

FINISHING STONE CHART



Diemaker Stones

- By far our most popular finishing stone.
- This Medium-hard, aluminum oxide stone combines the characteristics of fast cutting and moderate breakdown.
- Ideal for general purpose stoning on hard and soft grades of tool steel such as H-13, P-21, SS420 and pre-finishing on aluminum.
- The precise grit size of aluminum oxide is evenly distributed throughout each stone to ensure consistent cutting time and time again.
- Can be used by hand or in a reciprocating profiler.
- New 800 and 1200 grit stones have been added to the Diemaker line in select sizes.

"Fast cutting, leaves a good surface finish."

5/32" x 5/32" x 4"	
Grit	Item#
150	415-0010
220	415-0020
320	415-0030
400	415-0040
600	415-0060
800	415-0080
900	415-0090
1200	415-4080

1/4" x 1/16" x 4"	
Grit	Item#
220	405-2210
320	405-2310
400	405-2410
600	405-2610
900	405-2910
1200	405-4010

1/4" x 1/8" x 6"	
Grit	Item#
150	405-2101
220	405-2201
320	405-2301
400	405-2401
600	405-2601
800	405-2801
900	405-2901
1200	405-4001

1/4" x 1/4" x 6"	
Grit	Item#
150	405-2102
220	405-2202
320	405-2302
400	405-2402
600	405-2602
800	405-2802
900	405-2902
1200	405-4002

3/8" x 3/8" x 6"	
Grit	Item#
150	405-2108
220	405-2208
320	405-2308
400	405-2408
600	405-2608
800	405-2808
900	405-2908
1200	405-4008

1/2" x 1/16" x 6"	
Grit	Item#
150	405-2100
220	405-2200
320	405-2300
400	405-2400
600	405-2600
800	405-2800
900	405-2900
1200	405-4000

1/2" x 1/8" x 6"	
Grit	Item#
150	405-2103
220	405-2203
320	405-2303
400	405-2403
600	405-2603
800	405-2803
900	405-2903
1200	405-4003

1/2" x 1/4" x 6"	
Grit	Item#
150	405-2104
220	405-2204
320	405-2304
400	405-2404
600	405-2604
800	405-2804
900	405-2904
1200	405-4004

1/2" x 1/2" x 6"	
Grit	Item#
150	405-2105
220	405-2205
320	405-2305
400	405-2405
600	405-2605
800	405-2805
900	405-2905
1200	405-4005

1" x 1/8" x 6"	
Grit	Item#
320	405-2311
400	405-2411
600	405-2611

1" x 1/2" x 6"	
Grit	Item#
150	405-2107
220	405-2207
320	405-2307
400	405-2407
600	405-2607
900	405-2907

1" x 1" x 6"	
Grit	Item#
150	405-2106
220	405-2206
320	405-2306
400	405-2406
600	405-2606

1/4" x 1/4" x 6"	
Grit	Item#
150	405-2123
220	405-2223
320	405-2323
400	405-2423
600	405-2623
800	405-2823
900	405-2923
1200	405-4023

1/4" x 6"	
Grit	Item#
150	405-3102
220	405-3202
320	405-3302
400	405-3402
600	405-3602
900	405-3902

3/8" x 6"	
Grit	Item#
150	405-3108
220	405-3208
320	405-3308
400	405-3408
600	405-3608

1/2" x 6"	
Grit	Item#
150	405-3105
220	405-3205
320	405-3305
400	405-3405
600	405-3605

1/4" x 6"	
Grit	Item#
150	405-2192
220	405-2292
320	405-2392
400	405-2492

3/8" x 6"	
Grit	Item#
150	405-2198
220	405-2298
320	405-2398
400	405-2498



EDM Stones

- Remove the tough, hard scale left by the EDM process much faster than any of our other finishing stones.
- Contains extra-sharp premium-grade aluminum oxide for fast cutting action.
- Special clay bond enables the EDM stones to hold their shape well for working small details and sharp corners.
- Breaks down slowly, cuts fast and resists loading.

"To get into a cavity to remove the recast layer resulting from the EDM machine, use the Gesswein EDM stone which breaks through the recast much faster than any other stone!"

5/32" x 5/32" x 4"	
Grit	Item#
120	415-0610
180	415-0620
220	415-0622
320	415-0630
400	415-0640
600	415-0660

1/4" x 1/16" x 4"	
Grit	Item#
180	425-6110
220	425-6210
320	425-6310
400	425-6410
600	425-6610

1/4" x 1/8" x 6"	
Grit	Item#
120	425-6121
180	425-6181
220	425-6201
320	425-6301
400	425-6401
600	425-6601

1/4" x 1/4" x 6"	
Grit	Item#
120	425-6122
180	425-6182
220	425-6202
320	425-6302
400	425-6402
600	425-6602

3/8" x 3/8" x 6"	
Grit	Item#
120	425-6128
180	425-6188
220	425-6208
320	425-6308

1/2" x 1/16" x 6"	
Grit	Item#
120	425-6120
180	425-6180
220	425-6200
320	425-6300
400	425-6400
600	425-6600

1/2" x 1/8" x 6"	
Grit	Item#
120	425-6123
180	425-6183
220	425-6203
320	425-6303
400	425-6403
600	425-6603

1/2" x 1/4" x 6"	
Grit	Item#
120	425-6124
180	425-6184
220	425-6204
320	425-6304
400	425-6404
600	425-6604

1/2" x 1/2" x 6"	
Grit	Item#
120	425-6125
180	425-6185
220	425-6205
320	425-6305
400	425-6405
600	425-6605

1" x 1/2" x 6"	
Grit	Item#
120	425-6127
180	425-6187
220	425-6207
320	425-6307

1" x 1" x 6"	
Grit	Item#
120	425-6126
180	425-6186
220	425-6206
320	425-6306

1/4" x 1/4" x 6"	
Grit	Item#
120	425-0123
180	425-0183
220	425-0223
320	425-0323
400	425-0423
600	425-0623

1/4" x 6"	
Grit	Item#
120	425-0122
180	425-0182
220	425-0222
320	425-0302
400	425-0402
600	425-0602

1/4" x 6"	
Grit	Item#
120	425-6192
180	425-6292
320	425-6392

3/8" x 6"	
Grit	Item#
120	425-6198
180	425-6298
320	425-6398



EDM Blue Stones

- Harder than our regular EDM Stones and designed specifically to remove the tough, hard scale left by the EDM process.
- Contains extra-sharp premium-grade aluminum oxide for fast cutting action plus a small amount of cobalt blue for added hardness.
- Breaks down slowly and cuts fast.
- Resists breakage and specifically designed for use in reciprocating profilers.

"The Gesswein EDM Blue stones don't break down as fast as other stones saving you wasted time of having to dress the stone often."

5/32" x 5/32" x 4"	
Grit	Item#
120	415-6010
180	415-6020
220	415-6022
320	415-6030
400	415-6040
600	415-6060

1/4" x 1/16" x 4"	
Grit	Item#
120	424-6121
180	424-6181
220	424-6201
320	424-6301
400	424-6401
600	424-6601

1/4" x 1/8" x 6"	
Grit	Item#
120	424-6122
180	424-6182
220	424-6202
320	424-6302
400	424-6402
600	424-6602

1/2" x 1/16" x 6"	
Grit	Item#
120	424-6120
180	424-6180
220	424-6200
320	424-6300
400	424-6400
600	424-6600

1/2" x 1/8" x 6"	
Grit	Item#
120	424-6123
180	424-6183
220	424-6203
320	424-6303
400	424-6403
600	424-6603

1/2" x 1/4" x 6"	
Grit	Item#
120	424-6124
180	424-6184
220	424-6204
320	424-6304
400	424-6404
600	424-6604

1/4" x 6"	
Grit	Item#
120	424-0122
180	424-0182
320	424-0302



Oil-Treated Stones

- Medium-hard stone with white aluminum oxide soaked with oil – can be used without additional lubrication.</



RA Stones

- Aluminum oxide abrasive bonded together with a unique organic resin bond gives these stones great resiliency.
- Retain their shape and have a flexing capability, making them resistant to breakage even during heavy use.
- Leave a finer finish with less stock removal than other stones of the same grit.
- Can be used by hand, in a profiler or in an ultrasonic polisher on all mold and die steels.

"Ideal for finishing slots, deep ribs and other hard-to-reach mold areas and can also be used to remove EDM scale."



GP Stones

- Made of extra-sharp pure white aluminum oxide grains in a specially formulated bond & a proprietary treatment.
- Cuts well, holds their shape and resists loading.
- Suitable for use on both EDM and machined surfaces of all tool and hardened steels.

"Polishers will notice the special treatment provides a lubricating effect."



Premium White Stones

- Pure white premium-grade aluminum oxide stones.
- Specially formulated to be load-resistant.
- Can be used on all steels, from the hard A2, D2, and M2 to the softer P20, 420XX, M13 and S7.
- Moderate breakdown, retain their shape well.
- Can be used in a profiler or ultrasonic polisher.

"Semi-hard; good choice for finishing details."



Super Fine Stones

- Contain levigated (finely powdered) alumina.
- One of our "softest" stones for finishing steel surfaces — they break down very rapidly and do not scratch.
- An excellent choice for P20 and 420SS.
- Not quite as soft as our Ultra-Soft stones.

"Super Fine Stones provide a great final finish or use them as a pre-finish prior to using diamond compound."



Ultra-Soft Stones

- Aluminum oxide abrasive with a special bonding agent designed for very rapid breakdown.
- Formulated for soft metals, stainless steel, aluminum, brass, beryllium and kirksite.
- Cuts fast without loading.

"Can be easily shaped for finishing contours."



Rough Out Stones

- Large, coarse, relatively soft stones containing aluminum oxide.
- Cuts fast with rapid breakdown.
- Quickly remove rough scratches and machine tool marks.
- A good choice for roughing surfaces of larger molds and dies.

"Ideal for 'hogging' out large amounts of material prior to finishing."

Which Gesswein Stone Should I Use?

Use this chart to determine which finishing stone is right for you based upon the type of surface and application.

Stone Application Chart

Surface Type	Diemaker	EDM	EDM Blue	Oil Treated	Premium White	RA	GP	Moldmaker	Mold Maker Plus	Super Fine	Ultra Soft	Rough Out	Ceramic Diamond Stones	Ceramic	Ruby
All Tool Steels	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Heat Treated Tool Steel	•					•						•			•
EDM Surface		•	•	•	•	•	•						•		
Machined Surface	•			•	•		•					•	•		
Stainless Steel	•			•				•	•			•	•		
Aluminum								•	•	•	•	•	•	•	
Non-Ferrous								•	•	•	•	•	•	•	
High Polishing										•	•	•	•		
Rough Grinding										•	•	•	•		
Carbide													•		•

• Red dot indicates the most commonly used for each surface

5/32" x 5/32" x 4"	
Grit	Item#
180	415-0410
220	415-0420
320	415-0430
400	415-0440
600	415-0460

1/4" x 1/8" x 6"	
Grit	Item#
90	420-4091
120	420-4121
180	420-4181
220	420-4201
320	420-4301
400	420-4401
600	420-4601

1/4" x 1/4" x 6"	
Grit	Item#
90	420-4092
120	420-4122
180	420-4182
220	420-4202
320	420-4302
400	420-4402
600	420-4602

1/2" x 1/16" x 6"	
Grit	Item#
90	420-4090
120	420-4120
180	420-4180
220	420-4200
320	420-4300
400	420-4400
600	420-4600

1/2" x 1/8" x 6"	
Grit	Item#
90	420-4093
120	420-4123
180	420-4183
220	420-4203
320	420-4303
400	420-4403
600	420-4603

1/2" x 1/4" x 6"	
Grit	Item#
90	420-4094
120	420-4124
180	420-4184
220	420-4204
320	420-4304
400	420-4404
600	420-4604

5/32" x 4"	
Grit	Item#
320	420-0033



5/32" x 5/32" x 4"	
Grit	Item#
150	415-0315
180	415-0318
220	415-0320
320	415-0330
400	415-0340
600	415-0360

1/4" x 1/8" x 6"	
Grit	Item#
150	406-6151
180	406-6181
220	406-6201
320	406-6301
400	406-6401
600	406-6601

1/4" x 1/4" x 6"	
Grit	Item#
150	406-6152
180	406-6182
220	406-6202
320	406-6302
400	406-6402
600	406-6602

1/2" x 1/8" x 6"	
Grit	Item#
150	406-6153
180	406-6183
220	406-6203
320	406-6303
400	406-6403
600	406-6603

1/2" x 1/4" x 6"	
Grit	Item#
150	406-6154
180	406-6184
220	406-6204
320	406-6304
400	406-6404
600	406-6604

1/4" x 1/4" x 6"	
Grit	Item#
150	406-1523
180	406-1823
220	406-1223
320	406-1323
400	406-1423
600	406-1623

1/4" x 6"	
Grit	Item#
150	406-0152
180	406-0182
220	406-0222
320	406-0322
400	406-0402
600	406-0602

5/32" x 5/32" x 4"	
Grit	Item#
220	415-5002
320	415-5003
400	415-5004
600	415-5006

1/4" x 1/16" x 4"	
Grit	Item#
220	407-5210
320	407-5310
400	407-5410

1/4" x 1/8" x 6"	
Grit	Item#
100	407-5101
150	407-5151
220	407-5201
320	407-5301
400	407-5401
600	407-5601

1/4" x 1/4" x 6"	
Grit	Item#
100	407-5102
150	407-5152
220	407-5202
320	407-5302
400	407-5402
600	407-5602

1/2" x 1/8" x 6"	
Grit	Item#
100	407-5103
150	407-5153
220	407-5203
320	407-5303
400	407-5403
600	407-5603

1/2" x 1/4" x 6"	
Grit	Item#
100	407-5104
150	407-5154
220	407-5204
320	407-5304
400	407-5404
600	407-5604

Gesswein
Finishing Stones
are Proudly made in the U.S.A.

Stone Holders

Pencil Stone Holder

Item# #403-0050

For 5/32" square

Double Ender Holder

Blue #403-0101
Black #403-0102
Red #403-0103

Up to 1/4" x 1/4" square

LT Stone Holder

Item# #403-1020

Holds 1/8" x 1/4", 1/8" x 1/2", 1/4" x 1/4"

Adjustable Stone Holder – 3mm Shank

Item# #403-1000

Up to 1/4" thickness

T-38 Stone Holder – 3mm Shank

Item# #403-1010

Up to 3/8" x 1/2" wide

Go to gesswein.com for our full line of stone holders.

Stone Sets

Gesswein® 12-Piece Diemaker Finishing Stone Set #405-2060
Gesswein® 20-Piece Hybrid Stone Set #405-2086
Gesswein® 62-Piece Finishing Stone Set #405-2053

Go to gesswein.com for our full line of stone sets.

Gesswein® Stoning and Lubricating Oil

1 Pint (wide-mouth glass container) #800-0100
1 Gallon #800-0110



Super Ceramic Stones

Choose from flat and round sizes. For use with our Ultramax Ultrasonic handpieces, Power Hand 2X reciprocating and rotary handpieces, or by hand.

FLAT	Emerald (120 grit)	Gold (180 grit)	Lt. Brown (300 grit)	Orange (400 grit)	Brown (600 grit)	Blue (800 grit)	White (1000 grit)	Red (1200 grit)
Size (mm)	Item#	Item#	Item#	Item#	Item#	Item#	Item#	Item#
0.5 x 4 x 100	351-0301	351-0209	351-0204	351-0206	351-0201	351-0226	351-0227	351-0228
0.8 x 4 x 100	351-0304	351-0219	351-0235	351-0236	351-0004	351-0005	351-0010	351-0015
1 x 2 x 100	351-0307	351-0274	351-0275	351-0276	351-0277	351-0278	351-0279	351-0280
1 x 4 x 100	351-0308	351-0224	351-0241	351-0242	351-0036	351-0035	351-0040	351-0045
1 x 6 x 100	351-0309	351-0048	351-0243	351-0244	351-0049	351-0050	351-0055	351-0060
ROUND								
3 x 50mm	351-0317	351-0157	351-0196	351-0197	351-0198	351-0200	351-0205	351-0210
1/8" x 2"	351-0319	351-0158	351-0217	351-0218	351-0211	351-0212	351-0213	351-0214

Made in Japan.

For our full line of Ceramic Stones see our catalog or go to: www.gesswein.com

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Gesswein®
The Right Tools Since 1914