

“Practical Pointers – Polishing Granite”

The Monumental News

Vol. 8, No. 3, March 1896, pp. 198

This article begins as follows:

“By way of preface to the following remarks upon granite polishing, it should be stated that the discussion is based upon the employment of machines of the most approved type and excellence, several of which are manufactured in Barre, Vt. Illustrations of some of these may be seen in the advertising columns of this journal....”

This article, which begins on the next page,
is presented on the Stone Quarries and Beyond web site.

<http://quarriesandbeyond.org/>

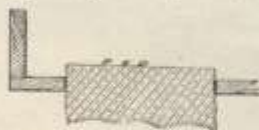
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October 2014

PRACTICAL POINTERS.

Polishing Granite.

By way of preface to the following remarks upon granite polishing, it should be stated that the discussion is based upon the employment of machines of the most approved type and excellence, several of which are manufactured in Barre, Vt. Illustrations of some of these may be seen in the advertising columns of this journal.

In the operations and methods to obtain the best polish in the shortest time there is room for "divers opinions." However it is first necessary to level the bed or surface to be polished and construct around it a frame work of common sawed boards, six or eight inches wide by one inch in thickness. Make the frame larger by six inches all around the bed; then place another board to fill in the space and nail side and end pieces to same forming a right angle or square corner all around the bed. This



frame work must be left an inch or two below the surface to allow the wheel to pass over the edges, ends etc. Also the frame must

drop a little lower at one of the ends, enough so that the water and waste may run to that end, and through an opening into a tub filled with water. In this way if any of the unwrought iron or shot is forced away it will drop into this tub and is thus saved for further use. While the waste will wash over the top, it is generally conceded "now-a-days" that it is not so much what one makes as what he saves—that counts, hence the necessity of saving the material used in process of polishing.

After adjusting the frame work around the bed of stone to be polished, fill up all the crevices around and between the different pieces that make up the bed with calcined plaster or plaster of paris. While the plaster is in process of hardening, adjust the wrought iron scroll wheel which is considered the best in use today, using about one pint of chilled shot or crushed steel to each surface foot. After the tool marks are all rubbed out and a good solid surface appears, let the iron get thick or muddy, using but little water, and in this way avoid deep iron scratches, making the surface ready for emery. Wash the iron thoroughly from the bed by means of a hose, such as garden hose, using plenty of water and scrub brush. This done and all trace of the iron washed away, then apply another thin coating of the calcined plaster and this will prevent iron scratches; in process of emerying use a plain ring wheel of cast iron allowing $\frac{1}{2}$ pint emery to each surface foot of bed, using it over and over un-

til it gets down to a sludge and the surface of stone begins to show a dull gloss. At this stage you wash clean as before and your bed will be ready for buffing.

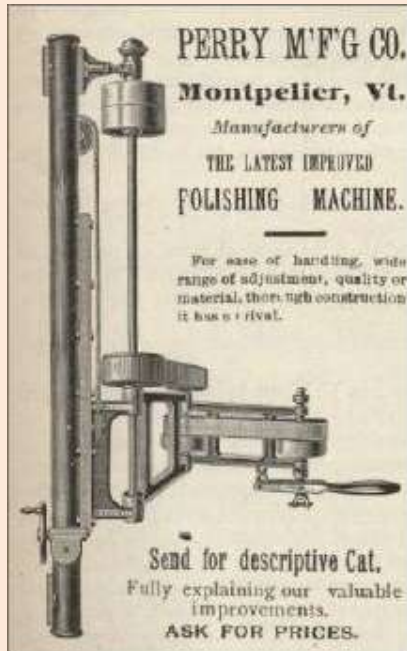
In doing this you may use the same ring as used with the emery, only be careful to wash clean and cover over the under side with heavy felting, wet thoroughly with water and apply a small quantity of putty powder. What is more generally used in Barre, however, in all polishing mills is, simply, ordinary rope about $1\frac{1}{4}$ to $1\frac{1}{2}$ inch in diameter cut in lengths of about 8 inches, stood on end and firmly bound together with one or two iron rings or hoops around the outside of the bunch, which can be bought ready made of the manufacturers at Barre. These rope buffers when new, must be well soaked in water before being used, then shake a small quantity of putty powder on the surface of bed and run the buffer over and over until you get the desired gloss or shine. Be careful not to run this too dry, as it is very necessary to keep damp or moist. Running too dry will cause the surface to heat by the friction and the result is detrimental to the good gloss. These are the principal points to observe in polishing granite.

The speed a shot rubber should have to do the best work depends largely upon the diameter of your rings, for instance, a set of rings 18 inches in diameter could be run up to 180 revolutions per minute with good results, and a set of rings 36 inches in diameter could be run from 140 to 160 revolutions. So that the average speed for rubbing down with chilled iron or crushed steel would be about 160 revolutions per minute. The same rule of speed applies to rubbing with emery and in buffing. Every machine has two speeds, so that either can be used at will. The writer does not know of any electric motors being used to propel polishing machines, although this might be done to advantage. There is a gasoline engine in use in Barre for polishing, and it runs one machine and two grindstones at average cost of 90 cts to \$1 per day. It is said to be capable of running one other machine with but little or any additional cost.

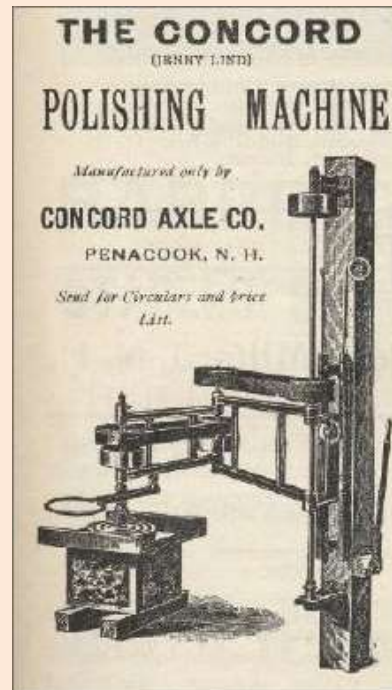
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James Ingram.

A Connecticut shop foreman will tell: "How to Avoid Mistakes in Inscriptions," and "A Good Way to Point the Joints of Monuments," in the April issue.

"Tom All Alone's" the dismal graveyard in Russell Court, Drury Lane, London, immortalized by Dickens in the Poor Joe episode of "Bleak House," is now almost an "open space," owing to the extensive demolitions in the neighborhood. The old dismal passage and steps have gone, and the yard is paved and laid out as a poor children's gymnasium, but the sullen looking gate with the rust-eaten bars still remains.



Perry Manufacturing Company, Montpelier, Vermont – Polishing Machine Ad in *The Monumental News*, pp. 217



Concord Axle Company – Polishing Machine, Penacook, New Hampshire, Ad in *The Monumental News*, pp. 217



Granite City Polishing Machine Ad
W. A. Lane, Proprietor, Barre, Vermont, Ad in *The Monumental News*, pp. 221