

Ceramic Lap and Spray Diamond INSTRUCTIONS

The ceramic lap has an ideal surface for polishing tool steel and carbide tools. It is extremely smooth and hard enough to resist damage from tool pressure during use. It is virtually impervious to wear - - but **DO NOT DROP IT!** Like fine china, it will break. Fine diamond particles accomplish the cutting (polishing) of the tool surface.

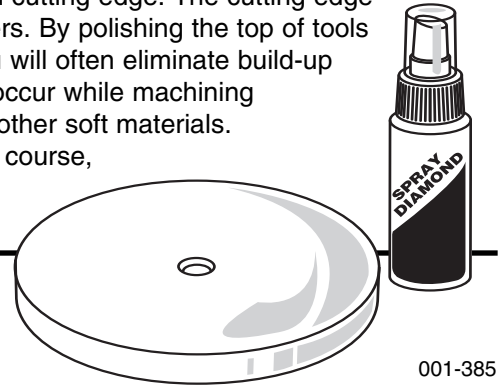
TO CHARGE THE LAP.. carefully mount it on the machine and turn it "on". Be careful no to over-tighten the mounting screw which could break the lap. **SHAKE the spray diamond container vigorously immediately before each application.** Diamond particles quickly settle out of the solution, so shaking the container immediately before each use is necessary.

Hold the spray nozzle 3" - 4" from the rotating lap surface and spray a band near the outer edge of the lap surface. About a one second burst is adequate. You will be mostly using the outer 1" - 2" of the lap surface, so concentrate the diamond there. Cutting action will gradually decrease through use and a short burst of spray will then be needed.

Also during use, the lap surface will gradually turn black from the metal debris. This coating will build up and eventually affect smooth polishing action. When it becomes loaded, scrub the surface with a cleanser (Ajax, Comet, etc.) to remove the debris and then recharge with diamond spray.

You can speed up the polishing job considerably by proper selection of clearance angles on your tools. Rough the tool with a 260 or 360 wheel at 1° greater clearance than the desired angle. Next, prefinish the tool at the same angle using a 600 or finer wheel. Now adjust the tool table to the final desired angle and use the ceramic lap with a diamond spray charge to finish just the needed cutting edge. The cutting edge is all that matters. By polishing the top of tools and inserts you will often eliminate build-up problems that occur while machining aluminum and other soft materials.

You can, of course, use both sides of the lap.



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