

Instructions for **Removing Tig Welds**

For Large TIG Welds Apply tape around the weld to protect the surrounding surface areas. Use a **W144 Mounted Stone** (or **Mounted Diamond Point**) with a rotary tool at high speeds (up to 50,000 RPM) to grind down the TIG weld until *almost flat*. Now it is safe to remove the protective tape. Continue with steps below.

For Micro TIG Welds Use a **Ceramic Stone** by hand, or preferably with ultrasonic tool, to grind the weld flush to the surface. Once the weld is flush, you can now polish the welded surface up to your surface finish requirement. To achieve a mirror finish, use **Diemaker Stones** in the grit sequence 400, 600, and then 900 (by hand or with reciprocating tool). A **Hard Brush** with the **9 micron Diamond Compound** will eliminate the stone scratches. Finally, you will take your **Soft Cup Brush** and **3 micron Yellow Diamond Compound** to achieve A-1 mirror finish.

STEP	TOOL/COMPOUND	GRIT	POWER	SPEED
1	W144 Mounted Stone <i>or</i> Mounted Diamond Point	120	Ultrasonic	Max
2	NSS Ceramic Stone	300	Ultrasonic	Max
3	Diemaker Stone	400	By hand or profiler	
4	Diemaker Stone	600	By hand or profiler	
5	Diemaker Stone	900	By hand or profiler	
6	Hard Brush #962SC with Diamond Compound	— 9 Mic Green	Rotary	10,000rpm
7	Soft Cup Brush #752 with Diamond Compound	— 3 Mic Yellow	Rotary	10,000rpm