

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 Power Hone and turn it "on". **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.

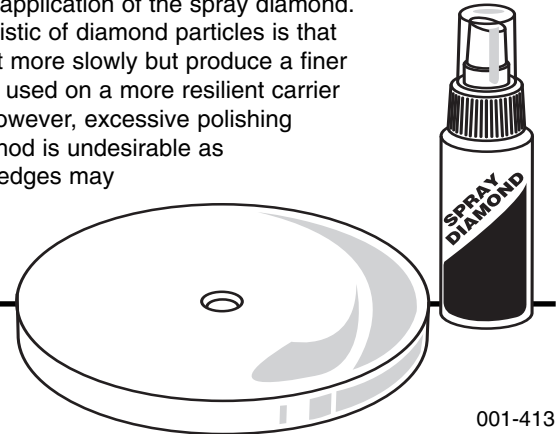
Hold the spray nozzle 3" - 4" from the rotating lap surface and spray a band near the outer edge of the lap surface. About a one second burst is adequate. You will be mostly using the outer 1" - 1-1/2" of the lap surface, so concentrate the diamond there. Cutting action will gradually decrease through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

Use the lap to polish the desired surfaces. It is generally not necessary to polish the face of the graver, but it can be easily done. If you use a very small heel, it is possible to do both cutting and polishing with the ceramic lap only. You can do this with less danger of making the heel too long. Also, it is relatively easy to form a rounded heel surface by alternately rocking the fixture approximately 5° and 15° with the sharpening fixture clamp screw loose. Cutting action is extremely smooth and controllable.

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

A final, even more brilliant polish can be obtained after the lap finish by wiping the polished surface on a piece of very hard leather - - the surface of which you have treated with a light application of the spray diamond. A characteristic of diamond particles is that they will cut more slowly but produce a finer finish when used on a more resilient carrier material. However, excessive polishing by this method is undesirable as the cutting edges may be dulled.



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