



GENERAL PURPOSE POLISHING STONES (TYPE G.P.)



- 6 DIFFERENT COMPOSITION MATERIALS -

G.P. Polishing Stones are a complete line of exceptionally fast cutting stones in grit range from 100-900 for the polishing on plastic molds, die-cast and stamping dies. Their extremely high density of abrasive particles will give you an even cutting action, and at the same time, minimize clogging and assure an even cutting polishing action. Stones which are used continuously should be kept in their liquid cutting agent to let them soak when not in use.

- STONE TYPE AND DESCRIPTION -

Type AM-2 (OLD A)- Green/Tan, Regular Aluminum Oxide. An excellent all around finishing stone, the type AM-2 was engineered for hand polishing all types of mold and die steel grades. These grades include: SAE 1030 tool steel, pre-heat treated P-20 (AISI 4130), H-13, S-7, and T-420. The soft action, as well as the perfect breakdown of the type AM-2, also permits pre-finishing on non-ferrous materials such as aluminum, beryllium, kirksite and high chrome/nickel content stainless steel. Finishing on aluminum, beryllium, kirksite and stainless steel beyond 320 mesh should be accomplished with waterproof type abrasive paper. The use of a lubricant is suggested. In most instances, use an oil free lubricant agent (odorless mineral spirits). Some expert polishers have claimed that using water when finishing kirksite will generate excellent results.

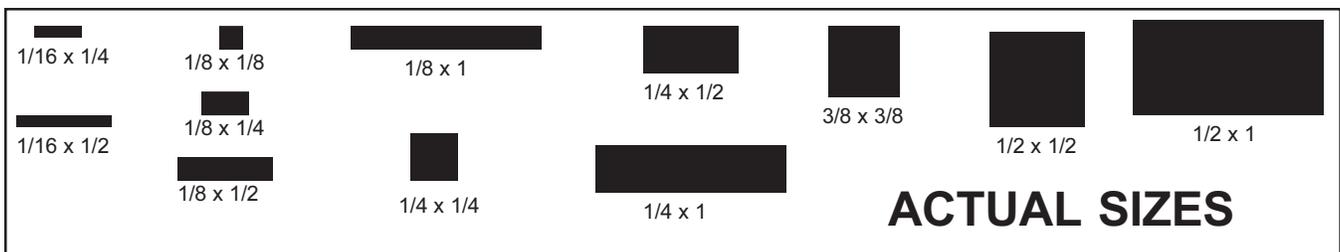
Type CS-M (OLD B)- Black, Black Silicon Carbide. The type CS-M is a soft mold stone designed to conform rapidly to a variety of details (shallow radii details or a series of "V" grooves, etc..). The breakdown is very rapid and is mostly applied where hand polishing is required. The CS-M series stones can be used on all tool steels, as well as for roughing out aluminum,, beryllium, brass and kirksite. Finish operations on all extremely high alloy mold and die steel, aluminum, beryllium, brass, kirksite, ect. should be performed with special "wet" abrasive paper only.

Type AM-8 (OLD C)- Dark Brown, White Aluminum Oxide. The type AM-8 stone is engineered for removing the hard scale generated by the EDM process on all types of mold & die steel. It is also an excellent tool for polishing sharp corners and small details by hand, and with the use of polishing machines. This stone works well when used with ultrasonic polishing machines. Although this stone can be used dry, most polishers prefer to use an oil free lubricant (odorless mineral spirit) when finishing.

Type AM-K (OLD D)- White, White Aluminum Oxide. The type AM-K series is a white aluminum oxide stone of medium hardness that performs well on all types of mold steel. Generally, this stone can be used dry for rough forming and removal of machine marks. Lubricants are used in the finer grit ranges.

Type 900F (OLD E)- White, Levigated Alumina. This stone has a super fine structure and excellent breakdown properties for final finishing prior to mirror (diamond polished) finishing. The type 900F works especially well on P-20 mold steel with a hardness ranging from 29 to 32 Rc. and is primarily used for hand finishing operations. Always use lubrication with this stone.

Type AB (OLD G)- Light Brown, Aluminum Oxide Resin Bonded. Finishing deep ribbed details and other hard to reach corners in a mold requires a special stone with added resilience. This special manufacturing process gives the type AB mold stone the flexibility required for finishing those hard to reach areas and small details. The type AB series mold stone can be used by hand or with profiler on all mold and die steel, conventional or pre-heat treated.



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