

INSTRUCTIONS

for fine grinding tools made of FRIALIT®-DEGUSSIT® oxide ceramics

Fine, dense Whetstones made of **DEGUSSIT DD57** should be moistened with petroleum or cutting oil before use.

Clean with oil after use: using grease solvent, for example petroleum, xylene or similar. If necessary, any acid or alkaline solution can also be used.

For dry applications, the stone will remain clean considerably longer if usage traces are removed at regular intervals.

Regrinding the abrasive surfaces: Grind on a flat iron plate using a lapping emulsion of silicon carbide powder (with the following grain sizes) and water:

Type **fine**: Grain no. 400

Type **medium**: Grain no. 80

Type **coarse**: Grain no. 60

Refine or coarsen the surfaces of the **fine** stones with silicon carbide powder. Use grain no. 180 to coarsen the **fine stones**. The surface can be considerably enhanced or polished using very fine boron carbide or diamond powder. Use grain size no. 60 to coarsen fine grinding tools of **medium** type and no. 120 to enhance.

When treating surfaces, ensure that there is enough unused silicon carbide powder on the grinding plate, otherwise its effectiveness will be quickly lost during grinding.

Fine cuts and edges (e.g. knife blades, gouge stones, etc.) can be **sharpened or blunted** by pulling through another stone in FRIALIT-DEGUSSIT oxide ceramic.

Do not bend thin, fine grinding tools in FRIALIT-DEGUSSIT oxide ceramics.