



## OVERVIEW: POLISHING STONES

Polishing stones	No.	Page	Grit	Surface					Machining				Material removal 0 = Slow 10 = Fast	Hardness 0 = Soft 10 = Hard	Wear 0 = Slow 10 = Fast	Use 0 = Roughing 10 = Finishing	
				Tool steel	Aluminium	Non-ferrous	Stainless steel	EDMed	Manual	File machine	Ultrasonic	Wet					Dry
EDM polishing stones	V 76104	#N01#	150 - 400	+				++	+	+	+	+	+	4	8	4	4
	V 76110	#N02#	150 - 1000	++				++	+	+		+		8	6	4	8
	V 76124	#N03#	180 - 400	+				+	+	+		+	+	6	6	6	6
Universal polishing stones	V 76108	#N04#	150 - 600	+	+	+	+		+	+		+		6	6	8	8
	V 76126	#N05#	180 - 600	+	+				+	+		+	+	6	6	6	4
	V 76128	#N06#	180 - 600	++	+	++	+	+	+	+		+	+	8	4	6	4
	V 76130	#N07#	150 - 600	+				+	+	+		+		6	6	6	6
	V 76131	#N08#	150 - 600	+				+	+	+		+		6	6	6	6
	V 76132	#N09#	150 - 600	+				+	+	+		+		6	6	6	6
Special polishing stones	V 76102	#N10#	80 - 180	++			+		+	+		+	+	6	6	6	2
	V 76106	#N11#	100 - 220	++				+	+	+		+	+	10	8	8	0
	V 76114	#N12#	180 - 600	+					+	+	+		+	2	8	2	4
	V 76152	#N13#	150 - 400	+	++	+	+		+	+		+		8	6	8	4
	V 76154	#N14#	220 - 900	+	+	+	+		+	+		+		6	6	8	10
	V 76182	#N15#	150 - 1000	+			+	+	+	+		+	+	6	6	6	4
	V 76184	#N16#	120 - 1000	+		++	+	+	+	+		+	+	8	4	8	8

### ALUMINIUM OXIDE:

- » Roundish grains
- » Ideal for unhardened and alloyed steel
- » Hardness: approx. 18,000 - 21,000 N/mm<sup>2</sup> (according to Knoop hardness test)

### SILICON CARBIDE:

- » Extremely sharp-edged grit
- » Ideal for hardened steel due to the high material removal rate
- » Hardness: approx. 25,000 N/mm<sup>2</sup> (according to Knoop hardness test)