



Workshop equipment

Polishing stones

Polishing stone	Item no.	Designation	Abrasive	Bond	Grit size	Application
	V 76102	Roughout polishing stone	Aluminium oxide	Ceramic, soft	80-180	Ideal for working on large workpieces; fast material removal due to soft bond; ideal for removing milling marks during roughing
	V 76104	EDM polishing stone	Aluminium oxide	Ceramic, hard	150-400	For removing EDM scale on every common hardened and unhardened tool steel; not suitable for finishing
	V 76106	Ruby-coloured polishing stone	Aluminium oxide	Ceramic, medium	100-220	Polishing stone for high material removal rate on unhardened tool steel; not suitable for finishing, as it is available in coarse grit only
	V 76108	Polishing stone	Aluminium oxide	Ceramic, medium	150-600	For cleaning or smoothing; for removing EDM scale; also suitable for very fine grinding; high resistance and dimensional stability
	V 76110	Gold-coloured EDM polishing stone	Aluminium oxide	Ceramic, hard	150-1000	Premium stone for EDM and milled surfaces; quick material removal; to create a silky and smooth surface
	V 76112	Polishing stone, stainless steel	Aluminium oxide	Ceramic, hard	150-1000	Special polishing stone for stainless steel and high-alloy tool steel; to create a silky matt surface
	V 76114	Polishing stone	Aluminium oxide	Synthetic resin, hard	180-600	Special polishing stone in resin bond; high resistance to fractures; ideal for deep grooves and fillets, when only a small part of the stone can be clamped; for unhardened tool steel
	V 76122	EDM polishing stone, TM	Aluminium oxide	Ceramic, medium	180-600	The Toolmaker is very suitable for levelling transitions as well as removing EDM scale and adapts quickly.
	V 76124	EDM polishing stone	Aluminium oxide	Ceramic, medium	180-400	For removing EDM scale on every common hardened and unhardened tool steel; adapts quickly; not suitable for finishing
	V 76126	General-purpose polishing stone	Aluminium oxide	Ceramic, medium	180-600	For polishing every common unhardened tool steel; high surface quality; suitable for finishing
	V 76128	General-purpose polishing stone	Aluminium oxide	Ceramic, soft	180-600	With high cutting performance for steel with high chromium and nickel content; also suitable for tool steel, aluminium, and copper; adapts optimally to the contours of the workpiece
	V 76130 □ V 76131 ○ V 76132 △	General-purpose polishing stone, oil-soaked	Aluminium oxide	Ceramic, medium	150-600	Grit with high cutting performance for polishing unhardened tool steel; ideal for technical polishing
	V 76150	Premium polishing stone	Aluminium oxide	Ceramic, medium	150-900	This premium stone combines a high material removal rate with the finest surface quality; can be used in dry or wet condition.
	V 76152	Special polishing stone	Aluminium oxide	Ceramic, soft	150-400	Special polishing stone particularly suited for aluminium; adapts quickly to the contours of the workpiece; barely leaves any scratches or marks on the surface
	V 76154	Fine-grit polishing stone	Aluminium oxide	Ceramic, soft	220-900	Special polishing stone for superfinishing hardened and unhardened steel as well as copper; not suitable for high material removal or removal of EDM scale
	V 76182	Extra polishing stone	Silicon carbide	Ceramic, hard	120-1000	Extra sharp grit with high cutting performance; suitable for steel with high chromium content and hardened steel with up to 63 HRC; leaves machining marks with grit size 600 or smaller
	V 76184	Extra polishing stone	Silicon carbide	Ceramic, soft	120-1000	Similar properties to V 76182, but with a soft bond; for steel with up to 55 HRC; adapts very quickly
	V 76296	Bench stone	Aluminium oxide	Ceramic, hard	120/320	For deburring and honing large surfaces; two grit sizes in one stone; can also be used as sharpening stone
	V 76298	Bench stone	Silicon carbide	Ceramic, hard	120/320	Same as V 76296, but from silicon carbide

Hardness

Silicon carbide	2500 kp/mm ²
Aluminium oxide	2100 kp/mm ²

Selection of the right grit size for EDM surfaces according to VDI 3400 (Ra)

EDM grade	27	24	21	18
Ra	2.2	1.6	1.12	0.8

Average roughness depth attainable in Ra

Grit size	180	220	320	400	600	900
Ra	2	1.6	0.8	0.4	0.3	0.2



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