

EDM Polishing Stones



AM-8 Excellent ultrasonic stone, strong; holds shape



AS-9 Most popular EDM stone; great with profiler and hand stoning



Orange EDM Fast cutting action with consistent breakdown



Golden Star Offers superior breakdown characteristics and a smooth, silky finish

Specialty Stones



RASP Our most versatile all around finishing stone



PC Premium polishing stone for final finish work



T2 Excellent stone for stainless steel



T4 Engineered for finishing aluminum and soft metals



AO Aggressive oil treated stone for general mill removal and EDM



TH Performs well on all types of tool steels



900-F Very soft stone for super-fine finishing

General Purpose Stones



AM-2 General purpose stone; soft; fast breakdown



Die Stone Slightly harder than AM-2



AM-K White aluminum oxide stone good for machined surfaces



AS-H White aluminum oxide stone softer than AM-K



CS Fast-cutting, soft, black silicon carbide



CS-M Premium green silicon carbide, fast-cutting, medium hardness



CS-HD Harder stone than CS-M, excellent for hardened steel, 47-63Rc

Detail Stones



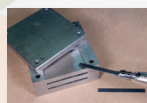
Cristone® Crystal Fiber Stone Tremendous bending strength and outstanding polishing efficiency



Ceramic Stones/Super Stones Very strong, used for EDM removal in ribs and slots



Ceramic Diamond Stones Combination of ceramic fibers and evenly distributed diamond particles



CNB-80 and CNB-120 Extremely aggressive advanced composite fiber; great for blending weld repairs

Polishing Stones - Applications



Type of Stone		Surface	Tool Steel	Aluminum	Non-Ferrous	Stainless Steel	EDM	Method	Hand	Profiler	Ultrasonic	Use	Wet	Dry	Breakdown	0 = Slow 5 = Fast	Hardness	0 = Soft 5 = Hard	
EDM Polishing Stones	AM-8		•				▲		•	•	•		•			2		4	
	AS-9		•				▲		•	•			•	•		3		3	
	Orange EDM		•				•		•	•			•	•		3		3	
	Golden Star		▲				▲		•	•			•			4		3	
General Purpose Stones	AM-2		▲	•	▲	•			•	•			•	•		4		2	
	Die Stone		•			•			•	•			•	•		3		3	
	AM-K		•	•					•	•			•	•		3		3	
	AS-H		•	•	•	•			•	•			•	•		4		2	
	CS		•		•				•				•	•		5		2	
	CS-M		•	•	▲				•	•			•	•		4		2	
	CS-HD		•			•	•		•	•			•	•		3		3	
Specialty Stones	RASP		•	•	•	•	▲		•	•			•	•		4		2	
	PC		•	•	•	•			•	•			•			4		3	
	T2		•			▲	•		•	•			•			2		4	
	T4		•	▲	•	•			•	•			•			4		3	
	TH		▲				•		•	•			•			3		3	
	AO		•				•		•	•			•			3		3	
	900-F		•						•				•			5		0	
Detail Stones	Ceramics		Detail Areas, Ribs & Slots										•	•					
	CNB - 80 & 120		Aggressive - Fast Cutting/Welds-Blending EDM										•						
	CRISTONE®		Extremely Strong and Thin - Fine Detail Polishing										•	•					

▲ Indicates most popular stone for the application

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