

KOCOUR

Pioneers in Metal Finishing Since 1923

Metal Finishing Supplies





Many times it is possible to select the proper composition from a catalog description. For that reason you will find in this brochure a list of Kocour products and a brief description of each. Products are gladly sent on approval, without charge. However, in order for Kocour to select the best possible product or products for a specific application, your cooperation is requested in furnishing the following data:

1. Type and shape of metal or material to be finished.
2. Condition of surface prior to finishing, and sample or description of finish required.
3. Diameter and type of buff, and R.P.M. of spindle.
4. Manual or automatic operation.
5. Type of cleaning, if any, to follow.
6. Amount of composition desired to make a suitable test.

METAL FINISHING IS A DANGEROUS BUSINESS. PLEASE READ AND FOLLOW THESE SAFETY INSTRUCTIONS. THEY WILL MAKE YOUR JOB EASIER AND THEY COULD SAVE YOUR LIFE.

Wear the proper clothing and protective gear. It is critically important that you wear a respirator suitable for the compound you are using. See the compound SDS for additional information.	Never let the work contact two points on the wheel at the same time.	Apply compound carefully, and don't overload the buff. Too much compound produces less abrasive action on the work. Work with properly guarded equipment.	Use the proper size wheel at the recommended speed for the job. Always work the face of the wheel turning toward you and down. Work between 3 and 5 o'clock on the disc.	Use work holding tools when parts are small or difficult to grip. Such as: Door Knob on a work spinner. Flat stock fixtured to a larger surface of wood or metal for ease of holding.	Use smaller buffs on hand tools for I.D. work and in sharp corners.
--	--	---	--	---	---

Use **Bold/Italic Face Range in Shaded Areas** as a wheel speed guide.
Lower Numbers in each column for Coloring, Higher Numbers for Cut.

R.P.M. at Arbor or Spindle	Diameter of Wheels in Inches										
	4	6	8	10	12	14	16	18	20	22	24
	Surface Speed in Feet per Minute (S.F.P.M.)										
800	837	1256	1675	2094	2513	2932	3351	3770	4189	4608	5026
900	942	1413	1885	2356	2827	3298	3770	4241	4712	5184	5655
1000	1047	1570	2094	2618	3141	3665	4189	4712	5236	5760	6283
1100	1152	1727	2304	2880	3455	4031	4608	5183	5760	6336	6911
1200	1256	1884	2513	3142	3769	4398	5027	5655	6283	6912	7540
1300	1361	2042	2723	3404	4084	4764	5446	6126	6807	7488	8168
1400	1466	2199	2932	3666	4398	5131	5865	6597	7330	8064	8796
1500	1571	2356	3142	3927	4712	5497	6284	7069	7854	8640	9425
1600	1675	2513	3351	4189	5026	5864	6703	7540	8678	9216	10053
1700	1780	2670	3560	4451	5340	6230	7121	8011	8901	9792	10681
1800	1885	2827	3770	4713	5654	6597	7540	8482	9425	10368	11310
1900	1989	2984	3979	4975	5969	6963	7959	8954	9948	10944	11938
2000	2094	3141	4189	5236	6283	7330	8378	9425	10472	11520	12566
2100	2199	3298	4398	5498	6597	7696	8797	9896	10996	12096	13194
2200	2304	3455	4608	5760	6911	8063	9215	10367	11519	12672	13822
2300	2408	3612	4817	6022	7225	8429	9634	10839	12043	13248	14451
2400	2513	3770	5027	6284	7540	8796	10053	11310	12566	13824	15079
2500	2618	3927	5236	6545	7854	9162	10471	11781	13090	14400	15708
2600	2722	4084	5445	6807	8168	9529	10890	12253	13613	14976	16336
2700	2827	4241	5655	7069	8482	9895	11309	12724	14136	15552	16964
2800	2932	4398	5864	7331	8796	10262	11728	13196	14660	16128	17592
2900	3037	4555	6074	7592	9110	10629	12147	13667	15184	16704	18221
3000	3141	4712	6283	7854	9425	10996	12566	14137	15708	17280	18850
3200	3351	5026	6702	8378	10053	11729	13404	15079	16755	18431	20107
3400	3560	5340	7121	8901	10681	12462	14242	16022	17802	19583	21363
3600	3769	5654	7539	9425	11309	13193	15079	16964	18850	20735	22619
3800	3979	5969	7958	9948	11938	13927	15917	17907	19897	21887	23876
4000	4188	6283	8377	10472	12566	14661	16755	18850	20944	23039	25132



Greaseless Compounds

As the name implies, Kocour Greaseless Compounds are made entirely free of any grease binders such as tallow, oil, wax, etc. Using animal hide glue as the binder, abrasive grain is skillfully blended into this glue base to form a uniformly mixed "greaseless" compound. When applied to a revolving buffing wheel, the frictional heat created causes the compound to melt, thus an even coating of glue and abrasive grain is transferred to the wheel. This abrasive coating dries quickly, and the wheel is ready for use. The many grades of Greaseless Compounds produced, in grit sizes from coarse to very fine, permit an equally wide range of finishes and cutting actions on the work. Further, Greaseless Compound is easily applied to loose or tight sewed buffs, hard felt or cloth polishing wheels and small bobs. This allows extreme flexibility for the operator when finishing articles that have a flat or rounded surface as well as irregular, restricted, and recessed areas.

Typical applications are blending of pre-finished stainless steel, relieving of antiqued finishes, and as a sisal substitute prior to nickel plating. Because Greaseless Compound is made completely free of any tallows, oils, or waxes, the buffed work is left clean and dry, and further cleaning operations are not required.

They are available in the following grit sizes:

80	180
120	240
150	300

Kocour Greaseless is packaged in a very economical and easy-to-use plastic tube. Each tube is approximately 2" x 8.5" long and weighs about 3 pounds. A 45 pound case holds 15 tubes.



Application Tip:

Start with a clean dry wheel and rake it out to open the face. Peel the plastic covering back a few inches to expose the compound. If you are using a variable speed lathe, slow it down to the minimum speed and apply the compound to the face of the wheel with short strokes. When using a single speed lathe above 1200 rpm, let the lathe come up to speed then shut it off and use the compound tube as a brake to stop the wheel. Repeat this process until a thick head has been formed on the wheel surface, letting the compound air dry with the wheel in motion between applications. With a new wheel, it can take several minutes to build a good head.



Liquid Buffing Compounds

A fast, efficient, and economical method of applying and using buffing compounds. Air powered spray applicators can apply liquid compound to large areas of buff face on automatic equipment where bar applicators would be too cumbersome, and hand application too dangerous.

Note: Compounds can be adjusted to meet customer specifications or new compounds can be developed for customer specific applications.

#5 A heavy cut compound made from a blend of coarse abrasive for fast cutting action. (White)

#8 An alternative to heavy cut tripoli liquid compound. (Orange/Brown)

#10 A blend of coarse aluminum oxides makes this compound very aggressive for those jobs requiring a heavy cut. (White)

#10B A blend of coarse aluminum oxides makes this compound very aggressive for those jobs requiring a heavy cut. (Orange/Brown)

#10SC Our highest cut compound used when a fast extra aggressive cut compound is needed. (Gray)

#22 A cut and color compound that has been formulated to be an alternative to Tripoli. (Orange/Brown)

JCT 50/50 An all purpose liquid for cutting and coloring a wide variety of steel parts. Careful blending of several different abrasives in high quality binders make this formula very useful in the job shop environment. (Light Green)



#44 A color compound that has a small amount of cut to refine the surface as well as leave a high luster finish. (White)

#47 A coloring compound designed for work that has a high quality polish or is free from deep surface imperfections and requires buffing for luster. Very good on aluminum, steel and stainless steel. (Green)

Hi Shine B A high color, easy cleaning compound especially formulated for stainless steel. (White)

MS Coloring A coloring compound designed for work that has a high quality polish finish or is free from deep surface imperfections and requires buffing for luster. Very good on aluminum, brass and copper. (White)





Cut and Cut/Color Bar Compounds

Buffing compound is composed of various grades of aluminum oxide abrasive combined with the appropriate amounts of fatty acid binders to produce "cut", "cut and color", and "coloring compounds". Listed are a few of our more popular compositions. Keep in mind that the effectiveness of the compound is dependent on both the size of the abrasive used and the quantity of binder that holds it on the wheel. We will work with you to find the most effective and least expensive combination of products to meet your buffing requirements.

Cut Compounds

SS 35 A medium greasy, fast cutting compound suitable for buffing and coloring out the work in one operation. Our most popular grade for a large variety of work. (Gray)

SS 47 A blend of sharp abrasives produce an extra fast cutting action. Ideal for buffing out light tool marks or scratches. Its use may reduce or eliminate the need for finer belt operations. (Gray)

SS 47G A greasier version of the SS47. (Gray)

SS 47A Our most aggressive cutting compound. A blend of hard fast cutting abrasives. (Gray)



Cut/Color Compounds

Black Diamond A dry grade compound that is very versatile with good cutting and coloring action. Leaves the work piece very clean for preplate or a final finish. (Black)

C88 A greasy grade compound with light cutting and good color. (White)

SS 17 A semi-dry grade compound with a fast cutting action achieved through fine but sharp cutting abrasive particles. This compound is especially effective for coloring steel tubing products and also is widely used to cut and color aluminum castings and brass after an abrasive belt or flap wheel polishing operation. SS 17 leaves the work very clean and is an excellent buffing composition for preplate operations. (Yellow)

SS 17U A more aggressive version of the SS 17 that allows faster cutting while still leaving the work with a bright finish. (Yellow)

SS 45 A dry grade intended for use on work that has a good starting surface, such as light stampings, and moldings. Has light cutting action with bright finish. (Light Green)

SS 45U A more aggressive version of the SS45 that gives better cutting with slightly less coloring. (Light Green)

SS 37 A medium dry compound with fast cut and light color. Works well on ferrous and non-ferrous materials. Ideal compound for shops running a variety of materials. (Red/Orange)

All grades are made in standard size bars weighing approximately 2-3/4 pounds each. Also available in special bar sizes to fit robotic bar feeders and other special applications.

Application Tip:

When using bar compounds, make frequent light applications to the wheel. Take care NOT TO overload or "glaze" the wheel. Too much compound will interfere with the cutting action.



Color Bar Compounds

Intended for buffing non-ferrous metals where the work surface is in good condition, free of deep tool or die marks. When heavy marks are present, a cutting compound is generally used to first cut down the surface. A second buffing operation is then performed using a white coloring compound to produce a highly reflective finish. (Coloring compound is also excellent for buffing brass plated parts to a clear bright luster.) Typically used with whole disc loose buffs, bias airway buffs or flannel coloring buffs.

CR-2 A very dry grade made of pure alumina. Excellent scratch free coloring. High usage in the dental and plastic industries. (White)

CR-6 A medium dry grade that has been our most popular seller for years, for all classes of chromium and stainless steel color buffing. A white compound made from pure alumina that produces a good cutting and coloring action without creating scratches. (White)

CR-15 A dry grade with a light cutting action and coloring that leave a bright, easy to clean finish. (Green)

CR163 A medium greasy and slightly waxy compound used for general color buffing of non-ferrous metals. (White)

KC 11 A soft white grade of coloring compound especially useful in buffing out nickel plated parts which have been lightly damaged in handling. An excellent choice whenever high luster and a haze free finish is required. (White)

Purple Diamond A medium greasy compound that produces a very high luster finish. Typically used as a final finish compound. (Light Purple)

Green Diamond A medium dry grade used for final coloring on soft metals. Can also be used to bring steel or stainless steel to a high shine. (Light Green)

Red Rouge Commonly known as "jewelers red rouge". Deep red in color, this compound is only used when a very high luster is required. (Dark Red)

Green Rouge This compound is used on both ferrous and non-ferrous materials to give the highest luster. Especially effective in coloring stainless steel and aluminum to a deep shine. (Dark Green)

Plastic Buffing Compounds

Because of the wide variation of plastics produced, we list only the grades of compound that have proven most popular for use on average work. Many other grades are available to meet special applications. Where cut down or minor stock removal is necessary, we recommend a fine greaseless operation on a flannel buff at slow wheel speeds followed by a coloring operation with one of these compounds.

Bar Compounds

CR-2 A very dry grade of pure alumina for excellent scratch-free coloring. (White)

Blue Diamond A greasy compound made for buffing plastic, acrylic, wood and paint. (Light Blue)

Liquid Compounds

Coarse Fiberglass Paste A cut compound designed to be used as the first step in buffing plastics, fiberglass or cultured marble. (White)

Fiberglass Paste A color compound designed to be used as the final step in buffing plastics, fiberglass or cultured marble. Leaves a scratch free finish. (White)



Tripoli Replacement Bar Compounds

These familiar reddish-brown colored "bricks" of compound are most widely used for cutting down and bringing out high luster on non-ferrous metals. Fast cutting and bright coloring action makes these compounds the best choice for buffing all types of zinc die castings, copper plated work and aluminum castings and stampings. A greasy grade is generally selected for coarse work because the extra percentage of grease binders keep the compound on the buff face longer increasing the cutting action. Lighter, drier grades are used for cut and color operations or for light coloring before electroplating. These compounds are practical with any type of buffing wheel, but generally used on a tight, spiral sewed, pocket or bias type buff.

SF 32 A medium dry compound that is a versatile cut and color Tripoli replacement. (Orange/Brown)

SF 36 A medium dry compound used for a light cut and color. Excellent for use on non-ferrous materials. Removes small defects/scratches and leaves a bright finish. (Orange/Brown)

SF 38 A medium dry compound with a faster cutting action and bright finish. Used for heavy buffing work. (Orange/Brown)

SF 40 A medium greasy compound with extra fast cutting action and light coloring. (Brown)

All grades available in standard bar sizes weighing 2-3/4 pounds each. Also available in special bar sizes to fit robotic bar feeders and other special applications

A note about Tripoli and other crystalline silica containing compounds:

Historically Tripoli has been considered the best cut and color compound for non-ferrous metals. The name "tripoli compound" is the common term used. However, the raw material tripoli is composed of crystalline silica a known carcinogen and, if improperly handled, a significant health hazard. In the past Kocour Company has offered compound formulated with the raw material tripoli as well as other crystalline silica raw materials.

To better serve our customer in today's regulatory intensive environment Kocour Company has formulated equivalent compounds that contain no detectable free crystalline silica.





Polishing Lubricants

Kocour lubricants are designed for wheels and belts set with aluminum oxide, silicon carbide or turkish emery grain. Often used with second or third stage polishing operations to "oil out" prior to buffing. The application of lubricants to an abrasive belt or wheel produces a softer more forgiving cutting action and results in a surface that is easier to buff out.

G-1 A yellow tallow grease with a low melting point. Primarily for polishing wheels or belts it is also used as a saw lubricant.

G-6 A higher melting point yellow tallow, medium hard grease for polishing wheels.

G-11 A high quality, fully saponifiable yellow tallow grease for applications where cleaning is a problem.

W-535 Lube Wax A soft solid wax with superior lubrication. It is excellent on circular or band saws, or for improved performance on grinding, sanding and drilling operations.



***Greases are also available in liquid form**

Detailing Products

Kocour manufactures detailing polishes that can be used for detailing cars, trucks, RVs and boats. Kocour also supplies buffing products that can be used with our bar or liquid compounds.

All Metal Polish A liquid polish that can be used on any metal to restore it to its original shine. (Blue)

Paint Polish A liquid polish that can be used on paint or plastic to remove scratches or oxidation. Leaves a protective coating for a long lasting shine. (White)

Bias Airways Buffs Available in 8" and 10" diameter with 3" center and 5/8" arbor. Buffs are offered in three varieties:

1. Blue (Stiff) – Used for heavy cutting
2. Yellow (medium) – Used for cutting
3. White (soft) – Used for coloring

Bar Compounds Offered in smaller 1 lb bars that are easier to apply to handheld buffers.



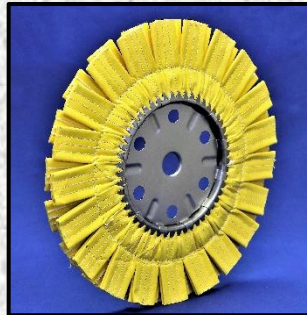


Buffing Wheels

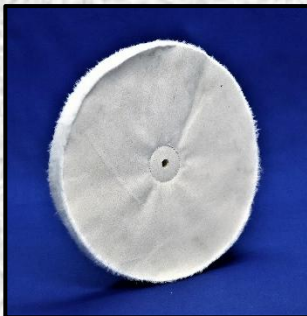
In this section we show the wide variety of buffs and wheels which are available at Kocour Company. All are manufactured from quality raw materials and produced to the highest quality standards of the industry. Proper selection is critical to every buffing application. Our experienced technical staff is always available to assist our customers. We also supply used buffs. Call for pricing and availability.



Bias Airway The work horse of the industry, can be used on almost any application. Bias cut sheeting is drawn into a center clinch ring to produce a puckered face. Cloth comes in several weights and treatments. This is the fastest cutting all cloth buff.



Muslin Finger Used where flexibility is required for irregular shapes. The number of fingers and sewing per finger is varied to meet the needs of the particular application. It is used for cut down and color on non-ferrous metals where deep penetration is needed. For ferrous metal buffing sisal can be added. Both can be treated for firmness and compound reaction.



Full Disc Loose Largely used as a color buff. This buff is constructed of whole discs of muslin cloth sewn once around the center hole. Soft and forgiving for a scratch free finish.



Full Disc Spiral Sewn A versatile buff for hand applications. Used universally before the invention of the bias construction, use is not limited to general purpose buffing. Will not snag parts, use on complex shapes such as plumbing fixture.



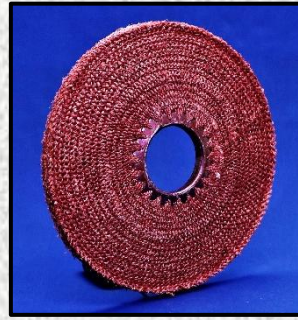
Full Disc Flannel Canton Flannel faced muslin produce this special loose coloring buff. Used where lusters of the highest quality are necessary such as finishes prior to clear lacquer or E-coat. This cloth is also very receptive to greaseless compounds for satin finishes.



Jewelers Buff Also manufactured of whole disc canton flannel, but with rows of concentric sewing for firmness. Basic buff in the jewelry and antique trades.



Sewed Sisal Sisal fiber is a form of hemp. Discs of sisal are sewn together to form a basic steel buff. Inexpensive, but effective, these buffs come untreated or treated for firmness and extra cut. Sometimes combined with cloth for better coloring.



Bias Sisal Straight Face A very aggressive cut buff for steel, stainless steel, and other hard metals. Made from bias cut sisal, this construction finds wide use in automatic machines. This is standard buff when hard treated, for tube and rod finishing.



Bias Sisal Open Face Usually combined with cloth this buff is more flexible than the straight face bias sisal. Open faces are used on contoured surfaces. Although designed for ferrous metals, this buff is the basic tool for finishing aluminum motorcycle castings.



String Wheels Cotton fringe wound onto a wooden core produces a brush with a big, soft, open face. Mostly used with greaseless compound and a flexible shaft machine to produce a satin finish on large areas of stainless steel.



Polishing Wheels Sections of full disc sewn buffs are glued and pressed together to make a solid wheel. When faced with adhesive and abrasive, this set-up wheel becomes a very versatile substitute for abrasive belts. Used extensively in automobile bumper refinishing.



Goblet Buffs Small, densely packed buffs for hard to reach areas. Used with mandrels or tapered screw points, they come in tapered, round end, and cylinder shapes.

Buffing Lathes



Heavy Duty Buffing Lathes

General purpose finishing lathe. For demanding, high production, polishing and buffing applications. Required for semi-automatic work holders. Available in single, variable speed, and twin powered spindle models, from 5 to 15 HP.

Medium Duty Buffing Lathes

Inexpensively designed for efficient performance on a wide variety of commercial applications. Available in single and variable speeds, with outboard bearings, enclosed drive, and mounted electrical starter.



Light Duty Buffers

Low cost bench or pedestal mounted buffer for home or shop use. Available in 1/4 to 5HP, single and three phase, these versatile 1800RPM buffers are ideal for use on small industrial parts, antiques, guns, knives, jewelry, dental, and medical applications.





Equipment and Accessories

Buff Flanges

Available in four diameters to fit almost any buff type of size. Proper fitting is especially critical on metal center, airway type, bias buffs. Standard arbor hole is 1-1/4". Heavy duty 1/4" thick steel.



Buffing Wheel Rakes

A necessary tool for preventing scratches by removing old compound and metal from buff faces. Replaceable teeth mounted on a hardwood handle. Handle and teeth sold separately or as a set.



Abrasive Belt Cleaner

Restores clogged loaded and glazed abrasive belts, sanding discs and drums, by removing embedded grinding debris lodged and packed between the abrasive grit particles. Works like a giant eraser.



Scotch Brite™

Synthetic fibers and abrasive particles are combined and bonded to form a conformably, three-dimensional, open web material. Hand pads, rolls, discs, wheels, belts, and bench area products meet the needs of production application.



Work Spinners

Ruggedly built with heavy duty, grease ball bearings, this indispensable finishing tool is capable of fixturing parts up to fourteen inches in diameter and several pounds in weight. Kocour work holders will spin parts smoothly and evenly into any wheel or belt. For stock removal, coloring, highlighting or deburring, a slight thumb drag will give just the right finishing touch.



Rubber & Foam Contact Wheels

With a serrated face for fast stock removal, this two piece wheel is the industry standard. A full range of durometers and sizes make this belt polishings most versatile performer.



Abrasive Belts

A complete line of coated abrasive products. Belts, discs, bands, rolls and sheets are available for both the metal and woodworking industries. Conversion facilities allow for quick delivery.



Backstand Idlers/Pulleys

Several models to choose from. Floor mount or pedestal base; spring, air or screw tension. An all steel 10" diameter by 5" wide pulley provides long unit life. Even the narrowest belts are easily replaced





Kocour Company has been a pioneer in developing buffing compounds in the United States. For over 100 years, Kocour has continued to develop more efficient and safer compounds to meet the demands of industry.

Kocour manufactures every type of liquid and bar compound and therefore can recommend the type that will work most efficiently for you. Specially trained personnel with broad metal finishing experience are available to demonstrate the advantages and savings available through Kocour Buffing Compounds.

ISO 9001:2015 Certified



Kocour Company

4800 South St. Louis Avenue, Chicago, Illinois 60632 U.S.A.

Telephone: (773) 847-1111

www.kocour.net