

Abrasive Stones

FOR GENERAL AND SPECIAL PURPOSE STONING, FINISHING AND POLISHING OF MOLDS AND DIES

GENERAL PURPOSE STONES

These silicon carbide, vitrified bond stones are available in two types:

TYPE A: For use on steel prior to heat treating or for steel hardness lower than 40 HRC.

TYPE B: For steel hardness higher than 40 HRC. Ideal for restoring finish after heat treating.

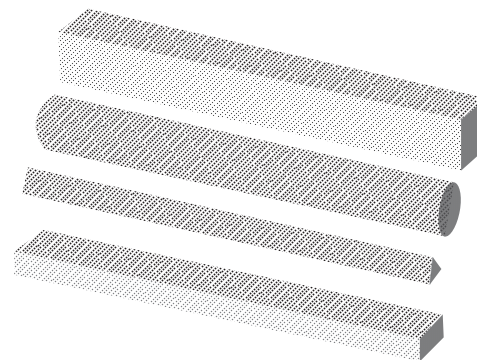
SPECIAL PURPOSE STONES

Available in three types:

TYPE E (EDM STONES): Aluminum oxide crystals in a medium hard vitrified bond, with a special resin treatment to improve cutting action on hard surface crusts, such as those produced by EDM.

TYPE M (MEDIUM OIL FILLED): Aluminum oxide crystals in a hard vitrified bond, with a special oil fill which eliminates the soaking often recommended for abrasive stones. The oil fill provides additional lubrication to prevent loading and assure optimum stock removal. Ideal for heat treated tool steels.

TYPE F (D-M-E FLEX): Aluminum oxide crystals in a hard resin bond provide some flexibility to reduce breakage. Ideal for polishing deep ribs and fine details.



GENERAL PURPOSE (TYPE A OR B)

RECTANGULAR			GRIT		
THK.	WIDTH	LGTH.	150 & 240	400	600
1/16	1/2	4"	•	•	•
1/8	1/2	4"	•	•	•
3/16	1/2	4"	•	•	•
1/4	3/4	4"	•	•	•
1/2	3/4	4"	•	•	•
1/2	1"	4"	•	•	•

GENERAL PURPOSE (TYPE A OR B)

SQUARE		GRIT		
SIZE & SHAPE	LGTH.	150 & 240	400	600
1/4 SQ	4"	•	•	•
3/8 SQ	4"	•	•	•
1/2 SQ	6"	•	•	•
3/4 SQ	6"	•	•	•

GENERAL PURPOSE (TYPE A OR B)

TRIANGULAR		GRIT		
SIZE & SHAPE	LGTH.	150 & 240	400	600
1/4 TRI	4"	•	•	•
1/2 TRI	4"	•	•	•

GENERAL PURPOSE (TYPE A OR B)

ROUND		GRIT		
SIZE & SHAPE	LGTH.	150 & 240	400	600
1/4 RD	4"	•	•	•
3/8 RD	4"	•	•	•
1/2 RD	4"	•	•	•

WHEN ORDERING, PLEASE SPECIFY:

- Quantity
- Size, Shape, Grit and Type
Example: (12) – 1/4 SQ x 4" – 400 GRIT-Type A

QUANTITY DISCOUNTS:

Discounts apply to current Net Prices. Types, sizes and grits may be mixed.
10 or more Less 15%

SPECIAL PURPOSE (TYPES E, M OR F)

For other stones (sized for use with profilers), see Page 41.

SHAPE AND SIZE			TYPE E (EDM STONES) GRIT					TYPE M (MEDIUM OIL FILLED) GRIT					TYPE F (D-M-E FLEX) GRIT				
RECTANGULAR																	
THICK.	WIDTH	LENGTH	150	240	320	400	600	150	240	320	400	600	150	240	320	400	600
1/16	1/4	4"	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
1/8	1/4	4"	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
1/8	1/2	4"	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
1/4	1/2	4"	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
SQUARE			GRIT					GRIT					GRIT				
SIZE AND SHAPE	LENGTH		150	240	320	400	600	150	240	320	400	600	150	240	320	400	600
1/8 SQ	4"		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
1/4 SQ	4"		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

Abrasive Stone Kit

Abrasive Stone Kit

This useful kit designed for the professional metal finisher contains a complete selection of 45 aluminum oxide special-purpose stones, plus one handheld stone holder. The special-purpose stones consist of:

- "Type E" (resin treated) for work on hard surface crusts such as EDM
- "Type M" (oil filled) for stoning heat-treated tool steels
- "Type F" (resin bonded) for added flexibility and break resistance when stoning deep ribs and fine details



ABRASIVE STONE KIT ITEM NUMBER: ASK-450

ABRASIVE STONE KIT INCLUDES

SHAPE AND SIZE			TYPE E [EDM STONES]	TYPE M (MEDIUM OIL FILLED)	TYPE F (D-M-E FLEX)
RECTANGULAR			1 EACH OF GRIT	1 EACH OF GRIT	1 EACH OF GRIT
THICK	WIDTH	LENGTH			
1/8"	1/4"	4"	150, 240, 320, 400, 600	150, 240, 320, 400, 600	150, 240, 320, 400, 600
1/8"	1/2"	4"	150, 240, 320, 400, 600	150, 240, 320, 400, 600	150, 240, 320, 400, 600
SQUARE			1 EACH OF GRIT	1 EACH OF GRIT	1 EACH OF GRIT
1/4" x 1/4"		4"	150, 240, 320, 400, 600	150, 240, 320, 400, 600	150, 240, 320, 400, 600

Abrasive Stone Holders

Abrasive Stone Holders

- Handheld and shank-mounted styles
- Provide excellent control and quick stone changes

The new line of abrasive stone holders provides the metal finisher with excellent control and convenience. They are precision molded of shock absorbing, impact resistant nylon 6-6, and feature a removable collar that locks the stones in place and permits quick stone changes. Shank mounted style is designed for use with the Minitor *Profiler 'R' as well as other reciprocating profilers.

Handheld style offers double end capacity.

* (1/8 shanks only)



HSH-400



SH-210



SH-220



SH-310



SH-320

ABRASIVE STONE HOLDERS

ITEM NUMBER	SHANK DIAMETER	ACCOMMODATE STONE SIZE
SH-210	(1/8) .125	1/8 x 1/4
SH-220	(1/8) .125	1/8 x 1/2 1/4 x 1/4
SH-310	(3/16) .185	1/8 x 1/4
SH-320	(3/16) .185	1/8 x 1/2 1/4 x 1/4
HSH-400 (Handheld Stone Holder)	None	1/16 x 1/2 1/8 x 1/2 1/4 x 1/4 1/8 x 1/4

QUANTITY DISCOUNTS:

Discounts apply to current Net Prices. Stone holder styles may be mixed.

3 or more Less 10%

Abrasive Stones

The stones are sized for use with D-M-E Stone Holders. They are available in three types of stones: VITRIFIED for general purpose finishing, RESIN for finishing EDM surfaces and ALUMINUM OXIDE for polishing. D-M-E abrasive stones can be used on pre-hardened, hardened and soft mold and die steels.



LENGTH (ALL STONES = 4")		GENERAL PURPOSE				EDM			FINE FINISH	
		SILICON-CARBIDE VITRIFIED BONDED TYPE V				SILICON-CARBIDE RESIN BONDED TYPE R			ALUMINUM OXIDE TYPE X	
THICKNESS	WIDTH	GRIT				GRIT			GRIT	
		150	240	400	600	120	220	320	600	900
1/8	3/8	•	•	•	•	•	•	•	•	•
3/16	3/8	•	•	•	•	•	•	•	—	—
1/4	3/8	•	•	•	•	•	•	•	—	—
1/8	1/2	•	•	•	•	•	•	•	—	—
3/16	1/2	•	•	•	•	•	•	•	—	—
1/4	1/2	•	•	•	•	•	•	•	•	•
3/8	1/2	•	•	•	•	•	•	•	•	•

For other shapes and sizes of abrasive stones, see page 50.

QUANTITY DISCOUNTS:

Discounts apply to current Net Prices.
Types, sizes and grits may be mixed.
10 or more Less 15%

WHEN ORDERING, PLEASE SPECIFY:

1. Quantity
2. Thickness, width, length, grit and type
Example: (16) 3/16 x 1/2 x 4", 220R