

Gesswein® Finishing Stones For Mold & Die Polishing

For over 100 years, leading metalworkers have come to know and rely upon Gesswein for the best in abrasives.

We are proud Gesswein stones are the unquestionable choice of leading mold and die craftsmen worldwide. Their trust and confidence in us is due to:

- **Demanding Standards:** For each stone, careful grading eliminates oversized grains and special blending operations ensure absolute uniformity of finish, whatever your application.
- **Exceptional Quality Control:** Working closely with the best suppliers in the industry as well as making blocks and stones at our facility to ensure the highest standards are consistently met.
- **Quality Ingredients:** Our stones are composed of the purest ingredients.
 Aluminum Oxide: An extremely tough abrasive; each grain holds its sharpness very well.
 Levigated Alumina: A very fine form of aluminum oxide (stones made of this formulation are softer).
 Silicon Carbide: Extremely sharp and brittle (these man-made particles are designed to shatter and expose new, sharp edges).



As an industry pioneer, we have long known an important key to continued success—provide a complete range of products that allows polishers to choose the perfect stone for each task. We continue to develop new products to meet the changing needs of our customers.



Add a **STONE CHART** to your order and receive it at no charge. (\$10.00 value)

Use the chart below to determine which finishing stone is right for you based upon the type of surface or call 800-544-2043 and speak with our technical staff to choose the best stone for your application.

Surface Type	Diemaker	EDM	EDM Blue	Oil Treated	Premium White	RA	General Purpose	Mold-maker	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													•		◆

◆ Blue diamond indicates the most commonly used for each application.

Which Gesswein® Stone is Right for Your Job?



The chart below contains helpful information to guide you in selecting the appropriate finishing stone based on your application. Stones are listed from hardest to softest.



Type	Abrasive Material	Characteristics & Usage	Page (s)
RA 	Aluminum oxide	Special breakdown-resistant resin bond. Can be used aggressively and be ground to a sharp edge or for use on hard-to-reach areas such as slots and ribs.	12
EDM Blue 	Premium aluminum oxide	New harder formulation of our EDM stones especially designed to handle the high-speed back-and-forth motion of a profiler or ultrasonic machine. Superior for removing the hardest EDM scale. Designed for use on hard surfaces at high speed. Holds shape very well.	8
EDM 	Premium aluminum oxide	Our best stones for fast removal of EDM scale. They have sharp points and edges to cut and dig into material to better remove it. Use EDM for more aggressive polishing.	6-7
General Purpose 	White aluminum oxide	This soft stone acts harder due to a proprietary treatment. Experienced polishers will find this formula cuts fast, wears slowly and holds its shape well.	13
Premium White 	Premium aluminum oxide	Semi-hard, good for general purpose mold polishing. Special treatment provides load resistance and a lubricating effect.	14
Oil-Treated 	White aluminum oxide	Soaked in oil solution to prevent loading. Fast-cutting with moderate breakdown. Popular general purpose stones often used for EDM scale removal. Can be used without stoning oil.	9
Diemaker 	Aluminum oxide	Extremely popular. For general purpose stoning on all types of steel. Fast-cutting, wears at an average rate and gives a good surface finish.	4-5
Moldmaker Plus 	Premium silicon carbide	Green silicon carbide. Medium stone with slower breakdown characteristics than our standard Moldmaker stones.	11
Moldmaker 	Silicon carbide	Easy to shape stone for contour polishing. Medium-soft, nonloading and fast-cutting with rapid breakdown.	10
Rough Out 	Aluminum oxide	Coarse, fast-cutting with rapid breakdown. For deep machining marks. Also good for rust removal.	15
Super Fine 	Levigated alumina	Our softest and finest stones for steel surfaces. They don't scratch and are nonloading. For final finish before using diamond compound.	16
Ultra-Soft 	White aluminum oxide	Formulated for polishing aluminum, stainless steel, beryllium, kirkcote and other soft metals. Very soft, fast-cutting and nonloading with very rapid breakdown.	16

IMPORTANT: Abrasive stones break down during mold and die polishing, grinding, tool sharpening, and dressing of cutting & grinding wheels. The resulting dust is classified by OSHA as inert or nuisance dust. Please consult the Material Safety Data Sheet for each stone; data provided therein pertains primarily to the dust produced during and after use. Please note that hazards may change when abrasive stones are used in conjunction with solvents, cutting fluids or other chemicals. For more complete information, consult the Material Safety Data Sheets of chemical products used with abrasive stone products.

Gesswein® Diemaker Stones

- Medium-hard aluminum oxide stones combine the characteristics of fast cutting and moderate breakdown.
- Ideal for general purpose stoning on hard and soft tool steels such as H-13, P-21, SS420 and pre-finishing.
- One of our most popular finishing stones.
- **New 100 grit stones in most sizes.**
- Sold in full box quantities of 6 or 12 each as indicated.



See Our Sampler Sets
on pages 19-21

IMPORTANT: See dust warning on page 3.

5/32" x 5/32" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
01	100	415-0001			
1	150	415-0010			
2	220	415-0020			
3	320	415-0030			
4	400	415-0040			
6	600	415-0060			
8	800	415-0080			
9	900	415-0090			
1200	1200	415-4080			

1/4" x 1/16" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
2210	220	405-2210			
2310	320	405-2310			
2410	400	405-2410			
2610	600	405-2610			
2910	900	405-2910			
4010	1200	405-4010			

1/4" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1801	100	405-1801			
2101	150	405-2101			
2201	220	405-2201			
2301	320	405-2301			
2401	400	405-2401			
2601	600	405-2601			
2801	800	405-2801			
2901	900	405-2901			
4001	1200	405-4001			

1/4" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1802	100	405-1802			
2102	150	405-2102			
2202	220	405-2202			
2302	320	405-2302			
2402	400	405-2402			
2602	600	405-2602			
2802	800	405-2802			
2902	900	405-2902			
4002	1200	405-4002			

3/8" x 3/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1808	100	405-1808			
2108	150	405-2108			
2208	220	405-2208			
2308	320	405-2308			
2408	400	405-2408			
2608	600	405-2608			
2808	800	405-2808			
2908	900	405-2908			
4008	1200	405-4008			

1/2" x 1/16" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1800	100	405-1800			
2100	150	405-2100			
2200	220	405-2200			
2300	320	405-2300			
2400	400	405-2400			
2600	600	405-2600			
2900	900	405-2900			
4000	1200	405-4000			

1/2" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1803	100	405-1803			
2103	150	405-2103			
2203	220	405-2203			
2303	320	405-2303			
2403	400	405-2403			
2603	600	405-2603			
2803	800	405-2803			
2903	900	405-2903			
4003	1200	405-4003			

1/2" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1804	100	405-1804			
2104	150	405-2104			
2204	220	405-2204			
2304	320	405-2304			
2404	400	405-2404			
2604	600	405-2604			
2804	800	405-2804			
2904	900	405-2904			
4004	1200	405-4004			

Sold in full box quantities of 6 or 12 each as indicated
by please order in these multiples.

1/2" x 1/2" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
1805	100	405-1805			
2105	150	405-2105			
2205	220	405-2205			
2305	320	405-2305			
2405	400	405-2405			
2605	600	405-2605			
2805	800	405-2805			
2905	900	405-2905			
4005	1200	405-4005			

Hybrid, 1/4" x 1/4" x 6"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
1823H	100	405-1823			
2123H	150	405-2123			
2223H	220	405-2223			
2323H	320	405-2323			
2423H	400	405-2423			
2623H	600	405-2623			
2823H	800	405-2823			
2923H	900	405-2923			
4023H	1200	405-4023			

1" x 1/8" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
1811	100	405-1811			
2111	150	405-2111			
2211	220	405-2211			
2311	320	405-2311			
2411	400	405-2411			
2611	600	405-2611			

Round, 1/4" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
3102	150	405-3102			
3202	220	405-3202			
3302	320	405-3302			
3402	400	405-3402			
3602	600	405-3602			
3902	900	405-3902			

1" x 1/4" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
1812	100	405-1812			
2112	150	405-2112			
2212	220	405-2212			
2312	320	405-2312			
2412	400	405-2412			
2612	600	405-2612			

Round, 3/8" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
3108	150	405-3108			
3208	220	405-3208			
3308	320	405-3308			
3408	400	405-3408			
3608	600	405-3608			

1" x 1/2" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
1807	100	405-1807			
2107	150	405-2107			
2207	220	405-2207			
2307	320	405-2307			
2407	400	405-2407			
2607	600	405-2607			
2907	900	405-2907			

Round, 1/2" x 6"			12pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
3105	150	405-3105			
3205	220	405-3205			
3305	320	405-3305			
3405	400	405-3405			
3605	600	405-3605			

Triangular, 1/4" x 6"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
21T2	150	405-2192			
22T2	220	405-2292			
23T2	320	405-2392			
24T2	400	405-2492			

1" x 1" x 6"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
1806	100	405-1806			
2106	150	405-2106			
2206	220	405-2206			
2306	320	405-2306			
2406	400	405-2406			
2606	600	405-2606			

Triangular, 3/8" x 6"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
21T8	150	405-2198			
22T8	220	405-2298			
23T8	320	405-2398			
24T8	400	405-2498			

Sold in full box quantities of 6 or 12 each as indicated by 6pc 12pc please order in these multiples.

IMPORTANT: See dust warning on page 3.

Gesswein® 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.
- Sold in full box quantities of 6 or 12 each as indicated.



IMPORTANT: See dust warning on page 3.

See Our Sampler Sets
on pages 19-21

5/32" x 5/32" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
61	120	415-0610			
62	180	415-0620			
622	220	415-0622			
63	320	415-0630			
64	400	415-0640			
66	600	415-0660			

3/8" x 3/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6128	120	425-6128			
6188	180	425-6188			
6208	220	425-6208			
6308	320	425-6308			

1/4" x 1/16" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6110	180	425-6110			
6210	220	425-6210			
6310	320	425-6310			
6410	400	425-6410			
6610	600	425-6610			

1/2" x 1/16" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6120	120	425-6120			
6180	180	425-6180			
6200	220	425-6200			
6300	320	425-6300			
6400	400	425-6400			
6600	600	425-6600			

1/4" x 1/8" x 6"



EACH Prices

Style	Grit	Item#1	12-60	72-132	144+
6121	120	425-6121			
6181	180	425-6181			
6201	220	425-6201			
6301	320	425-6301			
6401	400	425-6401			
6601	600	425-6601			

1/2" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6123	120	425-6123			
6183	180	425-6183			
6203	220	425-6203			
6303	320	425-6303			
6403	400	425-6403			
6603	600	425-6603			

1/4" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6122	120	425-6122			
6182	180	425-6182			
6202	220	425-6202			
6302	320	425-6302			
6402	400	425-6402			
6602	600	425-6602			

1/2" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6124	120	425-6124			
6184	180	425-6184			
6204	220	425-6204			
6304	320	425-6304			
6404	400	425-6404			
6604	600	425-6604			

Sold in full box quantities of 12 each as indicated by please order in these multiples.

		1/2" x 1/2" x 6"		6pc EACH Prices		
Style	Grit	Item#		6-66	72-138	144+
6125	120	425-6125				
6185	180	425-6185				
6205	220	425-6205				
6305	320	425-6305				
6405	400	425-6405				
6605	600	425-6605				

		Round, 1/4" x 6"		6pc EACH Prices		
Style	Grit	Item#		6-66	72-138	144+
E122	120	425-0122				
E182	180	425-0182				
E222	220	425-0222				
E302	320	425-0302				
E402	400	425-0402				
E602	600	425-0602				

		1" x 1/2" x 6"		6pc EACH Prices		
Style	Grit	Item#		6-66	72-138	144+
6127	120	425-6127				
6187	180	425-6187				
6207	220	425-6207				
6307	320	425-6307				

		Triangular, 1/4" x 6"		12pc EACH Prices		
Style	Grit	Item#		12-60	72-132	144+
61T2	120	425-6192				
62T2	180	425-6292				
63T2	320	425-6392				

		1" x 1" x 6"		6pc EACH Prices		
Style	Grit	Item#		6-66	72-138	144+
6126	120	425-6126				
6186	180	425-6186				
6206	220	425-6206				
6306	320	425-6306				

		Triangular, 3/8" x 6"		12pc EACH Prices		
Style	Grit	Item#		12-60	72-132	144+
61T8	120	425-6198				
62T8	180	425-6298				
63T8	320	425-6398				

		Hybrid, 1/4" x 1/4" x 6"		12pc EACH Prices		
Style	Grit	Item#		12-60	72-132	144+
123H	120	425-0123				
183H	180	425-0183				
223H	220	425-0223				
323H	320	425-0323				
423H	400	425-0423				
623H	600	425-0623				



Sold in full box quantities of 6 or 12 each as indicated by please order in these multiples.

IMPORTANT: See dust warning on page 3.

Gesswein® EDM Blue Stones

- Harder than our regular EDM Stones and designed to remove the tough, hard scale left by the EDM process.
- Breaks down slowly and cuts fast.
- Maintains shape, saving you time.
- Contains extra-sharp premium-grade aluminum oxide for fast cutting action plus a small amount of cobalt blue for added hardness.
- Resists breakage and specifically designed for use in reciprocating profilers.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.



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5/32" x 5/32" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
61B	120	415-6010			
62B	180	415-6020			
622B	220	415-6022			
63B	320	415-6030			
64B	400	415-6040			
66B	600	415-6060			

1/4" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6121B	120	424-6121			
6181B	180	424-6181			
6201B	220	424-6201			
6301B	320	424-6301			
6401B	400	424-6401			
6601B	600	424-6601			

1/4" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6122B	120	424-6122			
6182B	180	424-6182			
6202B	220	424-6202			
6302B	320	424-6302			
6402B	400	424-6402			
6602B	600	424-6602			

1/2" x 1/16" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
6120B	120	424-6120			
6180B	180	424-6180			
6200B	220	424-6200			
6300B	320	424-6300			
6400B	400	424-6400			
6600B	600	424-6600			

1/2" x 1/8" x 6"



Style	Grit	Item#	12-60	72-132	144+
6123B	120	424-6123			
6183B	180	424-6183			
6203B	220	424-6203			
6303B	320	424-6303			
6403B	400	424-6403			
6603B	600	424-6603			

1/2" x 1/4" x 6"



Style	Grit	Item#	12-60	72-132	144+
6124B	120	424-6124			
6184B	180	424-6184			
6204B	220	424-6204			
6304B	320	424-6304			
6404B	400	424-6404			
6604B	600	424-6604			

1" x 1/2" x 6"



Style	Grit	Item#	6-66	72-138	144+
6127	120	424-6127			
6187	180	424-6187			
6207	220	424-6207			
6307	320	424-6307			

Round, 1/4" x 6"



Style	Grit	Item#	6-66	72-138	144+
E122B	120	424-0122			
E182B	180	424-0182			
E302B	320	424-0302			



Sold in full box quantities of 6 or 12 each as indicated by please order in these multiples.

Gesswein® Oil-Treated Stones

- Excellent for machined surfaces.
- Fine cutting ability.
- Medium-hard stone with white aluminum oxide soaked with oil.
Can be used without additional lubrication.
- Holds shape well for finishing mold details.
- Moderate breakdown.
- Often used for EDM removal. Special oil treatment prevents loading.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.

See Our Sampler Sets
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ABRASIVES-FINISHING STONES

$\frac{5}{32}'' \times \frac{5}{32}'' \times 4''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
51	120	415-0510			
50	180	415-0518			
52	220	415-0520			
53	320	415-0530			
54	400	415-0540			
56	600	415-0560			
58	800	415-0580			
59	1200	415-0590			

$\frac{1}{2}'' \times \frac{1}{4}'' \times 6''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5104	120	435-5104			
5004	180	435-5004			
5204	220	435-5204			
5304	320	435-5304			
5404	400	435-5404			
5604	600	435-5604			
5804	800	435-5804			
5904	1200	435-5904			

$\frac{1}{4}'' \times \frac{1}{8}'' \times 6''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5101	120	435-5101			
5001	180	435-5001			
5201	220	435-5201			
5301	320	435-5301			
5401	400	435-5401			
5601	600	435-5601			
5801	800	435-5801			
5901	1200	435-5901			

Hybrid, $\frac{1}{4}'' \times \frac{1}{4}'' \times 6''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5123H	120	435-5123			
5023H	180	435-5023			
5223H	220	435-5223			
5323H	320	435-5323			
5423H	400	435-5423			
5623H	600	435-5623			
5823H	800	435-5823			
5923H	1200	435-5923			

$\frac{1}{4}'' \times \frac{1}{4}'' \times 6''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5102	120	435-5102			
5002	180	435-5002			
5202	220	435-5202			
5302	320	435-5302			
5402	400	435-5402			
5602	600	435-5602			
5802	800	435-5802			
5902	1200	435-5902			

Round, $\frac{1}{4}'' \times 6''$

6pc EACH Prices

Style	Grit	Item#	6-66	72-138	144+
E122B	120	435-0122			
E182B	180	435-0182			
E222B	220	435-0222			
E302B	320	435-0302			
E402B	400	435-0402			
E602B	600	435-0602			
E802B	800	435-0802			
E902B	1200	435-0902			

$\frac{1}{2}'' \times \frac{1}{8}'' \times 6''$

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5103	120	435-5103			
5003	180	435-5003			
5203	220	435-5203			
5303	320	435-5303			
5403	400	435-5403			
5603	600	435-5603			
5803	800	435-5803			
5903	1200	435-5903			



Sold in full box quantities of 12 each as indicated by **12pc** please order in these multiples.

Gesswein® Moldmaker Stones

- Medium-soft stone with silicon carbide abrasive designed to break down rapidly and expose fresh edges.
- Suitable for working on all types of steels as well as roughing out nonferrous metals.
- Ideal for blending, detailing radii and following contours.
- Resists loading.
- Sold in full box quantities of 6 or 12 each as indicated.



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on pages 19-21

IMPORTANT: See dust warning on page 3.

1/4" x 1/16" x 4"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
100	100	410-0100			
150	150	410-0150			
200	220	410-0200			
300	320	410-0300			
400	400	410-0400			
600	600	410-0600			

5/32" x 5/32" x 4"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
10	100	415-1000			
15	150	415-1001			
20	220	415-1002			
30	320	415-1003			
40	400	415-1004			
60	600	415-1006			

1/4" x 1/8" x 6"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1101	100	410-1101			
1151	150	410-1151			
1201	220	410-1201			
1301	320	410-1301			
1401	400	410-1401			
1601	600	410-1601			

1/4" x 1/4" x 6"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1102	100	410-1102			
1152	150	410-1152			
1202	220	410-1202			
1302	320	410-1302			
1402	400	410-1402			
1602	600	410-1602			

1/2" x 1/8" x 6"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1103	100	410-1103			
1153	150	410-1153			
1203	220	410-1203			
1303	320	410-1303			
1403	400	410-1403			
1603	600	410-1603			

1/2" x 1/4" x 6"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1104	100	410-1104			
1154	150	410-1154			
1204	220	410-1204			
1304	320	410-1304			
1404	400	410-1404			
1604	600	410-1604			

1/2" x 1/2" x 6"

6pc EACH Prices

Style	Grit	Item#	6-66	72-138	144+
1105	120	410-1105			
1155	150	410-1155			
1205	220	410-1205			
1305	320	410-1305			
1405	400	410-1405			
1605	600	410-1605			

1" x 1" x 6"

6pc EACH Prices

Style	Grit	Item#	6-66	72-138	144+
1106	100	410-1106			
1156	150	410-1156			
1206	220	410-1206			
1306	320	410-1306			
1406	400	410-1406			
1606	600	410-1606			

Hybrid, 1/4" x 1/4" x 6"

12pc EACH Prices

Style	Grit	Item#	12-60	72-132	144+
023H	100	410-0023			
123H	150	410-0123			
223H	220	410-0223			
323H	320	410-0323			
423H	400	410-0423			
623H	600	410-0623			

Round, 1/4" x 6"

6pc EACH Prices

Style	Grit	Item#	6-66	72-138	144+
102	100	410-0102			
152	150	410-0152			
222	220	410-0222			
322	320	410-0322			
422	400	410-0422			
622	600	410-0622			

Sold in full box quantities of 6 or 12 each as indicated by **6pc** **12pc** please order in these multiples.

Gesswein® Moldmaker PLUS Stones

- A premium complement to the Moldmaker Series.
- Produces a silky matte finish on all prehardened tool steels, from 28Rc SAE 4130 through 60Rc A2 and M2. Can also be used to rough out aluminum, beryllium copper and kirksite.
- Medium stone with slower breakdown characteristics than our standard Moldmaker stones.
- General purpose, premium-grade green silicon carbide stones.
- A good choice for stoning contours and radii.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.



ABRASIVES-FINISHING STONES

5/32" x 5/32" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
15P	150	415-1015			
20P	220	415-1020			
30P	320	415-1030			
40P	400	415-1040			
60P	600	415-1060			
80P	800	415-1080			
200P	1200	415-1200			



1/4" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1101P	100	412-1101			
1151P	150	412-1151			
1201P	220	412-1201			
1301P	320	412-1301			
1401P	400	412-1401			
1601P	600	412-1601			
1801P	800	412-1801			
2001P	1200	412-2001			

1/2" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1104P	100	412-1104			
1154P	150	412-1154			
1204P	220	412-1204			
1304P	320	412-1304			
1404P	400	412-1404			
1604P	600	412-1604			
1804P	800	412-1804			
2004P	1200	412-2004			

1/4" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1102P	100	412-1102			
1152P	150	412-1152			
1202P	220	412-1202			
1302P	320	412-1302			
1402P	400	412-1402			
1602P	600	412-1602			
1802P	800	412-1802			
2002P	1200	412-2002			

1/2" x 1/2" x 6"



EACH Prices

Style	Grit	Item#	6-66	72-138	144+
1105P	100	412-1105			
1155P	150	412-1155			
1205P	220	412-1205			
1305P	320	412-1305			
1405P	400	412-1405			
1605P	600	412-1605			
1805P	800	412-1805			
2005P	1200	412-2005			

1/2" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
1103P	100	412-1103			
1153P	150	412-1153			
1203P	220	412-1203			
1303P	320	412-1303			
1403P	400	412-1403			
1603P	600	412-1603			
1803P	800	412-1803			
2003P	1200	412-2003			

1" x 1" x 6"



EACH Prices

Style	Grit	Item#	6-66	72-138	144+
1106P	100	412-1106			
1156P	150	412-1156			
1206P	220	412-1206			
1306P	320	412-1306			

Sold in full box quantities of 6 or 12 each as indicated by please order in these multiples.

Gesswein® RA Stones

- Aluminum oxide abrasive bonded together with a unique organic resin bond gives these stones great resiliency.
- Retain their shape well, and are 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.
- Sold in full box quantities of twelve each.



See Our Sampler Sets
on pages 19-21

IMPORTANT: See dust warning on page 3.

5/32" x 5/32" x 4"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA41	180	415-0410				
RA42	220	415-0420				
RA43	320	415-0430				
RA44	400	415-0440				
RA46	600	415-0460				

1/4" x 1/8" x 6"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA4091	90	420-4091				
RA4121	120	420-4121				
RA4181	180	420-4181				
RA4201	220	420-4201				
RA4301	320	420-4301				
RA4401	400	420-4401				
RA4601	600	420-4601				

1/4" x 1/4" x 6"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA4092	90	420-4092				
RA4122	120	420-4122				
RA4182	180	420-4182				
RA4202	220	420-4202				
RA4302	320	420-4302				
RA4402	400	420-4402				
RA4602	600	420-4602				

1/2" x 1/16" x 6"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA4120	120	420-4120				
RA4180	180	420-4180				
RA4200	220	420-4200				
RA4300	320	420-4300				
RA4400	400	420-4400				
RA4600	600	420-4600				

Sold in full box quantities 12 each as indicated by please order in these multiples.



1/2" x 1/8" x 6"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA4093	90	420-4093				
RA4123	120	420-4123				
RA4183	180	420-4183				
RA4203	220	420-4203				
RA4303	320	420-4303				
RA4403	400	420-4403				
RA4603	600	420-4603				

1/2" x 1/4" x 6"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA4094	90	420-4094				
RA4124	120	420-4124				
RA4184	180	420-4184				
RA4204	220	420-4204				
RA4304	320	420-4304				
RA4404	400	420-4404				
RA4604	600	420-4604				

Round, 5/32" x 4"				EACH Prices		
Style	Grit	Item#	12-60	72-132	144+	
RA33	320	420-0033				

Gesswein® General Purpose Stones

- Excellent for P-20 steel polishing!
- Used with stoning oil, the General Purpose stone cuts well and lasts long. Resists loading of steel particles.
- Made of extra-sharp pure white aluminum oxide grains in a specially formulated bond which provides a lubricating effect.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.



See Our
Sampler Sets
on pages 19-21

ABRASIVES-FINISHING STONES

5/32" x 5/32" x 4" Sizes are available in grits 150-1200 on page 17.

1/4" x 1/8" x 6"

Style	Grit	Item#	12-60	72-132	144+
6151G	150	406-6151			
6181G	180	406-6181			
6201G	220	406-6201			
6301G	320	406-6301			
6401G	400	406-6401			
6601G	600	406-6601			
6801G	800	406-6801			
6901G	1200	406-6901			

1/4" x 1/4" x 6"

Style	Grit	Item#	12-60	72-132	144+
6152G	150	406-6152			
6182G	180	406-6182			
6202G	220	406-6202			
6302G	320	406-6302			
6402G	400	406-6402			
6602G	600	406-6602			
6802G	800	406-6802			
6902G	1200	406-6902			

1/2" x 1/8" x 6"

Style	Grit	Item#	12-60	72-132	144+
6153G	150	406-6153			
6183G	180	406-6183			
6203G	220	406-6203			
6303G	320	406-6303			
6403G	400	406-6403			
6603G	600	406-6603			
6803G	800	406-6803			
6903G	1200	406-6903			

1" x 1/8" x 6"

Style	Grit	Item#	6-66	72-138	144+
6011G	150	406-6011			
6111G	180	406-6111			
6211G	220	406-6211			
6311G	320	406-6311			
6411G	400	406-6411			
6611G	600	406-6611			
6811G	800	406-6811			
6911G	1200	406-6911			

Hybrid, 1/4" x 1/4" x 6"

Style	Grit	Item#	12-60	72-132	144+
1523H	150	406-1523			
1823H	180	406-1823			
1223H	220	406-1223			
1323H	320	406-1323			
1423H	400	406-1423			
1623H	600	406-1623			

1/2" x 1/4" x 6"

Style	Grit	Item#	12-60	72-132	144+
6154G	150	406-6154			
6184G	180	406-6184			
6204G	220	406-6204			
6304G	320	406-6304			
6404G	400	406-6404			
6604G	600	406-6604			
6804G	800	406-6804			
6904G	1200	406-6904			

1" x 1/4" x 6"

Style	Grit	Item#	6-66	72-138	144+
6012G	150	406-6012			
6112G	180	406-6112			
6212G	220	406-6212			
6312G	320	406-6312			
6412G	400	406-6412			
6612G	600	406-6612			
6812G	800	406-6812			
6912G	1200	406-6912			

1" x 1/2" x 6"

Style	Grit	Item#	6-66	72-138	144+
6157G	150	406-6157			
6187G	180	406-6187			
6207G	220	406-6207			
6307G	320	406-6307			
6407G	400	406-6407			
6607G	600	406-6607			
6807G	800	406-6807			
6907G	1200	406-6907			

1" x 1" x 6"

Style	Grit	Item#	6-66	72-138	144+
6011G	150	406-6156			
6111G	180	406-6186			
6211G	220	406-6206			
6311G	320	406-6306			
6411G	400	406-6406			
6611G	600	406-6606			

Round, 1/4" x 6"

Style	Grit	Item#	6-66	72-138	144+
152	150	406-0152			
182	180	406-0182			
222	220	406-0222			
322	320	406-0322			
402	400	406-0402			
602	600	406-0602			
802	800	406-0802			
902	1200	406-0902			

Sold in full box quantities of 6 or 12 each as indicated by please order in these multiples.

Gesswein® 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, 420SS, M13 & S7.
- Moderate breakdown, retain their shape wells.
- Can be used in a profiler or ultrasonic polisher.
- Sold in full box quantities of twelve each.



IMPORTANT: See dust warning on page 3.

See Our Sampler Sets
on pages 19-21

5/32" x 5/32" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
2W	220	415-5002			
3W	320	415-5003			
4W	400	415-5004			
6W	600	415-5006			

1/4" x 1/16" x 4"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5210W	220	407-5210			
5310W	320	407-5310			
5410W	400	407-5410			

1/4" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5101W	100	407-5101			
5151W	150	407-5151			
5201W	220	407-5201			
5301W	320	407-5301			
5401W	400	407-5401			
5601W	600	407-5601			

1/4" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5102W	100	407-5102			
5152W	150	407-5152			
5202W	220	407-5202			
5302W	320	407-5302			
5402W	400	407-5402			
5602W	600	407-5602			

1/2" x 1/8" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5103W	100	407-5103			
5153W	150	407-5153			
5203W	220	407-5203			
5303W	320	407-5303			
5403W	400	407-5403			
5603W	600	407-5603			

1/2" x 1/4" x 6"



EACH Prices

Style	Grit	Item#	12-60	72-132	144+
5104W	100	407-5104			
5154W	150	407-5154			
5204W	220	407-5204			
5304W	320	407-5304			
5404W	400	407-5404			
5604W	600	407-5604			



A-C Double Enders

Will accommodate pencil stones as well as small round and square stones up to 1/4" x 1/4". Available in three colors (blue, black and red) that may be used to distinguish one grit or grade of stone from another. Set of three (#403-0120) contains one of each color. Measure 5 7/8" overall length.

Description	Item#	EACH Prices	
		1-2	3+
A. Blue	403-0101		
B. Black	403-0102		
C. Red	403-0103		
Set of 3	403-0120		

Sold in full box quantities 12 each as indicated by please order in these multiples.

Gesswein® 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.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.



1/4" x 1/4" x 8"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
X8002	100	430-8002			

1" x 1/2" x 8"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
X8081	80	430-8081			
X8101	100	430-8101			
X8151	150	430-8151			
X8201	220	430-8201			

1/2" x 1/4" x 6"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
X8004	100	430-8004			

1 1/2" x 3/4" x 8"			6pc EACH Prices		
Style	Grit	Item#	6-66	72-138	144+
X8082	80	430-8082			
X8102	100	430-8102			
X8152	150	430-8152			
X8202	220	430-8202			

1" x 1/4" x 8"			12pc EACH Prices		
Style	Grit	Item#	12-60	72-132	144+
X8080	80	430-8080			
X8100	100	430-8100			
X8150	150	430-8150			
X8200	220	430-8200			



Gesswein® Supreme Green Stoning and Lubricating Oil

This stoning oil was developed for mold and die polishing. It is economical, practically odorless, and it's ecologically safer to use than alternative stoning oils. Use with finishing stones to prevent loading and keep the work surface clean. Lets stones cut better and more freely so they produce a bright, smooth surface. Eliminates the need for hazardous kerosene and other lubricating agents, which could be harmful to your health. Can also use with diamond tools where lubrication is suggested. Viscosity: 39.5/44.

Description	Item#	Each
A. 1 Pint (wide-mouth glass container)	800-0152	\$13.75
B. 1 Gallon	800-0151	44.95

Sold in full box quantities of 6 or 12 each as indicated by 6pc 12pc please order in these multiples.

Gesswein® Ultra-Soft Stones

- Aluminum oxide abrasive with a special bonding agent designed for very rapid breakdown.
- Cuts fast without loading; easily shaped for contours.
- Formulated for soft metals, stainless steel, aluminum, brass, beryllium and kirkite.
- Sold in full box quantities of 6 or 12 each as indicated.

IMPORTANT: See dust warning on page 3.



See Our Sampler Sets
on pages 19-21

Gesswein® Super Fine Stones

- Contain levigated (finely powdered) alumina.
- One of our "softest" stones for finishing P20 and 420SS steel surfaces. Breaks down very rapidly and does not scratch.
- Good choice for finishing details.
- Not quite as soft as our Ultra-Soft stones.
- Sold in full box quantities of 12 each.



1/4" x 1/4" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
7102	120	450-7102			
7202	220	450-7202			
7302	320	450-7302			
7402	400	450-7402			
7602	600	450-7602			
7002	1200	450-7002			

1/2" x 1/8" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
7103	120	450-7103			
7203	220	450-7203			
7303	320	450-7303			
7403	400	450-7403			
7603	600	450-7603			
7003	1200	450-7003			

1/2" x 1/4" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
7104	120	450-7104			
7204	220	450-7204			
7304	320	450-7304			
7404	400	450-7404			
7604	600	450-7604			
7004	1200	450-7004			

1" x 1/2" x 6"		6pc EACH Prices			
Style	Grit	Item#	6-66	72-138	144+
7107	120	450-7107			
7307	320	450-7307			
7607	600	450-7607			
7007	1200	450-7007			

1" x 1" x 6"		6pc EACH Prices			
Style	Grit	Item#	6-66	72-138	144+
7106	120	450-7106			
7306	320	450-7306			
7606	600	450-7606			
7006	1200	450-7006			

5/32" x 5/32" x 4"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
12	1200	415-0120			

1/4" x 1/8" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
9001	1200	440-9001			

1/4" x 1/4" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
9002	1200	440-9002			

1/2" x 1/8" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
9003	1200	440-9003			

1/2" x 1/4" x 6"		12pc EACH Prices			
Style	Grit	Item#	12-60	72-132	144+
9004	1200	440-9004			



Sold in full box quantities of 6 or 12 each as indicated by 6pc 12pc please order in these multiples.