

No. The 4" Twincur GB is intended for bullnose and radius applications only. Alpha® recommends using our Alpha® Twincur for flat edge 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 4" Twincur GB?

No. Each Alpha® Twincur GB 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.

Is there a final buff for the 4" Twincur GB?

No. Alpha® designed our system to achieve a perfect polish after the use of the #3000 grit. There is no need for a final buffing process.

What size adapter does the 4" Twincur GB use?

4" Twincur GB requires a 4" snail lock adapter (SFAT).

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

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

What does the GB in Twincur GB stand for?

GB is the identification of these particular wheels, GB stands for "Granite Bullnose".

Can I use the 4" Twincur GB for hand applications?

No. The 4" Twincur GB resin wheels are to be used for machine applications only. The resin abrasives of these wheels are designed to wear at appropriate BAR pressures.

Helpful Hints

- Consult your operation manual for proper set-up of tooling.

- Wet use only.

Reference

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