

# Which Gesswein® Stone is Right for Your Job?

The following chart contains helpful information to guide you in selecting the appropriate finishing stone based on your application. Use this chart to determine which finishing stone is right for you based upon the type of surface or contact our technical staff to choose the best stone for your application.



Stone	Page	Abrasive Grain	Bond	Hardness	Breakdown Ratio	Wet or Dry	Recommended Metals
Ultra-Soft	12	White Aluminum Oxide	Vitrified	Very Soft	Very Fast	Wet & Dry	Mold and tool steels including P20, 420SS, and soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
Rough Out	15	Aluminum Oxide	Vitrified	Very Soft	Fast	Wet & Dry	Hard and soft tool steels as low as Rockwell C 25. Soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
General Purpose	11	White Aluminum Oxide	Vitrified	Medium	Moderate	Wet	All tool steels of all hardness such as A2, D2, M2 S7, and H13.
Moldmaker	8	Black Silicon Carbide	Vitrified	Medium Soft	Fast	Wet	Hard and soft tool steels as low as Rockwell C 25. Soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
Diemaker	2-3	Brown Aluminum Oxide	Vitrified	Medium	Moderate	Wet & Limited Dry	All mold and tool steels of all hardness such as A2, D2, S7, H13, P20, 420SS, and soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
Ruby Rough Out	14	Ruby Aluminum Oxide	Vitrified	Medium	Moderate	Wet & Dry	All tool steels of all hardness such as A2, D2, M2, S7, and H13. Soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
Super Fine	12	Aluminum Oxide	Vitrified	Medium	Moderate-Fast	Wet & Dry	All tool steels of all hardness such as A2, D2, M2, S7, and H13.
Oil-Treated	7	White Aluminum Oxide	Vitrified	Medium Hard	Moderate	Wet & Limited Dry	All tool steels of all hardness such as A2, D2, M2, S7, and H13.
Moldmaker PLUS	9	Green Silicon Carbide	Vitrified	Medium Hard	Moderate-Fast	Wet	All mold and tool steels of all hardness such as A2, D2, S7, H13, P20, 420SS, and soft non-ferrous metals such as Aluminum, Beryllium and Kirksite.
Premium White	10	White Aluminum Oxide	Vitrified	Medium Hard	Slow	Wet	All tool steels of all hardness such as A2, D2, M2, S7, and H13.
EDM	4-5	White Aluminum Oxide	Vitrified	Hard	Slow	Wet	Medium and Hard tool steels as high as Rockwell C 62
EDM Blue	6	White Aluminum Oxide	Vitrified	Very Hard	Slow	Wet	Medium and Hard tool steels as high as Rockwell C 62
RA	13	Aluminum Oxide	Resin	Very Hard	Slow	Wet	All tool steels of all hardness such as A2, D2, M2, S7, and H13.



**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 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 Safety Data Sheets of chemical products used with abrasive stone products.