## Info — DEGUSSIT Fine grinding tools

**DEGUSSIT fine grinding tools** are free from bonding agents. They have maximum resistance to wear and deformation as a result of the high hardness of the sintered aluminium oxide crystals.This property is particularly important for precision work to achieve excellent surface quality and geometrical accuracy. Low wear brings significant economic benefits.

When using **DEGUSSIT fine grinding tools**, the surface of the workpiece is not only machined, but by using the finest grade and applying pressure, can also be strengthened and polished.

They are the ideal hand tools for all grinding, finishing and deburring work. They are also perfect for resharpening tools of all kinds. Furthermore, they are particularly suitable for making bevels on cutting tools, notching profiles, working shaped parts made from hardened steel as well as other hard or abrasive materials such as quartz, glass and ceramics.

The tools can be used wet or dry.
Moistening once with petroleum or cutting oil is sufficient.
Clean by wiping with a degreasing agent. If using dry,
simply clean the tool using a pencil eraser.

**Fine grinding tools from DEGUSSIT DD57 offer the following benefits:**
- Extreme hardness
- Excellent stability of edges and profiles
- High resistance to wear for outstanding durability
- Outstanding surface finish for workpieces

**Our fine grinding tools are designed for use in the following industries:**
- Precision engineering and watchmaking
- Glass and optical industry
- Tool and mould making
- The electrical industry

## 42086 - 42088 DEGUSSIT grinding file assortment

**Design**
Made of sintered oxide ceramic crystals, without any bonding agents. Extreme hardness, low wear, extremely stable form.
**Applications**
For fine grinding work in mould and tool making, precision engineering, optical industry, glass and porcelain industry etc. Ideal for machining hardened steels, glass and porcelain. Use dry or with oil or petroleum.

| | Set contents 42086 |
|---|---|
| 1 | square grinding file |
| 1 | triangular grinding file |
| 1 | round grinding file (medium grain) |
| 1 | half-round grinding file (coarse grain) |
| 1 | flat grinding file (fine grain) |

| | Set contents 42088 |
|---|---|
| 11 | different mini grinding files |
| 1 | holder |
| 2 | mountings |

42086

42088

| | Grinding files | | Mini files | |
|---|---|---|---|---|
| Design | 42086 | ... | 42088 | ... |
| In a solid cardboard box | | 101 | | |
| In a plastic box | | | | 101 |

## 42090 DEGUSSIT square files

| L x W mm | Grain | 42090 | ... |
|---|---|---|---|
| 100 x 6 | medium | | 202 |
| 100 x 8 | medium | | 203 |
| 100 x 10 | medium | | 204 |
| 100 x 10 | fine | | 304 |

42090

## 42091 DEGUSSIT triangular files

| L x W mm | Grain | 42091 | ... |
|---|---|---|---|
| 100 x 8 | medium | | 203 |
| 100 x 10 | medium | | 204 |
| 100 x 10 | fine | | 304 |

42091

## 42092 DEGUSSIT round files

| L x W mm | Grain | 42092 ... |
|---|---|---|
| 100 x 4 | medium | 201 |
| 100 x 6 | medium | 202 |
| 100 x 8 | medium | 203 |

42092

## 42093 DEGUSSIT half-round file

| L x W mm | Grain | 42093 ... |
|---|---|---|
| 100 x 10 | medium | 201 |

42093

## 42094 DEGUSSIT file (knife blade form)

| L x W x H mm | Grain | 42094 ... |
|---|---|---|
| 100 x 15 x 3/0.5 | medium | 201 |

42094

## 42095 DEGUSSIT flat file

| L x W x H mm | Grain | 42095 ... |
|---|---|---|
| 100 x 8 x 6 | medium | 201 |

42095

## 42002 - 42012 Silicon carbide grinding files

**Applications**
One of the hardest abrasives. It is used for filing hard workpieces (hardened steel and cemented carbide) wherever steel files are inadequate.
**Use**
Dry or with oil, petroleum or water.

42002 - 42004

42005 - 42007

42009

42012

| L x W mm | Square coarse 42002 ... | Square medium 42003 ... | Square fine 42004 ... | Triangular coarse 42005 ... | Triangular medium 42006 ... | Triangular fine 42007 ... | Round medium 42009 ... | Half-round medium 42012 ... |
|---|---|---|---|---|---|---|---|---|
| 100 x 10 | 103 | 103 | 103 | 103 | 103 | 103 | 103 | 103 |
| 100 x 13 | 104 | 104 | 104 | 104 | 104 | 104 | 104 | 104 |
| 150 x 13 | 106 | 106 | 106 | 106 | 106 | 106 | 106 | 106 |
| 150 x 20 | 108 | 108 | 108 | 108 | 108 | 108 | 108 | 108 |

## 42020 - 42021 Silicon carbide composite stones/gouge stones

**Applications**
One of the hardest abrasives. It is used for filing hard workpieces (hardened steel and cemented carbide) wherever steel files are inadequate.
**Use**
Dry or with oil, petroleum or water.

**42020**
**Composite stones**
**Applications**
With one coarse side for pre-grinding and one fine coating for finishing and honing.

**42021**
**Gouge stones**
**Design**
With two round edges of different thicknesses, medium grain.

42020

42021

Composite stones

| L x W x Th mm | 42020 ... |
|---|---|
| 100 x 25 x 13 | 101 |
| 125 x 50 x 20 | 103 |
| 150 x 50 x 25 | 105 |
| 200 x 50 x 25 | 107 |

Gouge stones

| L x W x Th mm | 42021 ... |
|---|---|
| 115 x 45 x 6/2 | 102 |
| 115 x 45 x 10/3 | 103 |



= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

## 42025 Silicon carbide dressing stones (rubbing stones)

**Design**
Coarse-grained and untreated.
**Applications**
For the machining of cast iron, steel, iron, glass, ceramics and porcelain, granite and synthetic stone.
Also for dressing sanding discs.

42025

| L x W x Th mm | 42025 ... |
|---|---|
| 150 x 50 x 25 | 101 |
| 200 x 50 x 25 | 102 |

## 42106 - 42111 Corundum grinding files

**Design**
Hard and very ductile material, non-wearing tool with high edge strength.
**Applications**
For fine machining of hardened steel parts and cemented carbide.
**Use**
Dry or with oil, petroleum or water.

42106 - 42108

42110 - 42111

| | Square coarse | Square medium | | Square fine | | Triangular medium | | Triangular fine | |
|---|---|---|---|---|---|---|---|---|---|
| L x W mm | 42106 ... | 42107 | ... | 42108 | ... | 42110 | ... | 42111 | ... |
| 100 x 8 | 102 | 102 | | 102 | | 102 | | 102 | |
| 100 x 10 | 103 | 103 | | 103 | | 103 | | 103 | |
| 150 x 13 | 106 | 106 | | 106 | | 106 | | 106 | |
| 150 x 20 | 108 | 108 | | 108 | | 108 | | 108 | |

## 42113 - 42118 Corundum grinding files

**Design**
Hard and very ductile material, non-wearing tool with high edge strength.
**Applications**
For fine machining of hardened steel parts and cemented carbide.
**Use**
Dry or with oil, petroleum or water.

42113 - 42114

42115 - 42116

42118

| | Round medium | Round fine | | Half-round coarse | | Half-round medium | | Knife blade medium | |
|---|---|---|---|---|---|---|---|---|---|
| L x W mm | 42113 ... | 42114 | ... | 42115 | ... | 42116 | ... | 42118 | ... |
| 100 x 10 | 103 | 103 | | | | 103 | | | |
| 150 x 13 | 106 | 106 | | 106 | | 106 | | | |
| 100 x 25 | | | | | | | | 102 | |

## 42130 Corundum composite stones

**Design**
Hard and very ductile material, non-wearing tool with high edge strength.
**Applications**
For fine machining of hardened steel parts and Cemented carbide.
**Use**
Dry or with oil, petroleum or water.

***Note:***
*With one coarse side for pre-grinding and one fine coating for finishing and honing.*

42130

| L x W x H mm | 42130 ... |
|---|---|
| 100 x 25 x 13 | 101 |
| 125 x 50 x 20 | 103 |

| L x W x H mm | 42130 ... |
|---|---|
| 150 x 50 x 25 | 105 |
| 200 x 50 x 25 | 107 |

## 42306 - 42310 Hard Arkansas natural stone grinding files

**Applications**
Particularly suitable for superfinishing hardened steel, used with oil or petroleum.

***Note:***
*Depending on the stone, these dimensions can vary within the tolerances given.*

42306

42307

42308

42309

42310

| Length x width approx. mm | Square 42306 | ... | Triangular 42307 | ... | Round 42308 | ... | Half-round 42309 | ... | Knife blade 42310 | ... |
|---|---|---|---|---|---|---|---|---|---|---|
| 75–100 x 5–6 | | 101 | | 101 | | | | | | |
| 75–100 x 7–8 | | 102 | | 102 | | | | 102 | | |
| 75–100 x 9–10 | | 103 | | 103 | | 103 | | 103 | | |
| 75–100 x 11–13 | | 104 | | 104 | | 104 | | 104 | | |
| 125–150 x 14–16 | | 107 | | | | | | | | |
| 75–100 x 20–25 x 3–6 | | | | | | | | | | 101 |

## 42330 Hard Arkansas oil stones (Mississippi stone) bench stone

**Applications**
The extremely fine and uniform grain is particularly suitable for superfinishing hardened steel.
Use with oil or petroleum.

42330


| L x W mm | Design | 42330 | ... |
|---|---|---|---|
| 90 x 25 | in wooden case | | 101 |
| 100 x 40 | in wooden case | | 102 |
| 125 x 50 | in wooden case | | 103 |
| 150 x 50 | in wooden case | | 104 |
| 175 x 50 | in wooden case | | 105 |

## 42331 Hard Arkansas oil stones (Mississippi stone) gouge stone

**Applications**
The extremely fine and uniform grain is particularly suitable for superfinishing hardened steel.
Use with oil or petroleum.

***Note:***
*Depending on the stone, these dimensions can vary within the tolerances given.*

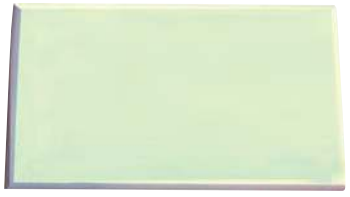
42331


| L x W x H approx. mm | 42331 | ... |
|---|---|---|
| 75–100 x 35–50 x 8–10/2–3 | | 101 |
| 100–120 x 35–50 x 10–13/3–4 | | 102 |

## 42325 Honing stone (Coticule)

**Design**
Super fine, uniform abrasive grain.
**Applications**
For honing bevelled-edge chisels and knife blades etc. with oil, petroleum and possibly also water.

42325



| Dimensions approx. mm | 42325 | ... |
|---|---|---|
| 115 x 60 x 18–20 | | 101 |



www.hhw.de
Fax order hotline: 0800 0 915910

= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

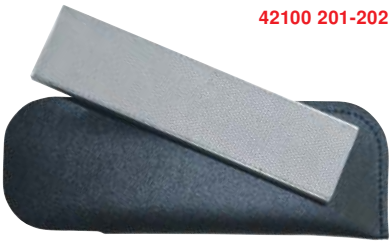
## 42100 - 42101 Diamond all-purpose sharpeners

**3M**

**Design**
Diamond abrasive-coated aluminium plate, 10 mm thick.
**Applications**
For sharpening and honing engraving irons, chisels, bevelled-edge chisels and tool cutting edges. For shearing cutting edges on glass, stone and all hard materials.

**42101 201-202**
**Design**
With non-slip feet.

42100 201-202



42101 201-202


| Grain | Dimensions mm | Design | 42100 | ... | 42101 | ... |
|---|---|---|---|---|---|---|
| **Very fine** | 100 x 25 x 10 | in leather sleeve | | 201 | | |
| **Very fine** | 150 x 50 x 10 | in plastic sleeve | | | | 201 |
| **Fine** | 100 x 25 x 10 | in leather sleeve | | 202 | | |
| **Fine** | 150 x 50 x 10 | in plastic sleeve | | | | 202 |

## 42911 - 42912 Hand lapping tool

**Design**
With plastic handle.
**Applications**
For sharpening, chamfering and shearing cutting edges, primarily of cemented carbide cutting tools. Also for post-machining hardened and ground workpieces.

**42911**
**Hand lapping tool**
**Applications**
For maintaining fine cutting edges on wood and metal milling cutters as well as small lathe chisels.

**42912**
**Diamond hand lapping tools**
**Applications**
For lathe chisels and milling heads in metalworking.

42911

42912 101

42912 102

| Grain µm | Coating mm | Colour | 42911 | ... | 42912 | ... |
|---|---|---|---|---|---|---|
| **180–130** | 60 x 20 x 10 | Yellow | | 101 | | |
| **220–100** | 60 x 20 x 10 | Blue | | 102 | | |
| **360–50** | 60 x 20 x 10 | Red | | 103 | | |
| **D 46 resin bond** | 30 x 9 | Blue | | | | 101 |
| **D 64 bronze bond** | 30 x 9 | Red | | | | 102 |

# Sanding blocks for finishing machines

## 42200 Plastic sanding blocks

OTEC

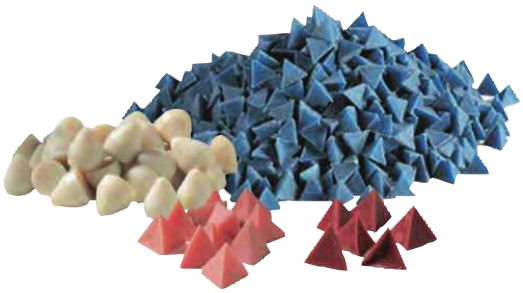
**Consumables for surface finishing processes**
The correct consumable/medium must be selected for each individual application.
Relevant factors include the composition, type and associated process parameters (time/speed). The correct consumable allows a high surface accuracy and gives you the option of individual machining and finishing of the workpieces to be machined.

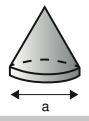
***Note:***
*Suitable for ECO series centrifugal finishing machines/surface finishers art. no. 92866–92867.*

**Plastic sanding blocks**
**Design**
- Plastic bonded sanding block with low density and soft base material

**Applications**
Mainly used for sanding and finishing non-ferrous base metals.

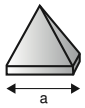
***Note:***
*Other sizes and qualities on request.*
*Order example: Type K, quality M.*
*Size 6 mm => KM6*






Type K

| Type | Colour | Sanding effect | Taper Size a in mm | 42200 | ... |
|---|---|---|---|---|---|
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 6 | | 294 |
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 10 | | 295 |
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 12 | | 296 |
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 15 | | 297 |
| F | Orange | Finishing and polishing, good material removal, results in very smooth surfaces | 6 | | 298 |
| F | Orange | Finishing and polishing, good material removal, results in very smooth surfaces | 10 | | 299 |
| A | Red | Medium coarse, medium roughness | 10 | | 300 |
| A | Red | Medium coarse, medium roughness | 12 | | 301 |
| T | Purple | Extremely coarse, coarse roughness | 10 | | 302 |
| T | Purple | Extremely coarse, coarse roughness | 12 | | 303 |




Type P

| Type | Colour | Sanding effect | Pyramid Size a in mm | 42200 | ... |
|---|---|---|---|---|---|
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 10 | | 395 |
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 12 | | 396 |
| M | Mint green | Finishing and polishing, good material removal, results in very smooth surfaces | 15 | | 397 |
| F | Orange | Finishing and polishing, good material removal, results in very smooth surfaces | 10 | | 398 |
| A | Red | Medium coarse, medium roughness | 6 | | 399 |
| A | Red | Medium coarse, medium roughness | 10 | | 400 |
| O | Blue | Coarse, medium roughness | 6 | | 401 |
| T | Purple | Extremely coarse, coarse roughness | 10 | | 402 |
| T | Purple | Extremely coarse, coarse roughness | 12 | | 403 |
| T | Purple | Extremely coarse, coarse roughness | 20 | | 404 |

Continued

## Info Surface finishing machines can be found in catalogue group 9

OTEC

Inexpensive to purchase and maintain, the ECO-18 was designed for medium and large series. Fast and versatile, suitable for the most varied surface machining. Deburring, chamfering, sanding and polishing are possible with a wide range of media (sanding bodies).

Its compact size and closed water circuit mean that it can be used directly adjacent to a machining centre,

**Saving up to 90% machining time - with perfect results!**

**Type ECO-18**
**(art. no. 92867 200)**



= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.

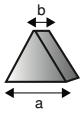
# 42200 Ceramic sanding block

Continued

**Ceramic sanding block**
**Design**
- Ceramic bonded sanding block with high density and hard base material

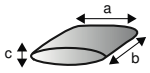
**Applications**
Mainly used for sanding steel alloys.

***Note:***
*Other sizes and qualities on request.*

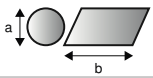



| Type | Sanding effect | Triangle<br>Size a/b in mm | Type D<br>42200 ... |
|---|---|---|---|
| M | Medium coarse | 4/4 | 094 |
| M | Medium coarse | 6/6 | 095 |
| M | Medium coarse | 8/8 | 096 |
| M | Medium coarse | 13/13 | 097 |
| S | Coarse sanding finish | 4/4 | 098 |
| S | Coarse sanding finish | 6/6 | 099 |
| S | Coarse sanding finish | 6/10 | 100 |
| S | Coarse sanding finish | 10/8 | 101 |
| S | Coarse sanding finish | 10/10 | 102 |
| S | Coarse sanding finish | 13/13 | 103 |
| BS | Extremely coarse sanding finish | 4/4 | 104 |
| BS | Extremely coarse sanding finish | 6/6 | 105 |
| BS | Extremely coarse sanding finish | 8/8 | 106 |
| BS | Extremely coarse sanding finish | 10/10 | 107 |


| Type | Sanding effect | Triangle (diagonal cut)<br>Size a=b in mm | Type S<br>42200 ... |
|---|---|---|---|
| S | Coarse sanding finish | DSS 4/10 | 108 |
| S | Coarse sanding finish | DSS 6/6 | 109 |
| S | Coarse sanding finish | DSS 6/10 | 110 |
| S | Coarse sanding finish | DSS 4/10 | 111 |
| S | Coarse sanding finish | DSS 6/10 | 112 |

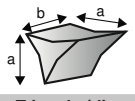



| Type | Sanding effect | Ellipse<br>Size a/b in mm | Type E<br>42200 ... |
|---|---|---|---|
| SF | Coarse sanding finish | 15/15/6 | 113 |




| Type | Sanding effect | Cylinder ** (diagonal cut)<br>Size a/b in mm | Type ZS<br>42200 ... |
|---|---|---|---|
| S | Coarse sanding finish | 6/13 | 114 |
| S | Coarse sanding finish | 4/10 | 115 |
| S | Coarse sanding finish | 6/13 | 116 |
| S | Coarse sanding finish | 7/13 | 117 |
| S | Coarse sanding finish | 7/15 | 118 |
| S | Coarse sanding finish | 8/15 | 119 |

** Also available without diagonal cut




| Type | Sanding effect | Triangle (diagonal cut)<br>Size a=b in mm | Type DZ<br>42200 ... |
|---|---|---|---|
| M | Medium coarse | 4/4 | 195 |
| M | Medium coarse | 6/6 | 196 |
| M | Medium course | 6/6 SK* | 197 |
| M | Medium coarse | 8/8 | 198 |
| S | Coarse sanding finish | 4/4 | 199 |
| S | Coarse sanding finish | 6/6 | 200 |
| S | Coarse sanding finish | 6/6 SK* | 201 |
| S | Coarse sanding finish | 10/10 | 202 |

* Very sharp-edged

Continued

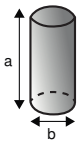
## 42200 Porcelain polishing block

Continued ▶

**Porcelain polishing block**
**Design**
- Excellent polishing properties, retains shape even after prolonged use

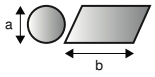
**Applications**
For smoothing, polishing (and high-gloss polishing) of different materials.

***Note:***
*Other sizes and qualities on request.*



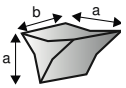

Type Z

| Type | Sanding effect | Cylinder Size a/b in mm | 42200 ... |
|---|---|---|---|
| P | Polishing | 4/10 | 499 |




Type ZS

| Type | Sanding effect | Triangle (diagonal cut) Size a=b in mm | 42200 ... |
|---|---|---|---|
| P | Polishing | 4/5 | 500 |
| P | Polishing | 4/10 | 501 |
| P | Polishing | 5/10 | 502 |
| P | Polishing | 6/10 | 503 |
| P | Polishing | 7/15 | 504 |




DZ type

| Type | Sanding effect | Ellipse Size a/b in mm | 42200 ... |
|---|---|---|---|
| P | Polishing | 4/4 | 600 |
| P | Polishing | 4/4 SK* | 601 |
| P | Polishing | 6/6 SK* | 602 |
| P | Polishing | 8/8 SK* | 603 |
| P | Polishing | 10/10 SK* | 604 |

* Very sharp-edged

## 42201 Compound

OTEC

**Design**
- A suitable compound is used to rinse away the abrasion particles resulting from the surfacing finishing process
- Concentration in process water 3–5%

**42201 100-101**
**SC 15**
**Applications**
Specially designed for ferrous metals, with corrosion protection, low foaming.

**42201 200-201**
**SC 13**
**Applications**
For all ferrous and non-ferrous metals, with corrosion protection, more suitable for polishing due to foaming action; however, this results in slightly longer process times because the foam slows down machining.

42201 100

42201 101

| Type | Design | Contents Litre | 42201 ... |
|---|---|---|---|
| SC15 | in a bottle | 1 | 100 |
| SC15 | in a canister | 20 | 101 |
| SC13 | in a bottle | 1 | 200 |
| SC13 | in a canister | 20 | 201 |

## 42202 ACTICIDE MBS for preservation and bacteria reduction

OTEC

**Design**
ACTICIDE MBS is effective on a broad range of bacteria, fungi and yeasts. ACTICIDE MBS offers outstanding protection against pseudomonads in particular.

**Applications**
ACTICIDE MBS is the ideal preservative for aqueous products, such as emulsion paints, polymer emulsions, adhesives, bitumen emulsions, lignosulphonates, pigment pastes, diesel fuel emulsions, slurry, glazes, coating compounds, fillers, starch products, process water, cleaning and care products, inks, printing pastes and pumping media.

**Dosage:**
OTEC surface finishing: Initial dose of 0.5%; a subsequent dose of between 0.2–0.5% can be added, depending on the bacteria present.

42202

| Contents Litre | 42202 ... |
|---|---|
| 1 | 100 |



= The specified prices are unit prices. Only sold in the specified packing units. Always specify number of units in order information.