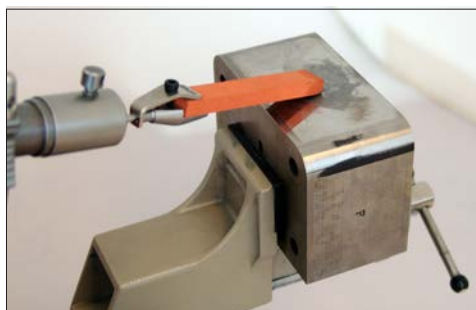
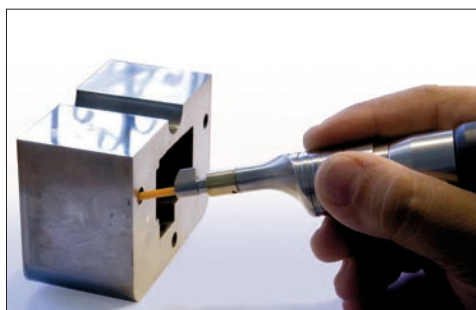


# **DIPROFIL®**

DIAMANTPRODUKTER AB

**Since 1950**



***Machines and Tools for Mould makers and Tool makers***

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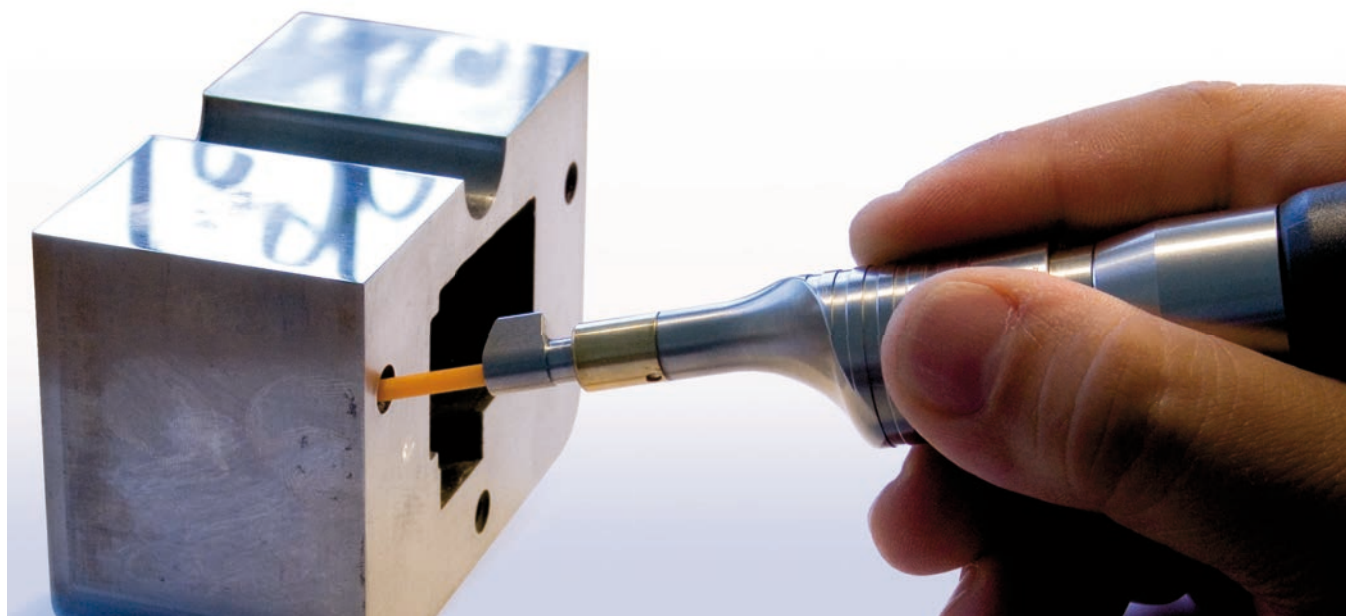
FOR INFORMATION ABOUT SPARE PARTS FOR THE  
DIFFERENT DIPROFIL MACHINES AND UNITS

PLEASE VISIT [WWW.DIPROFIL.SE](http://WWW.DIPROFIL.SE)

or see the corresponding operation guide  
supplied with each machine.



# DIAMANTPRODUKTER AB



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## Company Presentation

Diprofil/Diamantprodukter AB has more than 60 years of genuine experience in machines and tools for toolmakers, mould makers and other fine mechanical precision work. We offer a wide range of products for grinding, polishing and finishing applications including Polishing/Filing machines, Diamond and CBN tools, Lapping and Honing tools, Polishing stones etc.

On our up to date diamond department we manufacture diamond tools in all kinds of shapes and grit sizes including files, grinding pins and points, grinding wheels, cutting discs etc. We also offer customer specific diamond and CBN tools according to special requirements.

## Contact Information

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# **Di-PRO<sup>®</sup>** POLISHING-/FILING MACHINES

Maximum Efficiency – Minimal Vibrations



As the flagship of the Diprofil family the Di-Pro<sup>®</sup> represents a new standard of high-end polishing-/filing machines with an increased focus on the operator's well-being.

The low levels of vibration greatly reduce the risk of Hand Arm Vibration Syndrome (HAVS) – without compromising performance.

The dangers of Hand-Arm Vibrations (HAV) have in recent years been focused as one of the main occupational hazards in the industry. With this in mind Diprofil has developed a high quality low-vibrating machine with reduced vibration levels and the same renowned quality standard as the Classic Diprofil machine.

Operating the machine according to the operation guide ensures that the operator will be able to use the machine for full 8-hour working days with a minimum risk of sustaining vibration related injuries such as "vibration white finger".

To achieve as low vibration levels as possible, the Di-Pro<sup>®</sup> has been optimized for tools within a certain weight-span. This is based on Diprofil's long experience in tools normally used with this type of machine and keeping within this weight-span gives optimal efficiency in relation to the vibration levels.

Di-Pro machines are available with either a Ø 3,5 or a Ø 6,4 mm tool-holder and connections for a wide variety of drive-sources.

All Di-Pro machines are delivered in a handy tool-box with the necessary accessories.

**For the best efficiency to vibration-ratio, the following tools are recommended:**

- Diprofil diamond files type DLA, DLE, DLF, DLM and DBE
- Selected Diprofil lapping tools
- Selected Diprofil polishing tools
- Di-Pro stoning- & polishing tools

**The Di-Pro<sup>®</sup> is available with the following drive sources:**

- Flexible shaft connection (slip-joint / ball-joint)
- Integrated micro-motor
- Integrated air-motor



## Flexible-shaft driven machine with slip-joint connection



The FXB and FXK models should be driven by an electrical hanging-motor with speed control and a flexible-shaft with slip-joint connection (European standard) e.g. Diprofil type DSE-47. Corresponding motors of other brands may also be used.

### Technical data:

Speed (maximum): 7.000 rpm  
Speed (recommended): 5.000 – 7.000 rpm (depending on the weight of the used tool).  
Stroke length: 0 – 6 mm (recommended 0,5 – 4 mm) NOTE! At stroke lengths exceeding 4 mm a maximum speed of 5.000 rpm is recommended.  
Weight: **FXB:** 740 g **FXK:** 780 g  
Noise level: not exceeding 75 dB (A) at 7.000 rpm  
Vibration levels: Not exceeding 2,5 m/s<sup>2</sup> when the machine is operated according to the operation guide. For more information about vibration levels when using certain tools at different speeds and stroke lengths, please see the operation guide. Frequency weighed hand/arm vibration principally in accordance with ISO 28927-8.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FXB         |
| Ø 6,4 mm    | FXK         |

## Flexible-shaft driven machine with ball-joint connection



The FXC, FXS (key-hole) or FXH (square-hole) models should be driven by an electrical hanging-motor with speed control and a flexible-shaft with ball-joint connection (US standard) e.g. Diprofil type DSE-47. Corresponding motors of other brands may also be used.

### Technical data:

Speed (maximum): 7.000 rpm  
Speed (recommended): 5.000 – 7.000 rpm (depending on the weight of the used tool).  
Stroke length: 0 – 6 mm (recommended 0,5 – 4 mm) NOTE! At stroke lengths exceeding 4 mm a maximum speed of 5.000 rpm is recommended.  
Weight: **FXC:** 750 g **FXS+FXH:** 790 g  
Noise level: not exceeding 75 dB (A) at 7.000 rpm  
Vibration levels: Not exceeding 2,5 m/s<sup>2</sup> when the machine is operated according to the operation guide. For more information about vibration levels when using certain tools at different speeds and stroke lengths, please see the operation guide. Frequency weighed hand/arm vibration principally in accordance with ISO 28927-8.

| Connection  | Tool holder | Item number: |
|-------------|-------------|--------------|
| Key hole    | Ø 3,5 mm    | FXC          |
| Key hole    | Ø 6,4 mm    | FXS          |
| Square hole | Ø 6,4 mm    | FXH          |

**Learn more about the advantages and possibilities with using the low-vibrating *Di-PRO* polishing-/filing machines and protective finger sleeves from Diprofil.**



Visit [www.diprofil.se](http://www.diprofil.se) or scan the QR-code to watch the **Di-PRO** Promotion Video

## Air driven machine



The FXD and FXL models have a built-in air-motor and should be driven by compressed and oil mist lubricated air. PLEASE NOTE! The built-in air-motor may be damaged, if operated with un-lubricated air. Connection: The Diprofil quick-coupling HSL-M and fog lubrication unit MFB should be used for connection to your compressed air system.

PLEASE NOTE! Protect the air inlet from dust and dirt, when not in operation.

### Technical data:

Speed (maximum): 7.000 rpm  
Speed (recommended): 5.000 – 7.000 rpm (depending on the weight of the used tool).  
Stroke length: 0 – 6 mm (recommended 0,5 – 4 mm) NOTE! At stroke lengths exceeding 4 mm a maximum speed of 5.000 rpm is recommended.  
Weight: **FXD:** 880 g **FXL:** 920 g  
Oil consumption: minimum 30 mm<sup>3</sup>/min. at maximum speed (about 2 drops/min.)  
Air pressure: 4 bar (57psi)  
Air consumption: Approx. 60 l/min at 7.000 rpm  
Noise level: not exceeding 75 dB (A) at 7.000 rpm  
Vibration levels: Not exceeding 2,5 m/s<sup>2</sup> when the machine is operated according to the operation guide. For more information about vibration levels when using certain tools at different speeds and stroke lengths, please see the operation guide. Frequency weighed hand/arm vibration principally in accordance with ISO 28927-8.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FXD         |
| Ø 6,4 mm    | FXL         |

## Machine with built-in micro-motor (Diprofil connector)



The FXP and FXM models have a built-in micro-motor, which is connected to, and controlled by, the DIPROFIL DPU-3, TPU-20 or corresponding power units.

### Technical data:

Speed (maximum): 7.000 rpm  
Speed (recommended): 5.000 – 7.000 rpm (depending on the weight of the used tool).  
Stroke length: 0 – 6 mm (recommended 0,5 – 4 mm) NOTE! At stroke lengths exceeding 4 mm a maximum speed of 5.000 rpm is recommended.  
Weight: **FXP:** 960 g **FXM:** 980 g  
Noise level: not exceeding 75 dB (A) at 7.000 rpm  
Vibration levels: Not exceeding 2,5 m/s<sup>2</sup> when the machine is operated according to the operation guide. For more information about vibration levels when using certain tools at different speeds and stroke lengths, please see the operation guide. Frequency weighed hand/arm vibration principally in accordance with ISO 28927-8.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FXP         |
| Ø 6,4 mm    | FXM         |

## Machine with built-in micro-motor (Eneska 3-1 connector)



The FXP/EJ and FXM/EJ models have a built-in micro-motor, which is connected to, and controlled by, the Eneska 3-1 or corresponding power units.

### Technical data:

Speed (maximum): 7.000 rpm  
Speed (recommended): 5.000 – 7.000 rpm (depending on the weight of the used tool).  
Stroke length: 0 – 6 mm (recommended 0,5 – 4 mm) NOTE! At stroke lengths exceeding 4 mm a maximum speed of 5.000 rpm is recommended.  
Weight: **FXP/EJ:** 960 g **FXM/EJ:** 980 g  
Noise level: not exceeding 75 dB (A) at 7.000 rpm  
Vibration levels: Not exceeding 2,5 m/s<sup>2</sup> when the machine is operated according to the operation guide. For more information about vibration levels when using certain tools at different speeds and stroke lengths, please see the operation guide. Frequency weighed hand/arm vibration principally in accordance with ISO 28927-8.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FXP/EJ      |
| Ø 6,4 mm    | FXM/EJ      |

# CLASSIC DIPROFIL MACHINES

## ORIGINAL RECIPROCATING POLISHING/FILING MACHINE



The Original Diprofil reciprocating polishing-/filing machines are designed for efficient polishing and finishing operations and have been the preferred choice for tool- and mould-makers for more than 50 years. The Classic Machines, with a wide range of tools and accessories, have been developed by careful studies of fine mechanical handwork and finishing operations. They facilitate filing, lapping, honing, polishing etc. and have become an important concept in the daily work of mould-making, die-sinking, tool-making and other fine mechanical precision work.

Classic machines are available with either a Ø 3,5 or a Ø 6,4 mm tool-holder and connections for a wide variety of drive-sources.

All Classic machines are delivered in a handy tool-box with the necessary accessories.

## Air Drive



The air-driven Original Diprofil Filing Machine, has a specially developed 18-cylinder radial piston-type air motor with integrated speed regulator.

The machine is available with a Ø 3,5 mm tool holder (**FPD/R**) or a Ø 6,4 mm tool holder (**FPL/R**).

The airmotors are manufactured with a very high level of accuracy and require lubricated and filtered air (5µ) to obtain a long and trouble-free lifetime.

For better comfort, each model is fitted with an ergonomic rubber sleeve.

### Technical data

Stroke length: 0-6 mm (recommended 0,5-3mm)  
Speed: max 8.000 rpm (recommended: 5.000 - 7.000 rpm)  
Weight: 750 - 780 g  
Oil consumption: minimum 30 mm<sup>3</sup>/min. at maximum speed (about 2 drops/min.)  
Air pressure: **FPD/R**: 4 bar (57psi) **FPL/R**: 4 bar (57psi)  
Air consumption: **FPD/R**: Approx. 65 l/min at 8.000 rpm **FPL/R**: Approx. 60 l/min at 7.000 rpm  
Noise: < 70 dB(A) at 7.000 rpm  
Vibration: with standard tool holder (Ø 3,5 mm) 3-10 m/s<sup>2</sup>  
with heavy duty tool holder (Ø 6,4 mm) 4-12 m/s<sup>2</sup>.  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FPD/R       |
| Ø 6,4 mm    | FPL/R       |

## Flexible-Shaft Drive - Slip Joint Connection



The **Original Diprofil Filing Machine** for flexible-shaftdrive is available for connection to Slip Joint. The machines can be supplied with two different tool holders, standard Ø 3,5 mm (**FPB/R**) or heavy duty Ø 6,4 mm (**FPK/R**). For better comfort, each model is fitted with an ergonomic rubber sleeve.

### Technical data

Stroke length: 0-6 mm (recommended 0,5-3mm)  
Speed: max 8.000 rpm (recommended: 5.000 - 7.000 rpm)  
Weight: 585 - 615 g  
Noise: < 70 dB(A) at 7.000 rpm  
Vibration: with standard tool holder (Ø 3,5 mm) 3-10 m/s<sup>2</sup>  
with heavy duty tool holder (Ø 6,4 mm) 4-12 m/s<sup>2</sup>.  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Tool holder | Item number |
|-------------|-------------|
| Ø 3,5 mm    | FPB/R       |
| Ø 6,4 mm    | FPK/R       |

## Flexible-Shaft Drive - Ball Joint Connection



The **Original Diprofil Filing Machine** for flexible-shaft drive is available for connection to Ball joint (American model, connecting sleeve, key hole (**FPC/R** and **FPS/R**) or square hole (**FPH/R**).

The **FPC/R** is available with standard Ø 3,5 mm tool holder and the **FPS/R** is available with heavy duty Ø 6,4 mm tool holder.

The **FPH/R** is available with heavy duty Ø 6,4 mm tool holder.

For better comfort, each model is fitted with an ergonomic rubber sleeve.

The technical data is the same as for the **FPB/R** and **FPK/R**.

| Connection  | Tool holder | Item number |
|-------------|-------------|-------------|
| Key hole    | Ø 3,5 mm    | FPC/R       |
| Key hole    | Ø 6,4 mm    | FPS/R       |
| Square hole | Ø 6,4 mm    | FPH/R       |

FOR INFORMATION ABOUT SPARE PARTS FOR THE  
DIFFERENT DIPROFIL MACHINES AND UNITS

PLEASE VISIT [WWW.DIPROFIL.SE](http://WWW.DIPROFIL.SE)

or see the corresponding operation guide  
supplied with each machine.





## Micro Motor Drive - Integrated Micro Motor



The Original Diprofil Filing Machine for Micro motor drive can be supplied with two different tool-holders, standard Ø 3,5 mm (**FPP/R**) or heavy duty Ø 6,4 mm (**FPM/R**). These have a built-in micro-motor, which is connected to, and controlled by, the DIPROFIL DPU-3, TPU-20 or corresponding power units. For better comfort, each model is fitted with an ergonomic rubber sleeve. The machine is also available with Eneska 3-1 connector (**FPM/ERJ**, **FPP/ERJ**).

### Technical data

Stroke length: 0-6 mm (recommended 0,5-3mm)  
Speed: max 8.000 rpm (7.000 rpm at 32V) recommended: 5.000 - 7.000 rpm  
Weight: 800 - 830 g  
Noise: < 70 dB(A) at 7.000 rpm  
Vibration: with standard tool holder (Ø 3,5 mm) 3-10 m/s<sup>2</sup>  
with heavy duty tool holder (Ø 6,4 mm) 4-12 m/s<sup>2</sup>.  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Connector  | Tool holder | Item number: |
|------------|-------------|--------------|
| Diprofil   | Ø 3,5 mm    | FPP/R        |
| Diprofil   | Ø 6,4 mm    | FPM/R        |
| Eneska 3-1 | Ø 3,5 mm    | FPP/ERJ      |
| Eneska 3-1 | Ø 6,4 mm    | FPM/ERJ      |

## Micro Motor Connection - NSK EMax Evolution, ENESKA 3-1 and ENESKA 3-2



The Original Diprofil Filing Machine for NSK EMax Evolution, ENESKA 3-1 and ENESKA 3-2 connection can be supplied with two different tool-holders, standard Ø 3,5 mm (**FPV/NR**) or heavy duty Ø 6,4 mm (**FPT/NR**). Each model is fitted with an ergonomic rubber sleeve. Use motors with low rpm and high torque only.

### Technical data

Stroke length: 0-6 mm (recommended 0,5-3mm)  
Speed: max 8.000 rpm recommended: 5.000 - 7.000 rpm  
Weight: 0,8 kg  
Noise: < 70 dB(A) at 7 000 rpm  
Vibration: with standard tool holder (Ø 3,5 mm) 3-10 m/s<sup>2</sup>  
with heavy duty tool holder (Ø 6,4 mm) 4-12 m/s<sup>2</sup>.  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Tool holder | Item number: |
|-------------|--------------|
| Ø 3,5 mm    | FPV/NR       |
| Ø 6,4 mm    | FPT/NR       |

## Micro Motor Connection - NSK (Espert) & ENESKA 4-1



The Original Diprofil Filing Machine for NSK(Espert)/ENESKA 4-1 connection can be supplied with two different tool-holders, standard Ø 3,5 mm (**FPV/ER**) or heavy duty Ø 6,4 mm (**FPT/ER**). Each model is fitted with an ergonomic rubber sleeve. Technical data is the same as above.

| Tool holder | Item number: |
|-------------|--------------|
| Ø 3,5 mm    | FPV/ER       |
| Ø 6,4 mm    | FPT/ER       |

## **Di-PRO<sup>™</sup> MACHINE SETS - NEW 2013**

**A SELECTION OF DIPROFIL POLISHING-/FILING MACHINES ARE NOW AVAILABLE IN SETS TOGETHER WITH SUITABLE POWER UNITS AND HAND-PIECES AS SPECIFIED BELOW:**

### **Di-PRO<sup>™</sup> SET LARGE**

The largest and most versatile set consisting of the low-vibrating Di-Pro machine with either 3.5 mm or 6.4 mm tool-holder, Twin power unit type TPU-20 and the brushless rotary hand-piece type C-HPM-BL2.

| Specifications                                                                                                          | Item no.  |
|-------------------------------------------------------------------------------------------------------------------------|-----------|
| Di-Pro machine type FXP with 3.5 mm tool-holder, TPU-20-220V power unit and brushless rotary hand-Piece type C-HPM-BL2. | FXP-SET-L |
| Di-Pro machine type FXM with 6.4 mm tool-holder, TPU-20-220V power unit and brushless rotary hand-Piece type C-HPM-BL2. | FXM-SET-L |



### **Di-PRO<sup>™</sup> SET MEDIUM**

Same as the Di-Pro set large but without the rotary hand-piece.

| Specifications                                                                   | Item No.  |
|----------------------------------------------------------------------------------|-----------|
| Di-Pro machine type FXP with 3.5 mm tool-holder and power unit type TPU-20-220V. | FXP-SET-M |
| Di-Pro machine type FXM with 6.4 mm tool-holder and power unit type TPU-20-220V. | FXM-SET-M |



### **Di-PRO<sup>™</sup> SET SMALL**

The most basic set including the low-vibrating Di-Pro machine with either 3.5 mm or 6.4 mm tool-holder and the small power unit type DPU-3.

| Specifications                                                             | Item No.  |
|----------------------------------------------------------------------------|-----------|
| Di-Pro machine type FXP with 3.5 mm tool-holder and power unit type DPU-3. | FXP-SET-S |
| Di-Pro machine type FXM with 6.4 mm tool-holder and power unit type DPU-3. | FXM-SET-S |



# Diprofil Protective Finger Sleeves

To further emphasize our focus on the importance of reducing potentially harmful vibrations we are now introducing the new Diprofil Protective Finger Sleeve.

It's a well known fact that it's actually more common for operators to sustain vibration related injuries in the hand guiding the tool rather than in the hand holding the actual machine. With this in mind we have developed the Diprofil protective finger sleeve. The finger sleeve will improve guidance of the tool as there is no longer any need for putting your fingers on moving tools and/or machine parts.

The finger sleeve is compatible with both the Classic and the low-vibrating Di-Pro polishing-/filing machines and comes with an extension rod for longer tools in two different versions depending on the size of the original tool-holder (Ø 3,5 or 6,4 mm).

For more information on each specific item please see the technical information below.

The old (wrong) way.....



The new (right) way!



The two different models available for either 3,5 or 6,4 mm tool-holders are the following:

- PFS-3,5 Compatible with both the Classic and the low-vibrating Di-Pro polishing-/filing machines fitted with 3,5 mm tool-holders.
- PFS-6,4 Compatible with both the Classic and the low-vibrating Di-Pro polishing-/filing machines fitted with 6,4 mm tool-holders.

Both versions comes in a handy box with the necessary tools and an instruction on how to attach it to your machine.

## Protective Finger Sleeve for the Ø 3,5 mm tool-holder

Outer Ø: 23 mm  
Length (without extension rod): 34 mm  
Length (including extension rod): 91 mm  
Maximum tool shank Ø: 3,5 mm  
Weight (without extension rod): 33 g  
Weight (including extension rod): 50 g

|              |                                                                                                         |
|--------------|---------------------------------------------------------------------------------------------------------|
| Item number: | PFS-3,5 (incl extension rod FSH-3)<br>PFS-3,5-LE (without extension rod FSH-3)<br>FSH-3 (extension rod) |
|--------------|---------------------------------------------------------------------------------------------------------|



PFS-3,5-LE



FSH-3



PFS-3,5



## Protective Finger Sleeve for the Ø 6,4 mm tool-holder

Outer Ø: 26 mm  
Length (without extension rod): 48 mm  
Length (including extension rod): 105 mm  
Maximum tool shank Ø: 6,4 mm  
Weight (without extension rod): 49 g  
Weight (including extension rod): 66 g

|              |                                                                                                         |
|--------------|---------------------------------------------------------------------------------------------------------|
| Item number: | PFS-6,4 (incl extension rod FSH-3)<br>PFS-6,4-LE (without extension rod FSH-3)<br>FSH-3 (extension rod) |
|--------------|---------------------------------------------------------------------------------------------------------|



PFS-6,4-LE



FSH-3



PFS-6,4



# DIPROMINI

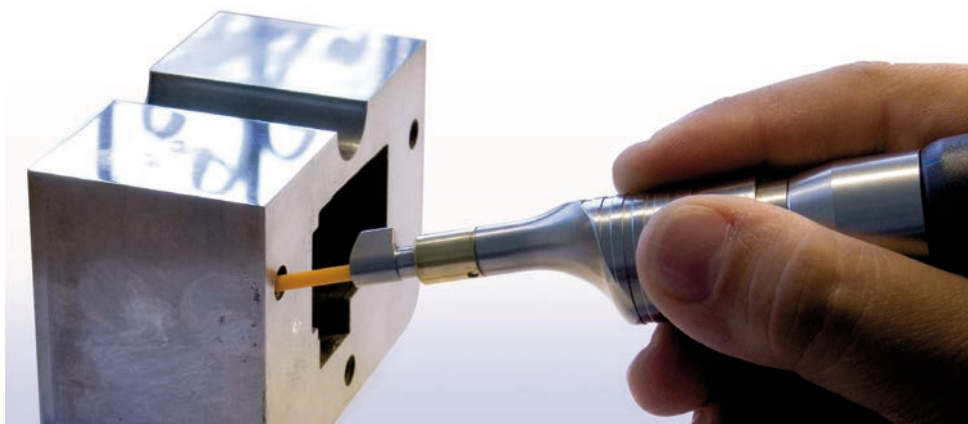
## DIPROFIL MINI POLISHING/FILING MACHINE

The natural choice when working in narrow and confined spaces. The compact and handy dimension makes it excellent for polishing and finishing applications on small and hard to reach surfaces. Using the Dipromini gives you total control even when working in the narrowest spaces on a delicate work-piece.

Dipromini machines are available with stroke length 0.5, 1.0 or 1.5 mm and connections for a wide variety of drive-sources.

For lowest possible vibration levels we recommend using light weight tools and tool-holders such as the THFS-1 and the THPS-3 (page 62).

All Dipromini machines are delivered in a handy tool-box with the necessary accessories.



## Flexible-Shaft Drive - Slip Joint Connection

The Diprofil Mini Polishing/Filing machine for flexible-shaft drive is available for connection to Slip Joint. There are three basic models with 0.5 mm (FMR/S5), 1.0 mm (FMR/S10) or 1.5 mm (FMR/S15) stroke length.

### Technical data

|                |                                                                                                                             |
|----------------|-----------------------------------------------------------------------------------------------------------------------------|
| Tool holder:   | max Ø 3,6 mm                                                                                                                |
| Stroke length: | 0,5, 1,0 or 1,5 mm                                                                                                          |
| Speed:         | max 12.000 rpm recommended: 5.000 - 11.000 rpm                                                                              |
| Dimension:     | Ø 24 mm                                                                                                                     |
| Weight:        | approx. 120 g                                                                                                               |
| Noise:         | < 70 dB(A) at 9.000 rpm                                                                                                     |
| Vibrations:    | stroke 0,5 mm: <2,5 m/s <sup>2</sup> , stroke 1,0 mm: 1,5 - 3 m/s <sup>2</sup> ,<br>stroke 1,5 mm: 1,5 - 4 m/s <sup>2</sup> |

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8.

For further details, see diagram and other information in the corresponding Operation Guide.



| Stroke length | Item number |
|---------------|-------------|
| 0.5 mm        | FMR/S5      |
| 1.0 mm        | FMR/S10     |
| 1.5 mm        | FMR/S15     |

|        |         |
|--------|---------|
| 0.5 mm | FMR/S5  |
| 1.0 mm | FMR/S10 |
| 1.5 mm | FMR/S15 |

## Flexible-Shaft Drive - Ball Joint Connection

The Diprofil Mini Polishing/Filing machine for flexible-shaftdrive is available for connection to Ball Joint. There are three basic models with 0.5 mm (FMR/B5), 1.0 mm (FMR/B10) or 1.5 mm (FMR/B15) stroke length. Technical data is the same as above.

| Stroke length | Item number |
|---------------|-------------|
| 0.5 mm        | FMR/B5      |
| 1.0 mm        | FMR/B10     |
| 1.5 mm        | FMR/B15     |

|        |         |
|--------|---------|
| 0.5 mm | FMR/B5  |
| 1.0 mm | FMR/B10 |
| 1.5 mm | FMR/B15 |



## Micro Motor Connection - Gesswein, Argofile & Uhandy

The Dipromini Filing Machine for Gesswein, Argofile and Uhandy connection can be supplied with three different stroke lengths: 0.5 mm (FMR/G5), 1.0 mm (FMR/G10) or 1.5 mm (FMR/G15).

Technical data is the same as above.

| Stroke length | Item number |
|---------------|-------------|
| 0.5 mm        | FMR/G5      |
| 1.0 mm        | FMR/G10     |
| 1.5 mm        | FMR/G15     |

|        |         |
|--------|---------|
| 0.5 mm | FMR/G5  |
| 1.0 mm | FMR/G10 |
| 1.5 mm | FMR/G15 |





## Micro Motor Connection - NSK EMax Evolution, Eneska 3-1 and Eneska 3-2



The Dipromini Filing Machine for NSK EMax Evolution, Eneska 3-1 or 3-2 connection can be supplied with three different stroke lengths: 0,5 mm (FMR/N5), 1,0 mm (FMR/N10) or 1,5 mm (FMR/N15).

### Technical data

Tool holder: max Ø 3,6 mm  
Stroke length: 0,5, 1,0 or 1,5 mm  
Speed: max 12.000 rpm recommended: 5.000 - 11.000 rpm  
Dimension: Ø 24 mm  
Weight: approx. 120 g  
Noise: < 70 dB(A) at 9.000 rpm  
Vibrations: stroke 0,5 mm: <2,5 m/s<sup>2</sup>, stroke 1,0 mm: 1,5 - 3 m/s<sup>2</sup>,  
stroke 1,5 mm: 1,5 - 4 m/s<sup>2</sup>

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Stroke length | Item number |
|---------------|-------------|
| 0,5 mm        | FMR/N5      |
| 1,0 mm        | FMR/N10     |
| 1,5 mm        | FMR/N15     |

## Micro Motor Connection - NSK (Espert) and Eneska 4-1



The Dipromini Filing Machine for NSK and Eneska 4-1 connection can be supplied with three different stroke lengths: 0,5 mm (FMR/E5), 1,0 mm (FMR/E10) or 1,5 mm (FMR/E15).

### Technical data

Tool holder: max Ø 3,6 mm  
Stroke length: 0,5, 1,0 or 1,5 mm  
Speed: max 12.000 rpm recommended: 5.000 - 11.000 rpm  
Dimension: Ø 24 mm  
Weight: approx. 120 g  
Noise: < 70 dB(A) at 9.000 rpm  
Vibrations: stroke 0,5 mm: <2,5 m/s<sup>2</sup>, stroke 1,0 mm: 1,5 - 3 m/s<sup>2</sup>,  
stroke 1,5 mm: 1,5 - 4 m/s<sup>2</sup>

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Stroke length | Item number |
|---------------|-------------|
| 0,5 mm        | FMR/E5      |
| 1,0 mm        | FMR/E10     |
| 1,5 mm        | FMR/E15     |

## Micro Motor Connection - Diprofil Motor type HPM-B1



Dipromini polishing/filing Machine with connection for Diprofil micro motor type HPM-B1 which should be connected to, and controlled by, the DIPROFIL DPU-3, TPU-20 or corresponding power units. Available with three different stroke lengths: 0,5 mm (FMR/D5), 1,0 mm (FMR/D10) or 1,5 mm (FMR/D15).

### Technical data

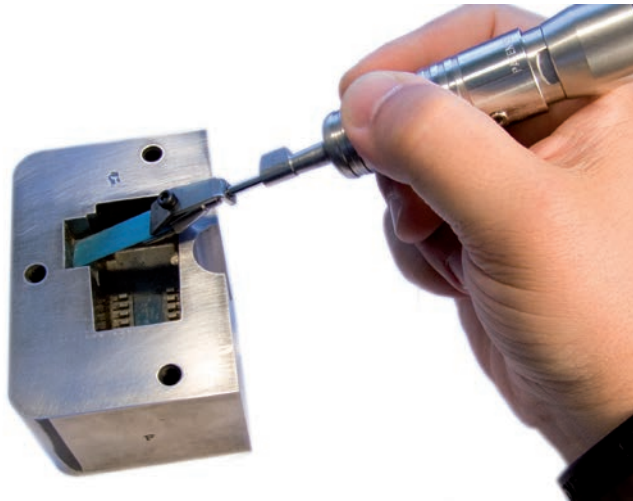
Tool holder: max Ø 3,6 mm  
Stroke length: 0,5, 1,0 or 1,5 mm  
Speed: max 12.000 rpm recommended: 5.000 - 11.000 rpm  
Dimension: Ø 24 mm  
Weight: approx. 120 g  
Noise: < 70 dB(A) at 9.000 rpm  
Vibrations: stroke 0,5 mm: <2,5 m/s<sup>2</sup>, stroke 1,0 mm: 1,5 - 3 m/s<sup>2</sup>,  
stroke 1,5 mm: 1,5 - 4 m/s<sup>2</sup>

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

| Stroke length | Item number |
|---------------|-------------|
| 0,5 mm        | FMR/D5      |
| 1,0 mm        | FMR/D10     |
| 1,5 mm        | FMR/D15     |

# DIPROMINI TRANSVERSE

## DIPROFIL TRANSVERSE MINI POLISHING/FILING MACHINE



The Dipromini Transverse with its swinging side to side movement is ideal when working on difficult surfaces such as narrow shoulders and ribs. The side to side movement also makes it possible to polish the bottom surface in i.e. cavities without damaging the side walls.

Variable stroke between 0-4 mm, that is easy to change by use of a hexagon key. The small and handy dimension improves control and effectiveness for polishing and finishing work. For the lowest possible vibration levels we recommend using light weight tools and tool-holders such as the THFS-1 and the THPS-3 (page 62).

All Dipromini Transverse machines are delivered in a handy tool-box with the necessary accessories.

## Flexible-shaft Drive - Slip Joint Connection



The Diprofil Transverse Mini Polishing/Filing machine for flexible-shaft drive is available for connection to Slip-joint (FMV/S).

### Technical data

|                |                                                                         |
|----------------|-------------------------------------------------------------------------|
| Tool holder:   | max Ø 3,6 mm                                                            |
| Stroke length: | Variable stroke 0-4 mm (measured 60 mm from the machine housing)        |
| Speed:         | max 12.000 rpm (at max 2 mm stroke length) recommended 5.000-11.000 rpm |
| Dimension:     | Ø 24 mm                                                                 |
| Weight:        | 235 g                                                                   |
| Noise:         | < 78 dB(A) at 12.000 rpm                                                |
| Vibrations:    | 1,5 - 3,5 m/s <sup>2</sup>                                              |

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8.

For further details, see diagram and other information in the corresponding Operation Guide.

Item number: FMV/S

## Flexible-shaft Drive - Ball Joint Connection



The Diprofil Transverse Mini Polishing/Filing machine for flexible-shaft drive is available for connection to Ball-joint (FMV/B). Technical data is the same as or for FMV/S.

Item number: FMV/B

# Micro Motor Connection - NSK EMax Evolution, Eneska 3-1 and Eneska 3-2

The Diprofil Transverse Mini Polishing/Filing machine is available for NSK EMax Evolution, Eneska 3-1 and Eneska 3-2 connection (FMV/N).

## Technical data

Tool holder: max Ø 3,6 mm  
Stroke length: variable stroke 0-4 mm (measured 60 mm from the machine housing)  
Speed: max 12.000 rpm (at max 2 mm stroke length) recommended 5.000-11.000 rpm  
Dimension: Ø 24 mm  
Weight: 205 g  
Noise: < 78 dB(A) at 12.000 rpm  
Vibrations: 1,5 - 3,5 m/s<sup>2</sup>  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

Item number: FMV/N



## Micro Motor Connection - NSK and Eneska 4-1

The Diprofil Transverse Mini Polishing/Filing machine is available for NSK and Eneska 4 connection (FMV/E).

### Technical data

Tool holder: max Ø 3,6 mm  
Stroke length: variable stroke 0-4 mm (measured 60 mm from the machine housing)  
Speed: max 12.000 rpm (at max 2 mm stroke length) recommended 5.000-11.000 rpm  
Dimension: Ø 24 mm  
Weight: 210 g  
Noise: < 78 dB(A) at 12.000 rpm  
Vibrations: 1,5 - 3,5 m/s<sup>2</sup>  
Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

Item number: FMV/E



## Micro Motor Connection - Gesswein, Argofile & Uhandy

The Diprofil Transverse Mini Polishing/Filing machine is available for Gesswein, Argofile and Uhandy connection (FMV/G). Technical data is the same as or for FMV/E.

Item number: FMV/G



## Micro Motor Connection - Diprofil Motor type HPM-B1

Dipromini Transverse polishing/filing machine with connection for Diprofil micro motor type HPM-B1 (FMV/D) which should be connected to, and controlled by, the DIPROFIL DPU-3, TPU-20 or corresponding power units.

### Technical data

Tool holder: max Ø 3,6 mm  
Stroke length: variable stroke 0-4 mm (measured 60 mm from the machine housing)  
Speed: max 12.000 rpm (at max 2 mm stroke length) recommended 5.000-11.000 rpm  
Dimension: Ø 24 mm  
Weight: 195 g  
Noise: < 78 dB(A) at 12.000 rpm  
Vibrations: 1,5 - 3,5 m/s<sup>2</sup>

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8. For further details, see diagram and other information in the corresponding Operation Guide.

Item number: FMV/D



## MACHINE SETS - **NEW 2013**

**A SELECTION OF DIPROMINI AND DIPROMINI TRANSVERSE MACHINES ARE NOW AVAILABLE IN SETS TOGETHER WITH SUITABLE MICRO-MOTORS AND POWER UNITS.**

### **DIPROMINI SET**

Set including the Dipromini polishing-/filing machine with either 0.5, 1.0 or 1.5 mm stroke length, suitable micro-motor type HPM-B1 and power unit type DPU-3.

| Specifications                                                                                  | Item No.    |
|-------------------------------------------------------------------------------------------------|-------------|
| Dipromini machine with 0.5 mm stroke length, micro-motor type HPM-B1 and power unit type DPU-3. | FMR-SET-5S  |
| Dipromini machine with 1.0 mm stroke length, micro-motor type HPM-B1 and power unit type DPU-3. | FMR-SET-10S |
| Dipromini machine with 1.5 mm stroke length, micro-motor type HPM-B1 and power unit type DPU-3. | FMR-SET-15S |



### **DIPROMINI TRANSVERSE SET**

Set including the Dipromini Transverse machine, suitable micro-motor type HPM-B1 and power unit type DPU-3.

| Specifications                                                                   | Item No.  |
|----------------------------------------------------------------------------------|-----------|
| Dipromini Transverse machine, micro-motor type HPM-B1 and power unit type DPU-3. | FMV-SET-S |



### **POWER UNIT – ROTARY HAND-PIECE SET**

A very basic and price efficient set consisting of power unit type DPU-3 and the rotary hand-piece type C-HPM-B1.

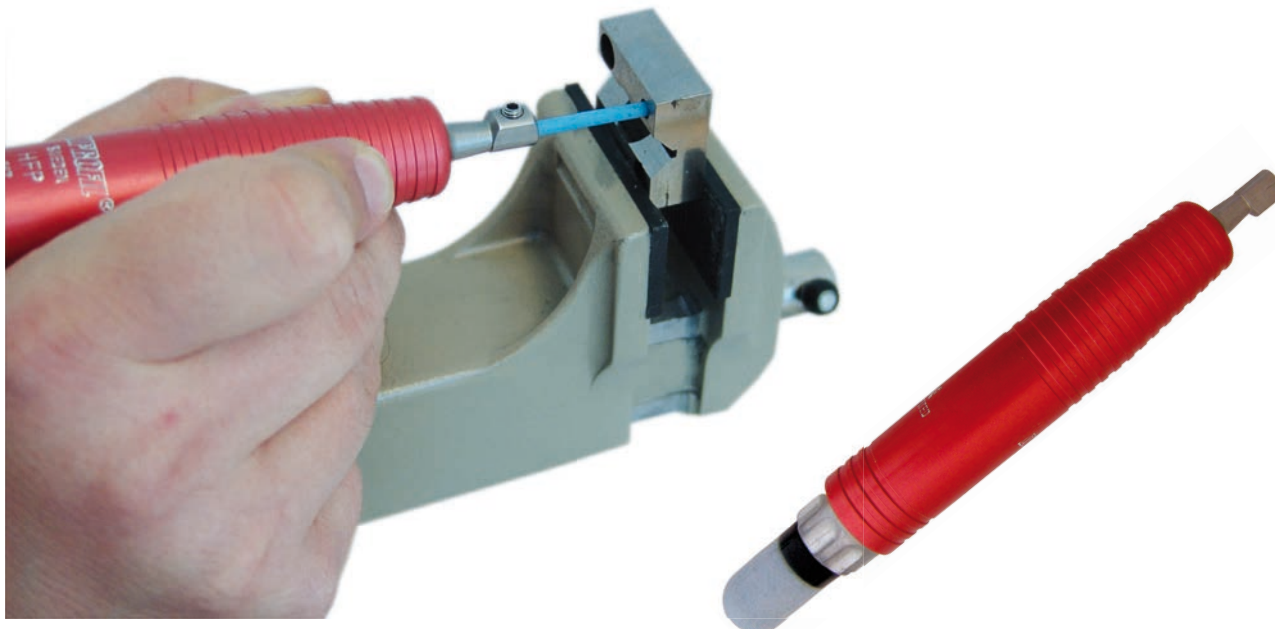
| Specifications                                             | Item No.  |
|------------------------------------------------------------|-----------|
| Power unit type DPU-3 and rotary hand-piece type C-HPM-B1. | DPU-SET-S |





# DIPROFIL HFP

## HIGH SPEED POLISHING MACHINE



The machine is a recommended alternative to ultrasonic finishing and polishing of small surfaces. Diprofil HFP is air-driven and the stroke is generated by two unbalanced weights built to avoid vibrations in the handle. Even when working against a shoulder no vibrations are generated into the handle.

The airmotor is manufactured with a very high level of accuracy and requires lubricated and filtered air (5 $\mu$ ) to obtain a long and trouble-free lifetime.

Most of Diprofil standard polishing tools are suitable in HFP: Tool holders, Super stones, Polishing stones, Diamond compound, Brass and Wooden sticks. For lowest possible vibration levels we recommend using light weight tools and tool-holders such as the THFS-1 and THPS-3 (page 62).

All Diprofil machines are delivered in a handy tool-box with the necessary accessories.

## Air Drive



**The Diprofil HFP** comes delivered in a handy tool-box containing:

- 1 polishing machine type HFP
- 1 Tool holder type FMR/VH
- 2 Hexagon keys
- 1,5 m air tube
- 1 Tube coupling R 1/8"
- 1 Lubricating oil

### Technical data

|              |                                   |
|--------------|-----------------------------------|
| Driving:     | lubricated air 4-6 bar            |
| Frequency:   | 20.000 strokes/min.               |
| Tool holder: | Ø 3,6 mm                          |
| Stroke:      | 0,25 mm                           |
| Weight:      | 190 g                             |
| Noise:       | < 80 db(A) at 20.000 strokes/min. |
| Vibrations:  | < 2,5 m/s <sup>2</sup>            |

Frequency weighed hand/arm vibration, principally in accordance with ISO 28927-8.

For further details, see diagram and other information in the corresponding Operation Guide.

Item number: HFP

# ROTARY HANDPIECES

*FOR EFFICIENT POLISHING AND FINISHING OPERATIONS*



Rotary handpieces for efficient grinding, polishing and finishing operations with tools such as diamond and CBN pins, felt bobs and wood bobs.

All rotary hand pieces comes with the necessary tools and accessories.

## Flexible-Shaft Drive - Slip Joint Connection



**Straight Rotary Hand-piece** supplied with collet Ø 2,35 mm (HSE-D2,35) or Ø 3,0 mm (HSE-D3,0).

### Technical data

|             |                          |
|-------------|--------------------------|
| Speed:      | Max. 22.000 rpm          |
| Weight:     | 110 g                    |
| Noise:      | < 70 db(A) at 15.000 rpm |
| Vibrations: | < 2,5 m/s <sup>2</sup>   |

| Collet    | Item number |
|-----------|-------------|
| Ø 2,35 mm | HSE/D2,35   |
| Ø 3,0 mm  | HSE/D3,0    |

## Flexible-Shaft Drive – Slip Joint Connection

**Right-angle Hand-piece** with ergonomic rubber grip supplied with collet Ø 3,0 mm (RSH-31300/R). Optional Ø 2,35 mm collet available as accessory.



### Technical data

|             |                                    |
|-------------|------------------------------------|
| Collet:     | Ø 3,0 mm                           |
| Speed:      | max. 18.000 rpm                    |
| Weight:     | 170 g                              |
| Dimensions: | L165 x Ø 26 mm (head Ø 17 x 27 mm) |
| Noise:      | < 75 db(A) at 18.000 rpm           |
| Vibrations: | < 2,5 m/s <sup>2</sup>             |

Item number: RSH-31300/R

## Flexible-Shaft Drive - Slip Joint Connection

**Straight Hand-piece** with ergonomic rubber grip including collet Ø 3,0 mm (RSH-20/R). Optional collets Ø 2,35, Ø 6,0, Ø 1/8" and Ø 1/4" available as accessories.



### Technical data

|             |                          |
|-------------|--------------------------|
| Collet:     | Ø 3,0 mm                 |
| Speed:      | max. 22.000 rpm          |
| Weight:     | 160 g                    |
| Dimensions: | Ø 25 x 138 mm            |
| Noise:      | < 70 db(A) at 15.000 rpm |
| Vibrations: | < 2,5 m/s <sup>2</sup>   |

Item number: RSH-20/R

## Rotary Hand-piece - C-HPM-B1

**Micro-motor driven high speed rotary hand-piece with carbon brush motor** for use together with power unit DPU-3 or twin power unit TPU-20. Features a quick change design for both the collet and the tool and is supplied with 3,0 mm collet. Optional 2,35 mm collet available.



### Technical data

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 38.000 rpm          |
| Consumed power: | 100 W                    |
| Torque:         | 4,0N cm                  |
| Weight:         | 285 g                    |
| Dimensions:     | L159 x Ø29,5 mm          |
| Noise:          | < 70 db(A) at 38.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: C-HPM-B1

## Brushless Rotary Hand-piece - C-HPM-BL1



**Micro-motor driven rotary hand-piece with brushless motor** for use together with twin power unit TPU-20. Features a quick change design for both the collet and the tool and is supplied with 3,0 mm collet. Optional 2,35 mm collet available.

### Technical data

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 40.000 rpm          |
| Consumed power: | max. 230 W               |
| Torque:         | 8,5N cm                  |
| Weight:         | 350 g                    |
| Dimensions:     | L159 x Ø27 mm            |
| Noise:          | < 70 db(A) at 40.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: C-HPM-BL1

## Brushless Rotary Hand-piece - C-HPM-BL2



**Micro-motor driven high speed rotary hand-piece with brushless motor** for use together with twin power unit TPU-20. Features a quick change design for both the collet and the tool and is supplied with 3,0 mm collet. Optional 2,35 mm collet available.

### Technical data

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 50.000 rpm          |
| Consumed power: | max. 230 W               |
| Torque:         | 7,6N cm                  |
| Weight:         | 350 g                    |
| Dimensions:     | L159 x Ø27 mm            |
| Noise:          | < 70 db(A) at 50.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: C-HPM-BL2

# DRIVE SOURCES

## DRIVE SOURCES, POWER UNITS AND MACHINE ACCESSORIES

### Diprofil Power Unit - DPU-3



**This compact and ergonomic Power Unit** is designed for use together with dedicated rotary hand-pieces and micro-motor driven reciprocating Diprofil polishing/filing machines with carbon brush motors. It has high torque and electrical feedback circuitry. Other features include continuously variable speed, forward / reverse switch and automatic overload protection. Supplied with foot control type DPU-3-FC for optional speed adjustment.

### Technical data

|                        |                          |
|------------------------|--------------------------|
| Input:                 | AC 110/220 V at 50/60 Hz |
| Output:                | DC 0 – 32 V, 1,2 A       |
| Power:                 | max. 100 W               |
| Weight Power unit:     | 1,7 kg                   |
| Dimensions Power unit: | W115 x D147 x H96 mm     |
| Weight Foot control:   | 585 g                    |

Item number: DPU-3



## Micro-motor - HPM-B1

DC micro-motor adapted for Diprofil mini polishing/filing machines type FMR/D, FMV/D and rotary hand-piece type C-HPM-B1. For use together with power unit DPU-3 or twin power unit TPU-20.



### Technical data

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 38.000 rpm          |
| Consumed power: | 100 W                    |
| Torque:         | 4,0N cm                  |
| Weight:         | 190 g                    |
| Dimensions:     | L100 x Ø29,5 mm          |
| Noise:          | < 70 db(A) at 38.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: HPM-B1

## Diprofil Twin Power Unit - TPU-20

Twin power unit featuring dual control system for both brushless and carbon brush micro-motors (not simultaneously). Variable speed control by hand dial or the included foot control type TPU-20-FC. Supplied with hand-piece cradle and a convenient magnetic tool holder.



- Digital display showing the speed in rpm
- Maximum torque set mode
- Maximum speed set mode
- Built in handle for best portability
- Error code display function
- Foot control with auto-cruise speed function
- Self diagnosis system

### Technical data

|                        |                                          |
|------------------------|------------------------------------------|
| Input:                 | AC 200 ~ 240 V at 50/60 Hz               |
| Output:                | DC 0 – 32 V, 1,6 A, BLDC 0 – 32 V, 1,6 A |
| Power DC:              | max. 185 W                               |
| Power BLDC:            | max. 245 W                               |
| Weight Power unit:     | 2,9 kg                                   |
| Dimensions Power unit: | W137 x D232 x H180 mm                    |
| Weight Foot control:   | 575 g                                    |

|                |                     |
|----------------|---------------------|
| <b>Voltage</b> | <b>Item number:</b> |
| 220V           | TPU-20-220V         |
| 110V           | TPU-20-110V         |

## Brushless Micro-motors - HPM-BL1 + HPM-BL2

Brushless micro-motor for use together with twin power unit TPU-20.



### Technical data:

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 40.000 rpm          |
| Consumed power: | max. 230 W               |
| Torque:         | 8,5N cm                  |
| Weight:         | 255 g                    |
| Dimensions:     | L100 x Ø27 mm            |
| Noise:          | < 70 db(A) at 40.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: HPM-BL1

### Technical data:

|                 |                          |
|-----------------|--------------------------|
| Speed:          | max. 50.000 rpm          |
| Consumed power: | max. 230 W               |
| Torque:         | 7,6N cm                  |
| Weight:         | 255 g                    |
| Dimensions:     | L100 x Ø27 mm            |
| Noise:          | < 70 db(A) at 50.000 rpm |
| Vibrations:     | < 2,5 m/s <sup>2</sup>   |

Item number: HPM-BL2



Adapter for connecting Urawa, Argofile and Gesswein front-pieces to the Diprofil micro-motors type HPM-BL1 and HPM-B1 (when using DC motor type HPM-B1 a specific shaft with item no. D/G-7 is also required).

Item number: D/G

# Hanging Motor - For Slip Joint Connection



The **DSE-47 Hanging motor** with Flexible Shaft and foot control is the natural choice of power source when working with flexible shaft driven polishing/filing machines and rotary handpieces.

## Technical data

|               |                          |
|---------------|--------------------------|
| Input:        | AC 115/230V              |
| Power output: | 150 W                    |
| Speed:        | max 15.000 rpm           |
| Voltage:      | 220V                     |
| Noise:        | < 70 db(A) at 15.000 rpm |
| Vibrations:   | < 2,5 m/s <sup>2</sup>   |

Item number: DSE-47-220V

## Flexible Shaft



Flexible-shaft (**UKB-3/30T**) with slip joint connection for the DSE-47 motor.  
Inner cable Ø 5 mm.

Item number: UKB-3/30T

## Suspension Stand



Suspension stand for hanging motors (**UGC**).

Item number: UGC

## Lubrication



MFB

The **Dipro-fog (MFB)** package consists of air filter, regulator, manometer, and fog lubrication device, all in one, with tubing and Dipro-fog oil (**MFA-K**).

## Technical data

|                        |              |
|------------------------|--------------|
| Max primary pressure:  | 16 bar       |
| Max capacity at 7 bar: | 1200 l/min   |
| Hose connection:       | 7 mm         |
| Secondary pressure:    | 0,5 - 10 bar |

| Description             | Item number |
|-------------------------|-------------|
| Dipro-fog               | MFB         |
| Lubrication Oil (0,5 l) | MFA-K       |



MFA-K

## Accessories for Air-Driven Machines



HSL-M

Each air-driven machine requires a quick coupling (**HSL-M**) as well as a fog lubricating device type Dipro-fog MFB to ensure efficient lubrication at all times.  
A 3-way hose connection and air hose is also available.

| Description           | Item number |
|-----------------------|-------------|
| Quick Coupling        | HSL-M       |
| 3-way hose connection | MFA-T2      |
| Air Hose              | MFA-S       |

# DIPROSONIC DUS-300

## ULTRASONIC FINISHING/POLISHING SYSTEM



### Accessories (all included with the DUS-300 package)

- Ultrasonic Hand-piece for DUS-300 (DUS-300-HP)
- Hand-piece Cable (DUS-5)
- Power Cord - US type 110V (DUS-6)
- Power Cord - European type 220V (DUS-7)
- Foot-switch (DUS-300-FS)
- 10/11mm Spanner (DUS-8)
- 2,5 mm Hex-key (DUS-9)
- Hand-piece stand (DUS-10)
- Tool-holder 1,1 mm (DUS-11)
- Tool-holder Diam. 3 mm (DUS-30)
- Tool kit Complete, more information below (DUS-300-TK)

The DIPROSONIC DUS-300 is the new and improved Ultrasonic Finishing System from Diprofil.

The Ultrasonic system's main advantage is its very short stroke length (10 – 35  $\mu$ m) at a very high frequency (18 – 25 kHz). This makes this unit ideal for working in narrow and confined spaces such as cavities and slots where a short stroke length is preferable. For this kind of delicate work, the DIPROSONIC will give you precise finishing with rapid stock removal in a relatively clean environment without the need for lubricating fluids etc.

The Unit is excellent for use together with Ceramic Fibre Stones and Sintered Diamond Files, but it is also possible to use Electro-plated Diamond Files as long as the shank of the used tool is kept as short as possible.

Operation is optional by hand or the included Foot-switch and the Unit will automatically find the right frequency for each tool.

### Technical data

#### Control Unit

|                          |                             |
|--------------------------|-----------------------------|
| Input:                   | AC 90 – 250 V, 50/60 Hz     |
| Ultrasonic Power Output: | 36 W                        |
| Frequency:               | 18 – 25 kHz                 |
| Stroke:                  | 10 – 35 $\mu$ m             |
| Dimensions:              | 144(W) x 195 (D) x 95(H) mm |
| Weight:                  | 658 g                       |

#### Handpiece

|              |                           |
|--------------|---------------------------|
| Cord length: | 1500 mm                   |
| Dimensions:  | $\varnothing$ 30 x 131 mm |
| Weight:      | 185 g                     |

#### Important Features

- 36 W max output
- Two output levels (high / low)
- Capable of long working periods
- Auto feedback system
- Small, compact and low weight

Item number: DUS-300

## Files and Fibre Stones tool-kit, containing:

- Fibre Stone 4x1x75 mm, grit 250.
- Fibre Stone 4x1x75 mm, grit 400.
- Fibre Stone 4x1x75 mm, grit 700.
- Fibre Stone 6x1x75 mm, grit 250.
- Fibre Stone 6x1x75 mm, grit 400.
- Fibre Stone 6x1x75 mm, grit 700.
- Sintered Diamond File, 4x1x75 mm, grit 200.
- Sintered Diamond File, 4x1x75 mm, grit 400.
- Sintered Diamond File, 6x1x75 mm, grit 200.
- Sintered Diamond File, 6x1x75 mm, grit 400.

#### Separate Item numbers:

CFS-41-250  
CFS-41-400  
CFS-41-700  
CFS-61-250  
CFS-61-400  
CFS-61-700  
DLU-645  
DLU-646  
DLU-710  
DLU-711



Item number: DUS-300-TK

# DIPROFIL DIAMOND FILES

## ORIGINAL DIPROFIL PRECISION DIAMOND FILES

Diprofil Diamond Files are made from carefully selected diamonds, precisely bonded to obtain the best physical properties for added strength and resistance to wear. Diamond files are excellent for use on carbide, hardened steel, glass, ceramics and other similar materials.

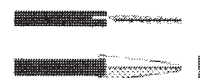
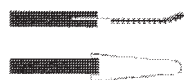
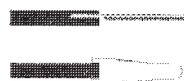
Other shapes, dimensions and grit sizes available on request.



## DLT - LTA Filing tips

For use with Dipromini polishing-/filing machines.

All DLT and LTA-files are sold in packages of 3 pcs.



|  | Description                                                                                                   | Colour Code | Grit size | Item number |
|--|---------------------------------------------------------------------------------------------------------------|-------------|-----------|-------------|
|  | Diamond Filing Tips, from 30 micron to FEPA D181. A thin tip with rectangular shape, for use on all surfaces. | Red         | D181      | DLT-10-150  |
|  |                                                                                                               | Green       | D151      | DLT-10-100  |
|  |                                                                                                               | Yellow      | D64       | DLT-10-50   |
|  |                                                                                                               | White       | 30 micron | DLT-10-30   |
|  | Diamond Filing Tips, from 30 micron to FEPA D151. A thin tip with spatula shape, for use in narrow spaces.    | Red         | D181      | DLT-20-150  |
|  |                                                                                                               | Green       | D151      | DLT-20-100  |
|  |                                                                                                               | Yellow      | D64       | DLT-20-50   |
|  |                                                                                                               | White       | 30 micron | DLT-20-30   |
|  | Diamond Filing Tip, FEPA D64. For use on concave surfaces.                                                    | Yellow      | D64       | LTA-E50/3   |
|  | Diamond Filing Tips, From 15 micron to FEPA D181. For use on concave surfaces.                                | Red         | D181      | LTA-S150/3  |
|  |                                                                                                               | Green       | D151      | LTA-S100/3  |
|  |                                                                                                               | Gold        | D107      | LTA-S75/3   |
|  |                                                                                                               | Yellow      | D64       | LTA-S50/3   |
|  |                                                                                                               | White       | 30 micron | LTA-S30/3   |
|  |                                                                                                               | Violet      | 15 micron | LTA-S15/3   |

## Filing tip holders

Tool-holder to be used together with diamond tips type DLT/LTA in the Dipromini polishing-/filing machines.  
Available in length 40 or 80 mm.

| Tool holder         | Item number: |
|---------------------|--------------|
| 40 mm               | FMR-20       |
| 80 mm               | FMR-21       |
| Set of both holders | FMR-20/21    |



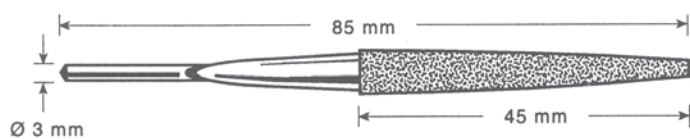
# DLA® - Machine Files



| Standard Files                                                                    |           | Item number    |                 |                 |
|-----------------------------------------------------------------------------------|-----------|----------------|-----------------|-----------------|
| Shape                                                                             | Size (mm) | Grit D64       | Grit D151       | Grit D181       |
|  | 2x1       | DLA-2x1S-D64   | DLA-2x1S-D151   | DLA-2x1S-D181   |
|                                                                                   | 3x1       | DLA-3x1S-D64   | DLA-3x1S-D151   | DLA-3x1S-D181   |
|                                                                                   | 4x1       | DLA-4x1S-D64   | DLA-4x1S-D151   | DLA-4x1S-D181   |
|                                                                                   | 4x2       | DLA-4x2S-D64   | DLA-4x2S-D151   | DLA-4x2S-D181   |
|                                                                                   | 5x2       | DLA-5x2S-D64   | DLA-5x2S-D151   | DLA-5x2S-D181   |
|  | Ø 1       | DLA-1-D64      | DLA-1-D151      | DLA-1-D181      |
|                                                                                   | Ø 2       | DLA-2-D64      | DLA-2-D151      | DLA-2-D181      |
|                                                                                   | Ø 3       | DLA-3-D64      | DLA-3-D151      | DLA-3-D181      |
|                                                                                   | Ø 4       | DLA-4-D64      | DLA-4-D151      | DLA-4-D181      |
|  | 2x2x2     |                | DLA-T2S-D151    |                 |
|                                                                                   | 3x3x3     |                | DLA-T3S-D151    |                 |
|                                                                                   | 4x4x4     |                | DLA-T4S-D151    |                 |
|  | R = 1     |                | DLA-R1S-D151    |                 |
|                                                                                   | R = 1,5   |                | DLA-R1,5S-D151  |                 |
|                                                                                   | R = 2     |                | DLA-R2S-D151    |                 |
|  | R = 2,5x5 | DLA-R2,5R5-D64 | DLA-R2,5R5-D151 | DLA-R2,5R5-D181 |

| Safe Sided Files                                                                    |           | Grit D64    | Grit D151      | Grit D181    |
|-------------------------------------------------------------------------------------|-----------|-------------|----------------|--------------|
| Shape                                                                               | Size (mm) |             |                |              |
|    | 2x1       | DLA-2x1-D64 | DLA-2x1-D151   | DLA-2x1-D181 |
|                                                                                     | 3x1       | DLA-3x1-D64 | DLA-3x1-D151   | DLA-3x1-D181 |
|                                                                                     | 4x1       | DLA-4x1-D64 | DLA-4x1-D151   | DLA-4x1-D181 |
|                                                                                     | 5x2       | DLA-5x2-D64 | DLA-5x2-D151   | DLA-5x2-D181 |
|  | 0,5x4     |             | DLA-0,5x4-D151 |              |
|                                                                                     | 1x4       |             | DLA-1x4-D151   |              |
|  | 2x2x2     | DLA-T2-D64  | DLA-T2-D151    | DLA-T2-D181  |
|                                                                                     | 3x3x3     | DLA-T3-D64  | DLA-T3-D151    | DLA-T3-D181  |
|                                                                                     | 4x4x4     | DLA-T4-D64  | DLA-T4-D151    | DLA-T4-D181  |
|  | R = 1     |             | DLA-R1-D151    |              |
|                                                                                     | R = 1,5   |             | DLA-R1,5-D151  |              |
|                                                                                     | R = 2     |             | DLA-R2-D151    |              |

# DLE - Machine Files



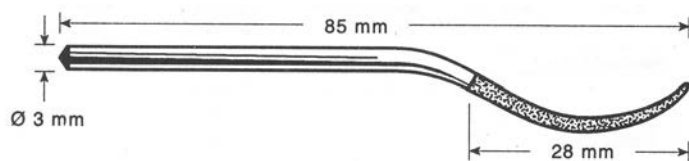
| Standard Files |             | Item number |
|----------------|-------------|-------------|
| Shape          | Size (mm)   | Grit D151   |
|                | 5x2         | DLE-11-D151 |
|                | Ø 3         | DLE-2-D151  |
|                | 5x2         | DLE-30-D151 |
|                | 5x2         | DLE-4-D151  |
|                | 3,5x3,5x3,5 | DLE-5-D151  |
|                | 2,5x2,5     | DLE-6-D151  |

| Safe Sided Files |           | Grit D151  |
|------------------|-----------|------------|
| Shape            | Size (mm) |            |
|                  | 5x2       | DLE-1-D151 |
|                  | 5x2       | DLE-3-D151 |

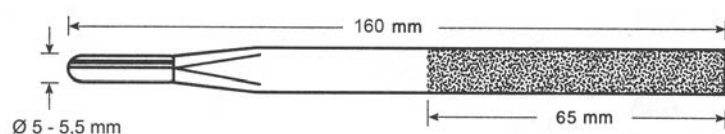


## DLF - Machine Files



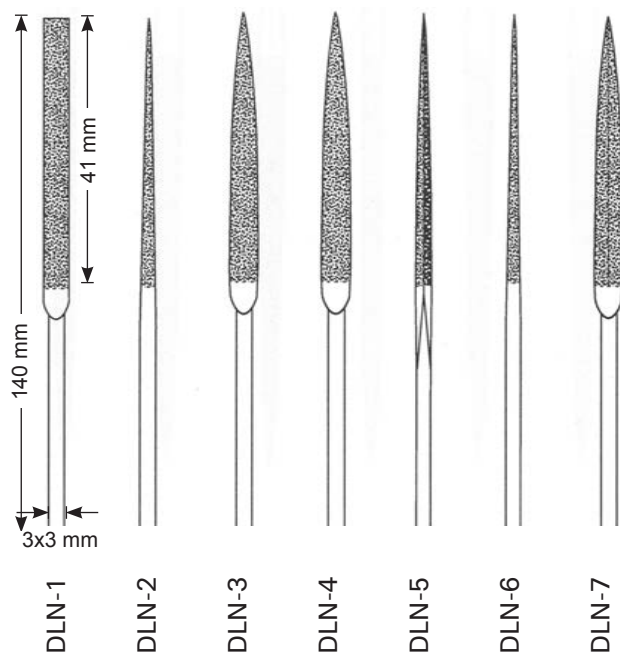
|       |           | Item number |
|-------|-----------|-------------|
| Shape | Size (mm) | Grit D151   |
|       | 4,5x2,5   | DLF-1-D151  |
|       | Ø 3       | DLF-2-D151  |
|       | 5x2,5     | DLF-4-D151  |
|       | 3x3       | DLF-6-D151  |

## DLK - Machine File



|       |           | Item number |
|-------|-----------|-------------|
| Shape | Size (mm) | Grit D151   |
|       | 10x2,5    | DLK-11-D151 |

## DLN - Hand Files



|       |           | Item number |            |
|-------|-----------|-------------|------------|
| Shape | Size (mm) | Grit D64    | Grit D151  |
|       | 4x1,3     | DLN-1-D64   | DLN-1-D151 |
|       | Ø 1,6     | DLN-2-D64   | DLN-2-D151 |
|       | 4x1,8     | DLN-3-D64   | DLN-3-D151 |
|       | 4x1,6     | DLN-4-D64   | DLN-4-D151 |
|       | 3x3x3     | DLN-5-D64   | DLN-5-D151 |
|       | 1,9x1,9   | DLN-6-D64   | DLN-6-D151 |
|       | 4,1x1,5   | DLN-7-D64   | DLN-7-D151 |

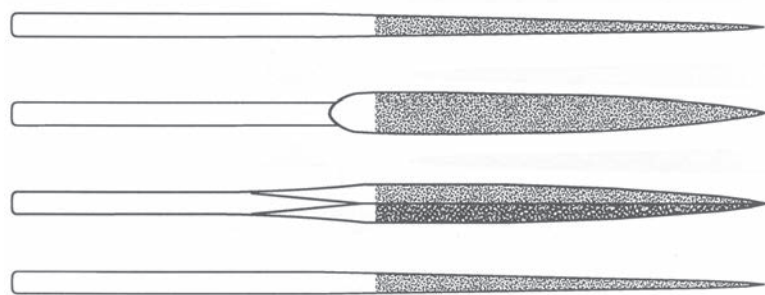
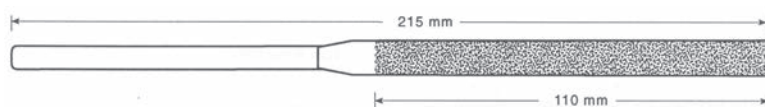
## DLN-Set

Set consisting of 7 different DLN-files, from DLN-1 to DLN-7 in respective grit sizes.



| Item number |             |              |
|-------------|-------------|--------------|
| Type        | Grit D64    | Grit D151    |
| DLN-Set     | DLN-SET-D64 | DLN-SET-D151 |

## DLG - Hand Files



Shank dimensions: 6x6 mm

| Shape | Size (mm)   | Item number |
|-------|-------------|-------------|
|       |             | Grit D151   |
|       | 10x3        | DLG-1-D151  |
|       | Ø 6,5       | DLG-2-D151  |
|       | 12,2x4      | DLG-3-D151  |
|       | 9,5x9,5x9,5 | DLG-4-D151  |
|       | 5,5x5,5     | DLG-5-D151  |

## DLG-Set



Set consisting of 5 different DLG-files, from DLG-1 to DLG-5

| Type    | Item number |
|---------|-------------|
|         | Grit D151   |
| DLG-Set | DLG/D151    |

## KSD - Diamond Plated Rulers



Total length 250 mm, width 25mm, thickness 1,0 mm. Length of plated area 135 mm. Diamond plated all around.

| Type                 | Item number  |               |
|----------------------|--------------|---------------|
|                      | Grit D64     | Grit D151     |
| Diamond plated ruler | KSD-2035-D64 | KSD-2035-D151 |

## FILE HANDLES - NEW 2013

Practical file handles with an imprinted Diprofil logo on each side. The handles are guaranteed to take file shanks from 2x2 mm up to Ø 4 mm and are really practical for someone working with hand files for long periods of time.

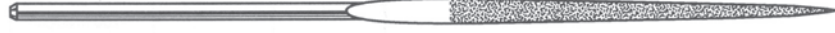
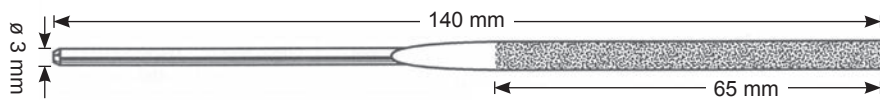
Item number: DFH-1



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**DIPROFIL®**

## DLH - Hand Files



| Standard Files |             | Item number |
|----------------|-------------|-------------|
| Shape          | Size (mm)   | Grit D151   |
|                | 5,3x1,4     | DLH-11-D151 |
|                | Ø 3         | DLH-2-D151  |
|                | 5,1x2,2     | DLH-4-D151  |
|                | 3,8x3,8x3,8 | DLH-5-D151  |
|                | 2,6x2,6     | DLH-6-D151  |
|                | 5,2x1,6     | DLH-8-D151  |
|                | 5,0x1,6     | DLH-9-D151  |
|                | 5,6x1,9     | DLH-30-D151 |



| Safe Sided Files |           | Item number |
|------------------|-----------|-------------|
| Shape            | Size (mm) | Grit D151   |
|                  | 4,8x1,1   | DLH-1-D151  |
|                  | 5,5x1,7   | DLH-3-D151  |
|                  | 4,9x2,1   | DLH-7-D151  |

## DLH-Set



Set consisting of 7 different DLH-files,  
(DHL-1 to DHL-7) as specified above.

| Type    | Item number |
|---------|-------------|
|         | Grit D151   |
| DLH-Set | DLH/D151    |

# DIPRO® DIAMOND FILES

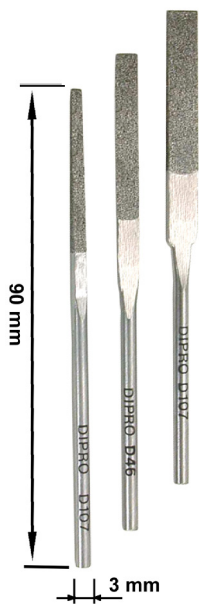
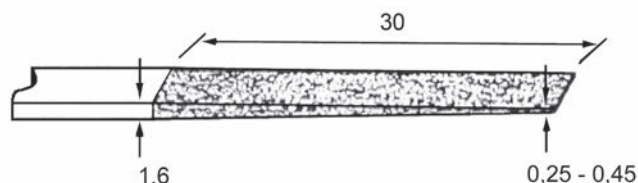
DIPRO® PRECISION DIAMOND FILES



Dipro Diamond Files are made from carefully selected diamonds, precisely bonded to obtain the best physical properties for added strength and resistance to wear. Diamond files are excellent for use on carbide, hardened steel, glass, ceramics and other similar materials.

Other shapes, dimensions and grit sizes available on request.

## DLM - Conical Machine Files



| Shape                                                                               | Size (mm) | Item number |           |           |            |
|-------------------------------------------------------------------------------------|-----------|-------------|-----------|-----------|------------|
|                                                                                     |           | Grit D30    | Grit D46  | Grit D76  | Grit D107  |
|  | 2,5x1,6   | DLM-1-D30   | DLM-1-D46 | DLM-1-D76 | DLM-1-D107 |
|  | 4X1,6     | DLM-2-D30   | DLM-2-D46 | DLM-2-D76 | DLM-2-D107 |
|  | 6X1,6     | DLM-3-D30   | DLM-3-D46 | DLM-3-D76 | DLM-3-D107 |
|  | 8X1,6     | DLM-4-D30   | DLM-4-D46 | DLM-4-D76 | DLM-4-D107 |

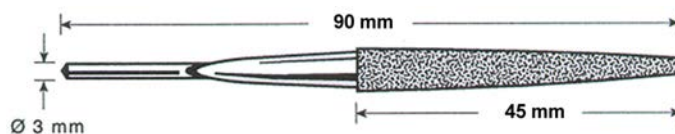
## DLM-Set

Sets consisting of 6 different DLM-files, DLM-1 through DLM-3 in the following grit sizes:



| Grit sizes | Item number |
|------------|-------------|
|            |             |
| D46 + D107 | DLM/1       |
| D30 + D46  | DLM-SET-F   |
| D76 + D107 | DLM-SET-M   |

## DBE - Machine Files



| Shape                                                                             | Size (mm)   | Item number |           |            |
|-----------------------------------------------------------------------------------|-------------|-------------|-----------|------------|
|                                                                                   |             | Grit D46    | Grit D76  | Grit D107  |
|  | 4 x 2       | DBE-1-D46   | DBE-1-D76 | DBE-1-D107 |
|  | ø3          | DBE-2-D46   | DBE-2-D76 | DBE-2-D107 |
|  | 5x2         | DBE-3-D46   | DBE-3-D76 | DBE-3-D107 |
|  | 5x2         | DBE-4-D46   | DBE-4-D76 | DBE-4-D107 |
|  | 3,5x3,5x3,5 | DBE-5-D46   | DBE-5-D76 | DBE-5-D107 |
|  | 2,5x2,5     | DBE-6-D46   | DBE-6-D76 | DBE-6-D107 |



### DBE-Set

Set consisting of the 6 different DBE-files in respective grit sizes.

#### Item number

DBE-SET-D46

DBE-SET-D76

DBE-SET-D107

## DLB - Machine Files



Approx file length 65 mm  
Shank diameter 3 mm

| Shape                                                                                 | Size (mm)   | Item number |
|---------------------------------------------------------------------------------------|-------------|-------------|
|                                                                                       |             | Grit D107   |
|   | 3,2x1,4     | DLB-1-D107  |
|  | ø3          | DLB-2-D107  |
|  | ø3          | DLB-3-D107  |
|  | 2,5x2,5x2,5 | DLB-4-D107  |
|   | 3,2x1,4     | DLB-5-D107  |
|   | 4x2         | DLB-6-D107  |



### DLB-Set

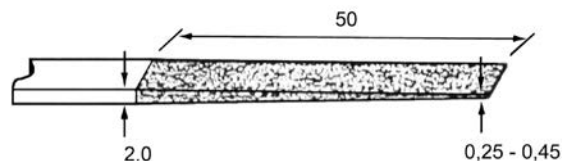
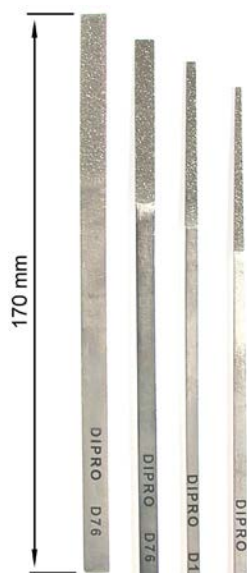
Set consisting of the above 6 different DLB files

#### Item number

DLB-SET-D107



## DLS - Conical Hand Files



|       |           | Item number |           |           |            |
|-------|-----------|-------------|-----------|-----------|------------|
| Shape | Size (mm) | Grit D30    | Grit D46  | Grit D76  | Grit D107  |
|       | 4 / 2     | DLS-1-D30   | DLS-1-D46 | DLS-1-D76 | DLS-1-D107 |
|       | 4 / 3     | DLS-2-D30   | DLS-2-D46 | DLS-2-D76 | DLS-2-D107 |
|       | 6 / 6     | DLS-3-D30   | DLS-3-D46 | DLS-3-D76 | DLS-3-D107 |
|       | 8 / 8     | DLS-4-D30   | DLS-4-D46 | DLS-4-D76 | DLS-4-D107 |

## DLS-Set



Sets consisting of 10 different DLS-handfiles.

Type

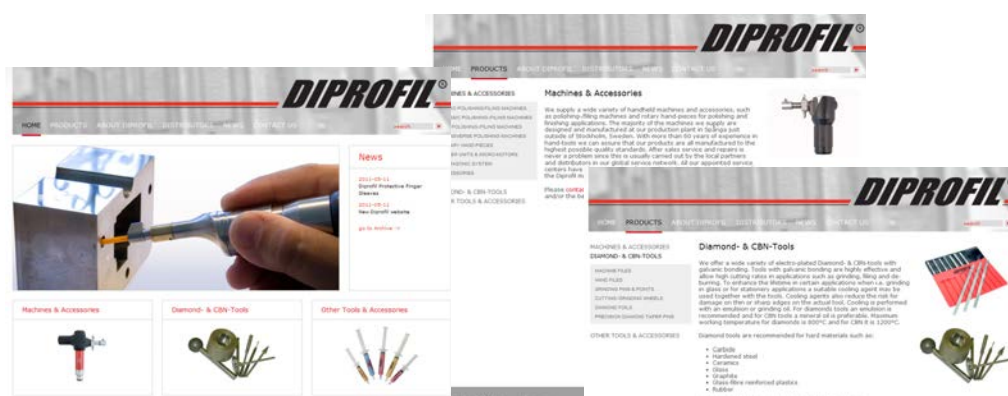
DLS 2,3,4 in D46; DLS 1,2,3,4 in D76; DLS 2,3,4 in D107

DLS 1,2,3,4 in D30; DLS 1,2,3,4 in D46; DLS 1,2 in D76

Item number

DLS/1

DLS-SET-F



Make sure to keep yourself updated about the latest news from Diprofil by visiting our website [www.diprofil.se](http://www.diprofil.se)

## DBH - Hand Files



Total file length approx 140 mm.  
Shank diameter 3 mm.

| Shape                                                                             | Size (mm)   | Item number |            |             |
|-----------------------------------------------------------------------------------|-------------|-------------|------------|-------------|
|                                                                                   |             | Grit D46    | Grit D76   | Grit D126   |
|  | 6x1,5       | DBH-1-D46   | DBH-1-D76  | DBH-1-D126  |
|  | ø3          | DBH-2-D46   | DBH-2-D76  | DBH-2-D126  |
|  | 5x2         | DBH-3-D46   | DBH-3-D76  | DBH-3-D126  |
|  | 5x2         | DBH-4-D46   | DBH-4-D76  | DBH-4-D126  |
|  | 3,5x3,5x3,5 | DBH-5-D46   | DBH-5-D76  | DBH-5-D126  |
|  | 2,5x2,5     | DBH-6-D46   | DBH-6-D76  | DBH-6-D126  |
|  | 6x2         | DBH-7-D46   | DBH-7-D76  | DBH-7-D126  |
|  | 5,4x1,5     | DBH-8-D46   | DBH-8-D76  | DBH-8-D126  |
|  | 1,7x6       | DBH-9-D46   | DBH-9-D76  | DBH-9-D126  |
|  | 6x1,5       | DBH-10-D46  | DBH-10-D76 | DBH-10-D126 |

## DBH-Set

Set consisting of the above 10 different DBH-handfiles in respective grit size.



### Item number

DBH-SET-D46  
DBH-SET-D76  
DBH-SET-D126

## FILE HANDLES - NEW 2013

Practical file handles with an imprinted Diprofil logo on each side.

The handles are guaranteed to take file shanks from 2x2 mm up to Ø 4 mm and are really practical for someone working with hand files for long periods of time.

Item number: DFH-1



## DLL- Conical Hand Files



| Shape | Size (mm) | Item number |           |           |            |
|-------|-----------|-------------|-----------|-----------|------------|
|       |           | Grit D30    | Grit D46  | Grit D76  | Grit D107  |
|       | 1,7x2     | DLL-1-D30   | DLL-1-D46 | DLL-1-D76 | DLL-1-D107 |
|       | 1,7x4     | DLL-2-D30   | DLL-2-D46 | DLL-2-D76 | DLL-2-D107 |
|       | 1,7x6     | DLL-3-D30   | DLL-3-D46 | DLL-3-D76 | DLL-3-D107 |
|       | ø3        | DLL-4-D30   |           |           |            |

Total file length approx 140 mm. Shank diameter 3 mm.



### DLL-Set

Set consisting of 10 different DLL-handfiles.

| Type                                                             | Item number |
|------------------------------------------------------------------|-------------|
| DLL 1,2,3,4 in D30; DLL 1,2,3 in D46; DLL 1,2,3 in D76           | DLL-SET     |
| DLL-4-D30; DLL 1,2,3 in D46; DLL 1,2,3 in D76; DLL 1,2,3 in D107 | DLL-SET-M   |

## DLD - Hand Files



Total file length approx 140 mm.  
Shank diameter 3mm.



| Shape | Size (mm) | Item number |
|-------|-----------|-------------|
|       |           | Grit D107   |
|       | 6,0x1,2   | DLD-1-D107  |
|       | 2,5x2,5   | DLD-2-D107  |
|       | 3x1,5     | DLD-3-D107  |
|       | 3x3x3     | DLD-4-D107  |
|       | 5x2       | DLD-5-D107  |
|       | 3,2x1,5   | DLD-6-D107  |
|       | 4x2,2     | DLD-7-D107  |
|       | Ø 2,5     | DLD-8-D107  |
|       | 5x1,5     | DLD-9-D107  |
|       | Ø 2,5     | DLD-10-D107 |



### DLD-Set

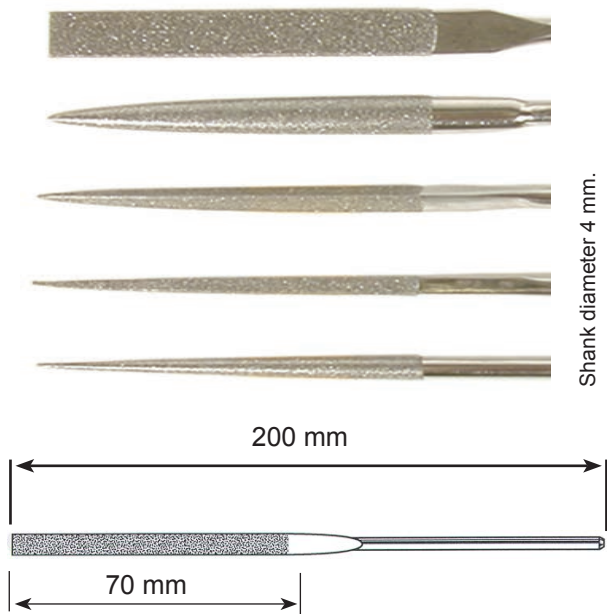
Set consisting of the above 10 different DLD-handfiles.

| Item number  |
|--------------|
| DLD-SET-D107 |

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**DIPROFIL®**

# DLQ - Hand Files



| Shape | Size (mm)    | Item number |            |
|-------|--------------|-------------|------------|
|       |              | Grit D46    | Grit D126  |
|       | 8,5x1,6      | DLQ-1-D46   | DLQ-1-D126 |
|       | ø4           | DLQ-2-D46   | DLQ-2-D126 |
|       | 7x2,5        | DLQ-3-D46   | DLQ-3-D126 |
|       | 3,5x3,5      | DLQ-4-D46   | DLQ-4-D126 |
|       | 4,5 x4,5x4,5 | DLQ-5-D46   | DLQ-5-D126 |



## DLQ-Set

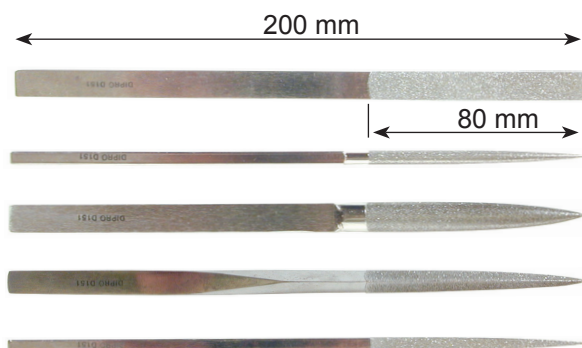
Set consisting of the above 5 different DLQ-handfiles in the respective grit size.

| Item number  |
|--------------|
| DLQ-SET-D46  |
| DLQ-SET-D126 |

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ACCORDING TO CUSTOMER  
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## DLX - Hand Files



| Shape | Size (mm)   | Item number |
|-------|-------------|-------------|
|       |             | Grit D151   |
|       | 11 x 3,5    | DLX-1-D151  |
|       | ø5          | DLX-2-D151  |
|       | 10,5x4,4    | DLX-3-D151  |
|       | 7,7x7,7x7,7 | DLX-4-D151  |
|       | 6,3x6,3     | DLX-5-D151  |



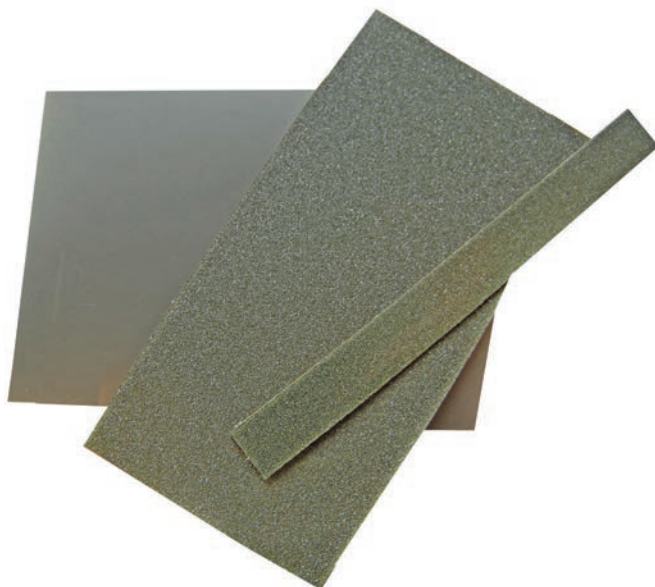
### DLX-Set

Set consisting of the above 5 different DLX-handfiles

| Item number  |
|--------------|
| DLX-SET-D151 |

## Diamond Foils

Flexible self-adhesive diamond coated metal foils with galvanic bonding. Can be easily cut to the required size and shape and is excellent for making tools adapted to special applications. The wide range of grit sizes makes it easy to achieve the required surface finish. Thickness 0,2 – 0,4mm (depending on the grit size).



### Item number / Grit size

| Size (mm) | #120/D126   | #150/D91   | #200/D76   | #300/D46   | #400/D30   | #600/D20   | #800/D15   | #1200/D10  | #1800/D7  |
|-----------|-------------|------------|------------|------------|------------|------------|------------|------------|-----------|
| 10x100    | DF-10-D126  | DF-10-D91  | DF-10-D76  | DF-10-D46  | DF-10-D30  | DF-10-D20  | DF-10-D15  | DF-10-D10  | DF-10-D7  |
| 50x100    | DF-50-D126  | DF-50-D91  | DF-50-D76  | DF-50-D46  | DF-50-D30  | DF-50-D20  | DF-50-D15  | DF-50-D10  | DF-50-D7  |
| 100x100   | DF-100-D126 | DF-100-D91 | DF-100-D76 | DF-100-D46 | DF-100-D30 | DF-100-D20 | DF-100-D15 | DF-100-D10 | DF-100-D7 |



# DIAMOND AND CBN ROTARY TOOLS

## DIPROFIL ROTARY DIAMOND AND CBN TOOLS



Diprofil Rotary Diamond and CBN Tools are made from carefully selected quality diamonds and Cubic Boron Nitride, precisely bonded to obtain the best physical properties for added strength and resistance to wear.

Electroplated Diamond pins and wheels are excellent for general grinding applications in hard materials such as carbide, hardened steel and ceramics. They are normally used without cooling agent but in stationary applications, and when grinding in thin glass cooling is often required. Maximum temperature for Diamonds is 800° C.

Electroplated cylindrical CBN pins are excellent for general grinding applications in hardened steel. They are normally used without cooling agent but in stationary applications cooling is often required. Maximum temperature for CBN is 1200° C.

### Recommended speeds

Recommend speed for dry cutting:

Diamond: 10 – 20 m/s

CBN: 15 – 30 m/s

Recommend speed for wet cutting:

Diamond: 15 – 30 m/s

CBN: 20 – 45 m/s

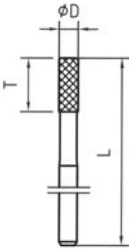
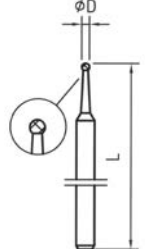
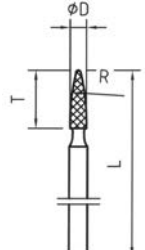
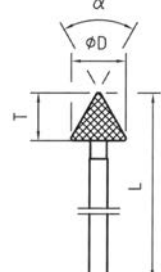
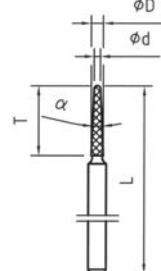
**Cooling:** Cooling normally enhances the lifetime of the tools. In addition it also generates a better surface. The risk for damage on thin or sharp edges of the grinding tool is reduced when using coolant.

Cooling is performed with an emulsion or grinding oil. For diamond tools an Emulsion is specially recommended and for CBN tools a mineral oil is preferable.

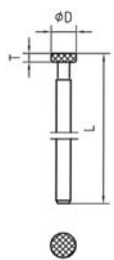
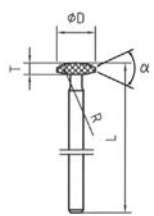
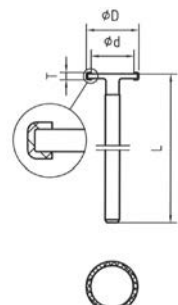
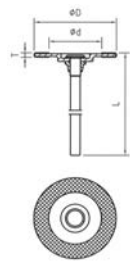
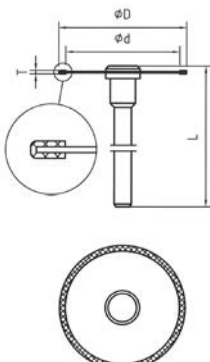
### Recommended speeds in RPM

| Tool Ø<br>(mm) | Peripheral speed (m/s) |        |        |        |        |        |        |        |
|----------------|------------------------|--------|--------|--------|--------|--------|--------|--------|
|                | 10                     | 20     | 25     | 30     | 35     | 40     | 45     | 50     |
| 2              | 95541                  | 191083 | 238854 | 286624 | 334395 | 382166 | 429936 | 477707 |
| 3              | 63694                  | 127389 | 159236 | 191083 | 222930 | 254777 | 286624 | 318471 |
| 4              | 47771                  | 95541  | 119427 | 143312 | 167197 | 191083 | 214968 | 238854 |
| 5              | 38217                  | 76433  | 95541  | 114650 | 133758 | 152866 | 171975 | 191083 |
| 6              | 31847                  | 63694  | 79618  | 95541  | 111465 | 127389 | 143312 | 159236 |
| 7              | 27298                  | 54595  | 68244  | 81893  | 95541  | 109190 | 122839 | 136488 |
| 8              | 23885                  | 47771  | 59713  | 71656  | 83599  | 95541  | 107484 | 119427 |
| 9              | 21231                  | 42463  | 53079  | 63694  | 74310  | 84926  | 95541  | 106157 |
| 10             | 19108                  | 38217  | 47771  | 57325  | 66879  | 76433  | 85987  | 95541  |
| 12             | 15924                  | 31847  | 39809  | 47771  | 55732  | 63694  | 71656  | 79618  |
| 14             | 13649                  | 27298  | 34122  | 40946  | 47771  | 54595  | 61419  | 68244  |
| 16             | 11943                  | 23885  | 29857  | 35828  | 41799  | 47771  | 53742  | 59713  |
| 18             | 10616                  | 21231  | 26539  | 31847  | 37155  | 42463  | 47771  | 53079  |
| 20             | 9554                   | 19108  | 23885  | 28662  | 33439  | 38217  | 42994  | 47771  |
| 22             | 8686                   | 17371  | 21714  | 26057  | 30400  | 34742  | 39085  | 43428  |
| 24             | 7962                   | 15924  | 19904  | 23885  | 27866  | 31847  | 35828  | 39809  |
| 26             | 7349                   | 14699  | 18373  | 22048  | 25723  | 29397  | 33072  | 36747  |
| 28             | 6824                   | 13649  | 17061  | 20473  | 23885  | 27298  | 30710  | 34122  |
| 30             | 6369                   | 12739  | 15924  | 19108  | 22293  | 25478  | 28662  | 31847  |
| 35             | 5460                   | 10919  | 13649  | 16379  | 19108  | 21838  | 24568  | 27298  |

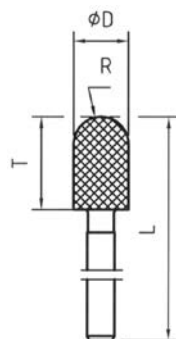
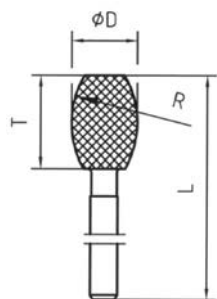
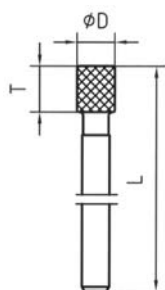
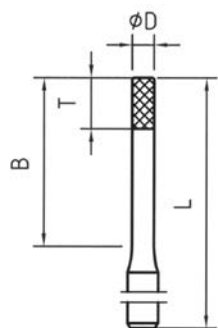
# Shank diameter: Ø 2,35 mm

|                                                                                     |            |                                                                                                           |                                                             | Item number                                                                               |
|-------------------------------------------------------------------------------------|------------|-----------------------------------------------------------------------------------------------------------|-------------------------------------------------------------|-------------------------------------------------------------------------------------------|
|                                                                                     | Shape      | Dimensions                                                                                                | Grit Size                                                   |                                                                                           |
|    | Cylinder   | D 1,4, T 7, L 46<br>D 1,9, T 5, L 46<br>D 2,5, T 7, L 46<br>D 2,6, T 3, L 46                              | D 107<br>D 151<br>D 151<br>D 151                            | DT-86-HP<br>DB-305-HP<br>DT-100-HP<br>DT-107-HP                                           |
|    | Ball       | D 0,8, L 46<br>D 1,3, L 46<br>D 1,7, L 46<br>D 1,9, L 46<br>D 2,5, L 46<br>D 3,0, L 41,3<br>D 4,1, L 42,7 | D 107<br>D 107<br>D 151<br>D 151<br>D 151<br>D 151<br>D 151 | DB-1-2/0-HP<br>DB-102-HP<br>DB-104-HP<br>DB-105-HP<br>DB-108-HP<br>DT-101-HP<br>DT-119-HP |
|   | Flame      | D 1,3, T 4, R 18, L 46<br>D 1,6, T 7,5, R 45, L 46<br>D 2,4, T 7,5, R 30, L 46<br>D 2,4, T 10, R 30, L 46 | D 151<br>D 151<br>D 151<br>D 151                            | DB-902A-HP<br>DT-95B-HP<br>DT-117-HP<br>DT-510-HP                                         |
|  | Cone       | D 5,1, a 27°, T 9,5, L 48,4<br>D 7,3, a 60°, T 6, L 45,6                                                  | D 151<br>D 151                                              | DT-93-HP<br>DT-236-HP                                                                     |
|  | Cone round | D 1,3, d 0,7, a 4°, T 9, L 46<br>D 1,6, d 0,8, a 5°, T 9, L 46<br>D 1,9, d 1,1, a 5°, T 9, L 46           | D 151<br>D 151<br>D 151                                     | DB-702-HP<br>DB-704-HP<br>DB-706-HP                                                       |

## Shank diameter: Ø 2,35 mm

|                                                                                     | Shape          | Dimensions                                                                                                               | Grit Size                        | Item number                                          |
|-------------------------------------------------------------------------------------|----------------|--------------------------------------------------------------------------------------------------------------------------|----------------------------------|------------------------------------------------------|
|    | Wheel          | D 6,3, T 0,5, L 40                                                                                                       | D 151                            | DT-129P-HP                                           |
|    | Wheel          | D 9,3, α 16°, T 1,3, L 40,2                                                                                              | D 151                            | DT-109-HP                                            |
|   | Grinding wheel | D 8,7, d 7,0, T 1,3, L 40<br>D 9,0, d 7,0, T 0,6, L 40<br>D 12,9, d 9,5, T 1,4, L 45,4                                   | D 151<br>D 151<br>D 151          | DT-56P-HP<br>DT-128P-HP<br>DT-55P-HP                 |
|  | Grinding wheel | D 20, d 12,75, T 1,0, L 48                                                                                               | D 151                            | DT-132P-HP                                           |
|  | Cutting wheel  | D 15,0, d 13,0, T 0,6, L 48<br>D 18,0, d 16,0, T 0,6, L 48<br>D 20,0, d 18,0, T 0,6, L 48<br>D 22,0, d 20,0, T 0,6, L 48 | D 151<br>D 151<br>D 151<br>D 151 | DT-124P-HP<br>DT-125P-HP<br>DT-126P-HP<br>DT-127P-HP |

# Shank diameter: Ø 3,0 mm



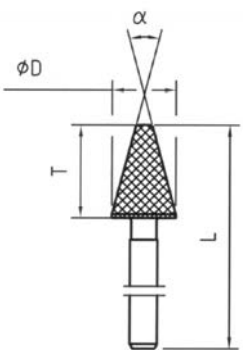
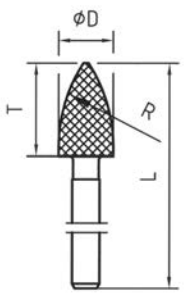
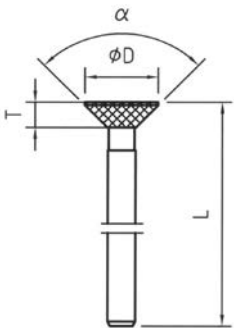
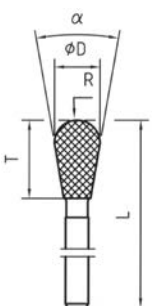
|                      |                                |           | Item number    |
|----------------------|--------------------------------|-----------|----------------|
| Shape                | Dimensions                     | Grit Size |                |
| Cylinder             | D 0,8, T 4,0, B 7, L 46        | D 107     | D-0308L-H3     |
|                      | D 1,0, T 4,0, B 8, L 46        | D 107     | D-0310L-H3     |
|                      | D 1,5, T 4,0, B 10, L 46       | D 107     | D-0315L-H3     |
|                      | D 2,0, T 5,0, B 14, L 46       | D 151     | D-0320L-H3     |
|                      | D 2,0, T 5,0, B 14, L 46       | D 64      | D-0320L-H3-D64 |
|                      | D 2,5, T 5,0, B 19, L 46       | D 151     | D-0325L-H3     |
|                      | D 2,5, T 7,0, B 19, L 46       | D 151     | D-1325-H3      |
|                      | D 3,0, T 5,0, B 19, L 46       | D 151     | D-0330L-H3     |
|                      | D 3,0, T 5,0, B 19, L 46       | D 64      | D-0330L-H3-D64 |
|                      |                                |           |                |
|                      |                                |           |                |
| Cylinder             | D 3,5, T 5,0, L 44             | D 151     | D-0335L-H3     |
|                      | D 4,0, T 5,0, L 44             | D 151     | D-0340L-H3     |
|                      | D 4,5, T 5,0, L 44             | D 151     | D-0345L-H3     |
|                      | D 5,0, T 6,0, L 45             | D 151     | D-0350L-H3     |
|                      | D 5,5, T 6,0, L 45             | D 151     | D-0352L-H3     |
|                      | D 6,0, T 6,0, L 45             | D 151     | D-0354L-H3     |
|                      | D 6,0, T 10, L 49              | D 151     | D-1354-H3      |
|                      |                                |           |                |
| Cylinder rounded     | D 7,0, d 4,5, T 10, R 10, L 49 | D 151     | D-6258-H3      |
|                      |                                |           |                |
| Cylinder rounded end | D 6,0 T 10, R 3, L 49          | D 151     | D-6054-H3      |

## Shank diameter: Ø 3,0 mm

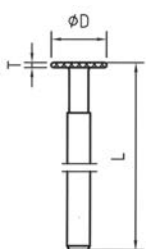
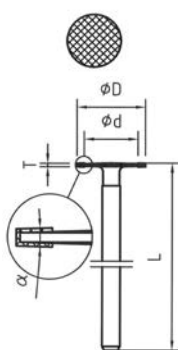
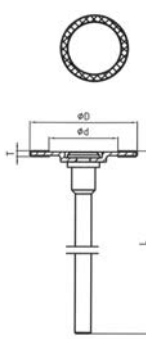
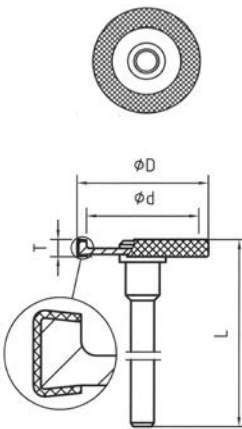
|  | Shape            | Dimensions                                                                                                                                                       | Grit Size                                                                   | Item number                                                                                                               |
|--|------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------|
|  | Ball             | D 1,7, L 46<br>D 1,7, L 46<br>D 2,1, L 46<br>D 2,5, L 46<br>D 3,0, L 46<br>D 3,0, L 46<br>D 4,1, L 46<br>D 5,0, L 46<br>D 6,0, L 46                              | D 151<br>D 64<br>D 151<br>D 151<br>D 151<br>D 64<br>D 151<br>D 151<br>D 151 | D-0116-H3<br>D-0116-H3-D64<br>D-0120-H3<br>D-0124-H3<br>D-0130-H3<br>D-0130-H3-D64<br>D-0140-H3<br>D-0150-H3<br>D-0154-H3 |
|  | Flame            | D 1,6, T 7,5, R 45, L 46<br>D 1,6, T 10, R 45, L 46<br>D 1,6, T 10, R 45, L 46<br>D 2,4, T 7,5, R 30, L 46<br>D 2,4, T 10, R 30, L 46<br>D 2,4, T 10, R 30, L 46 | D 151<br>D 151<br>D 64<br>D 151<br>D 151<br>D 64                            | D-0916-H3<br>D-0916L-H3<br>D-0916L-H3-D64<br>D-0924-H3<br>D-0924L-H3<br>D-0924L-H3-D64                                    |
|  | Cone             | D 3,1, a 30°, T 5,0, L 46<br>D 3,1, a 30°, T 5,0, L 46<br>D 8,0, a 90°, T 3,9, L 43,2<br>D 8,0, a 60°, T 6,6, L 45,9                                             | D 151<br>D 64<br>D 151<br>D 151                                             | D-5830-H3<br>D-5830-H3-D64<br>D-5562-H3<br>D-5662-H3                                                                      |
|  | Cone rounded end | D 1,3, d 0,7, a 4°, T 9, L 46<br>D 1,6, d 0,8, a 5°, T 9, L 46<br>D 1,9, d 1,1, a 5°, T 9, L 46<br>D 1,9, d 1,1, a 5°, T 9, L 46                                 | D 151<br>D 151<br>D 151<br>D 64                                             | D-0712-H3<br>D-0716-H3<br>D-0720-H3<br>D-0720-H3-D64                                                                      |



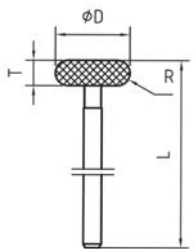
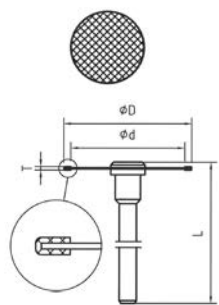
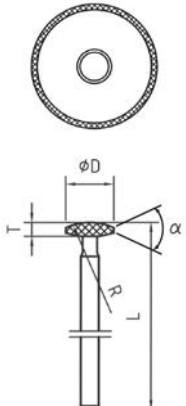
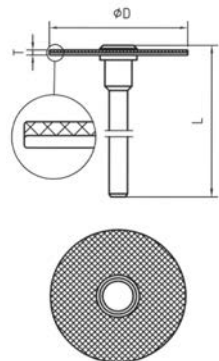
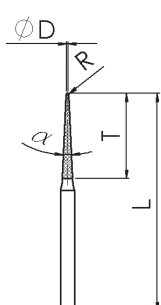
# Shank diameter: Ø 3,0 mm

|                                                                                     | Shape                            | Dimensions                                                                                                                                                                                                    | Grit Size                                         | Item number                                                                       |
|-------------------------------------------------------------------------------------|----------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|-----------------------------------------------------------------------------------|
|    | Cone<br>flat end                 | D 1,6, d 0,9, a 4°, T 10, L 46<br>D 2,1, d 1,4, a 4°, T 10, L 46<br>D 2,1, d 1,4, a 4°, T 10, L 46<br>D 2,6, d 1,75, a 4°, T 3, L 46<br>D 7,0, d 2,0, a 30°, T 10, L 49<br>D 8,0, d 1,4, a 45°, T 8,5, L 47,5 | D 151<br>D 151<br>D 64<br>D 151<br>D 151<br>D 151 | D-0516L-H3<br>D-0521L-H3<br>D-0521L-H3-D64<br>D-0526-H3<br>D-5858-H3<br>D-5756-H3 |
|   | Cone<br>rounded                  | D 6,0, T 10, R 17, L 49                                                                                                                                                                                       | D 151                                             | D-0954-H3                                                                         |
|  | Cone<br>inverted                 | D 2,4, d 1,5, a 20°, T 3, L 46<br>D 2,4, d 1,5, a 20°, T 3, L 46<br>D 6,5, d 3,5, a 15°, T 10, L 49<br>D 8,0, d 3,0, a 90°, T 2,15, L 42                                                                      | D 151<br>D 64<br>D 151<br>D 151                   | D-0224-H3<br>D-0224-H3-D64<br>D-5456-H3<br>D-5062-H3                              |
|  | Cone<br>inverted,<br>rounded end | D 6,0, d 3,5, a 20°, T 10,<br>R 3, L 49                                                                                                                                                                       | D 151                                             | D-6154-H3                                                                         |

## Shank diameter: Ø 3,0 mm

|                                                                                     | Shape          | Dimensions                  | Grit Size | Item number |
|-------------------------------------------------------------------------------------|----------------|-----------------------------|-----------|-------------|
|                                                                                     |                |                             |           |             |
|    | Wheel          | D 7,3, T 0,8, L 40          | D 151     | D-1525-H3   |
|    | Wheel          | D 9,0, d 7, T 0,6, L 40     | D 151     | D-1018-H3   |
|   | Wheel          | D 20, d 12,75, T 1,0, L 48  | D 151     | D-1539-H3   |
|  | Grinding wheel | D 17,2, d 14,6, T 2,4, L 48 | D 151     | D-1127-H3   |

## Shank diameter: Ø 3,0 mm

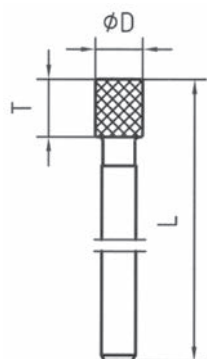
|                                                                                     |                |                                                                                                                          |                                  | Item number |
|-------------------------------------------------------------------------------------|----------------|--------------------------------------------------------------------------------------------------------------------------|----------------------------------|-------------|
|                                                                                     | Shape          | Dimensions                                                                                                               | Grit Size                        |             |
|    | Grinding wheel | D 5,8, T 2,3, R 1, L 41<br>D 9,8, T 3,4, R 1,5, L 42,2                                                                   | D 151<br>D 151                   | D-1422-H3   |
|                                                                                     |                |                                                                                                                          |                                  | D-1430-H3   |
|    | Cutting wheel  | D 15,0, d 13,0, T 0,6, L 48<br>D 18,0, d 16,0, T 0,6, L 48<br>D 22,0, d 20,0, T 0,6, L 48<br>D 36,0, d 34,0, T 1,0, L 48 | D 151<br>D 151<br>D 151<br>D 151 | D-1021-H3   |
|                                                                                     |                |                                                                                                                          |                                  | D-1024-H3   |
|                                                                                     |                |                                                                                                                          |                                  | D-1031-H3   |
|                                                                                     |                |                                                                                                                          |                                  | D-1042-H3   |
|   | Grinding wheel | D 4,1, a 60°, T 1,5, L 40,2<br>D 9,3, a 7,5°, T 1,3, L 41                                                                | D 151<br>D 151                   | D-1916-H3   |
|                                                                                     |                |                                                                                                                          |                                  | D-1629-H3   |
|  | Grinding wheel | D 22,0, d 7,0, T 0,35, L 48                                                                                              | D 151                            | D-1231-H3   |
|                                                                                     |                |                                                                                                                          |                                  |             |
|  | Cone           | D 0,6, R 0,3, a 5°, T 18, L46                                                                                            | D151                             | S-067       |

## Diamond grinding pin sets - Shank diameter Ø 3,0 mm

| Description                                                                                                                                                                                                                                                                                  | Grit Size     | Item number |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|-------------|
|                                                                                                                                                                                                                                                                                              |               |             |
| <p>Set consisting of 1 each of the following Diamond points and pins in Grit size FEPA D 151.</p> <p>D-0116-H3<br/>D-0130-H3<br/>D-0320L-H3<br/>D-0330L-H3<br/>D-0720-H3<br/>D-0521L-H3<br/>D-5830-H3<br/>D-0916L-H3<br/>D-0924L-H3<br/>D-0224-H3</p>                                        | D 151         | SET-10A-3   |
| <p>Set consisting of 1 each of the following Diamond points and pins in Grit size FEPA D 64.</p> <p>D-0116-H3-D64<br/>D-0130-H3-D64<br/>D-0320L-H3-D64<br/>D-0330L-H3-D64<br/>D-0720-H3-D64<br/>D-0521L-H3-D64<br/>D-5830-H3-D64<br/>D-0916L-H3-D64<br/>D-0924L-H3-D64<br/>D-0224-H3-D64</p> | D 64          | SET-10B-3   |
| <p>Set consisting of 1 each of the following Diamond points and pins in Grit size FEPA D 107 and D 151.</p> <p>D-0308L-H3 (D 107)<br/>D-0310L-H3 (D 107)<br/>D-0315L-H3 (D 107)<br/>D-0320L-H3<br/>D-0325L-H3<br/>D-0330L-H3<br/>D-0116-H3<br/>D-0120-H3<br/>D-0124-H3<br/>D-0130-H3</p>     | D 107 / D 151 | SET-20A-3   |

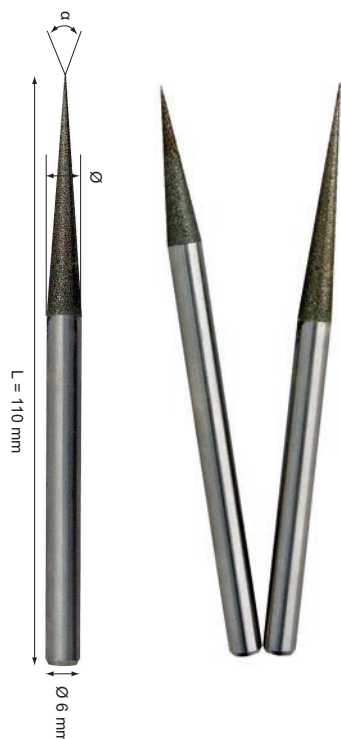


## Shank diameter: Ø 6,0 mm



| Shape    | Dimensions       | Grit Size | Item number |
|----------|------------------|-----------|-------------|
|          |                  |           |             |
| Cylinder | D 6, T 8, L 60   | D 151     | D-0354L-H6  |
|          | D 7, T 8, L 60   | D 151     | D-0358L-H6  |
|          | D 8, T 8, L 60   | D 151     | D-0362L-H6  |
|          | D 10, T 10, L 60 | D 151     | D-0370L-H6  |
|          | D 12, T 10, L 60 | D 151     | D-0374L-H6  |
|          | D 15, T 10, L 60 | D 151     | D-0380L-H6  |
|          |                  |           |             |

## Precision Diamond Taper Pins



Ideal for grinding and polishing of carbide drawing dies for the wire and tube industries. All tools have Ø 6 mm shank.

| Angle = $\alpha$ | Diameter = Ø | Grit Size | Item number  |
|------------------|--------------|-----------|--------------|
|                  |              |           |              |
| 8°               | 6 mm         | D 76      | DTP-86-D76   |
| 8°               | 6 mm         | D 91      | DTP-86-D91   |
| 8°               | 10 mm        | D 76      | DTP-810-D76  |
| 8°               | 10 mm        | D 91      | DTP-810-D91  |
| 12°              | 6 mm         | D 76      | DTP-126-D76  |
| 12°              | 6 mm         | D 91      | DTP-126-D91  |
| 12°              | 10 mm        | D 76      | DTP-1210-D76 |
| 12°              | 10 mm        | D 91      | DTP-1210-D91 |

All types are also available as blanks for polishing and final finishing with Diamond Compound.

| Angle = $\alpha$ | Diameter = Ø | Grit Size | Item number |
|------------------|--------------|-----------|-------------|
|                  |              |           |             |
| 8°               | 6 mm         | n/a       | DTP-86      |
| 8°               | 10 mm        | n/a       | DTP-810     |
| 12°              | 6 mm         | n/a       | DTP-126     |
| 12°              | 10 mm        | n/a       | DTP-1210    |

## Diamond Cutting Discs



Other dimensions and grit sizes available on request

| Dimensions (Ø x Width x Bore Ø) | Grit Size | Item number |
|---------------------------------|-----------|-------------|
|                                 |           |             |
| 20 x 0,4 x 2,5                  | D107      | ASEA-20/040 |
| 20 x 0,6 x 2,5                  | D151      | ASEA-20/060 |
| 20 x 0,8 x 2,5                  | D151      | ASEA-20/080 |
| 20 x 1,0 x 2,5                  | D151      | ASEA-20/100 |
| 22 x 0,6 x 2,5                  | D151      | ASEA-22/060 |
| 25 x 0,8 x 2,5                  | D151      | ASEA-25/080 |
| 30 x 0,8 x 6                    | D151      | ASEA-30/080 |
| 36 x 1,0 x 2,5                  | D151      | ASEA-36/100 |

## Mandrels for Diamond Cutting Discs



Hardened stainless mandrel shanks

| Type                                       | Item number |
|--------------------------------------------|-------------|
|                                            |             |
| Shank Ø 2,35 mm, Flange Ø 5 mm, Screw M2,5 | MLD/P       |
| Shank Ø 3,0 mm, Flange Ø 6 mm, Screw M2,5  | MLE/P       |

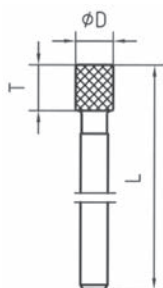
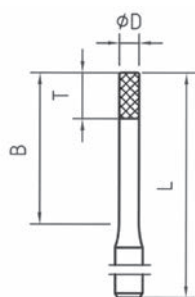


# ORIGINAL DIPROFIL PRECISION CBN TOOLS

Diprofil CBN Rotary Tools are made from carefully selected CBN (Cubic Boron Nitride), precisely bonded to obtain the best physical properties for added strength and resistance to wear. CBN tools are excellent for use on Tool Steels, Stainless Steels and Cast Iron. Other shapes, dimensions and grit sizes available on request.

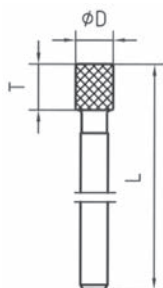


## Shank diameter: Ø 3,0 mm



|  | Shape    | Dimensions                                                                                                                                                         | Grit Size                                          | Item number                                                                      |
|--|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------|----------------------------------------------------------------------------------|
|  | Cylinder | D 0,8, T 4,0, B 7, L 46<br>D 1,0, T 4,0, B 8, L 46<br>D 1,5, T 4,0, B 10, L 46<br>D 2,0, T 5,0, B 14, L 46<br>D 2,5, T 5,0, B 19, L 46<br>D 3,0, T 5,0, B 19, L 46 | B 107<br>B 107<br>B 107<br>B 151<br>B 151<br>B 151 | B-0308L-H3<br>B-0310L-H3<br>B-0315L-H3<br>B-0320L-H3<br>B-0325L-H3<br>B-0330L-H3 |
|  | Cylinder | D 3,5, T 5,0, L 44<br>D 4,0, T 5,0, L 44<br>D 4,5, T 5,0, L 44<br>D 5,0, T 6,0, L 45<br>D 5,5, T 6,0, L 45<br>D 6,0, T 6,0, L 45                                   | B 151<br>B 151<br>B 151<br>B 151<br>B 151<br>B 151 | B-0335L-H3<br>B-0340L-H3<br>B-0345L-H3<br>B-0350L-H3<br>B-0352L-H3<br>B-0354L-H3 |

## Shank diameter: Ø 6,0 mm



|  | Shape    | Dimensions                                                                                                     | Grit Size                                          | Item number                                                                      |
|--|----------|----------------------------------------------------------------------------------------------------------------|----------------------------------------------------|----------------------------------------------------------------------------------|
|  | Cylinder | D 6, T 8, L 60<br>D 7, T 8, L 60<br>D 8, T 8, L 60<br>D 10, T 10, L 60<br>D 12, T 10, L 60<br>D 15, T 10, L 60 | B 151<br>B 151<br>B 151<br>B 151<br>B 151<br>B 151 | B-0354L-H6<br>B-0358L-H6<br>B-0362L-H6<br>B-0370L-H6<br>B-0374L-H6<br>B-0380L-H6 |

# DIAMOND COMPOUND



Universal Diamond Compound for rapid stock removal and superfine surface finish. Recommended for various types of precision superfinishing applications. Comes in handy applicator syringes containing 5, 10 or 20 grams.

## Type OWS - Oil/Water soluble

| Micron size | Concentration | Colour code | Item number |              |              |
|-------------|---------------|-------------|-------------|--------------|--------------|
|             |               |             | 5 grams     | 10 grams     | 20 grams     |
| 1           | Low           | Blue        |             | OWS-1-LC/10  | OWS-1-LC/20  |
| 1           | Medium        | Blue        | OWS-1-MC/5  | OWS-1-MC/10  | OWS-1-MC/20  |
| 1           | Heavy         | Blue        | OWS-1-HC/5  | OWS-1-HC/10  | OWS-1-HC/20  |
| 3           | Low           | Green       |             | OWS-3-LC/10  | OWS-3-LC/20  |
| 3           | Medium        | Green       | OWS-3-MC/5  | OWS-3-MC/10  | OWS-3-MC/20  |
| 3           | Heavy         | Green       | OWS-3-HC/5  | OWS-3-HC/10  | OWS-3-HC/20  |
| 6           | Low           | Yellow      |             | OWS-6-LC/10  | OWS-6-LC/20  |
| 6           | Medium        | Yellow      | OWS-6-MC/5  | OWS-6-MC/10  | OWS-6-MC/20  |
| 6           | Heavy         | Yellow      | OWS-6-HC/5  | OWS-6-HC/10  | OWS-6-HC/20  |
| 9           | Low           | Red         |             | OWS-9-LC/10  | OWS-9-LC/20  |
| 9           | Medium        | Red         | OWS-9-MC/5  | OWS-9-MC/10  | OWS-9-MC/20  |
| 9           | Heavy         | Red         | OWS-9-HC/5  | OWS-9-HC/10  | OWS-9-HC/20  |
| 15          | Low           | Brown       |             | OWS-15-LC/10 | OWS-15-LC/20 |
| 15          | Medium        | Brown       | OWS-15-MC/5 | OWS-15-MC/10 | OWS-15-MC/20 |
| 15          | Heavy         | Brown       | OWS-15-HC/5 | OWS-15-HC/10 | OWS-15-HC/20 |
| 30          | Low           | Mahogany    |             | OWS-30-LC/10 | OWS-30-LC/20 |
| 30          | Medium        | Mahogany    | OWS-30-MC/5 | OWS-30-MC/10 | OWS-30-MC/20 |
| 30          | Heavy         | Mahogany    | OWS-30-HC/5 | OWS-30-HC/10 | OWS-30-HC/20 |
| 45          | Low           | Purple      |             | OWS-45-LC/10 | OWS-45-LC/20 |
| 45          | Medium        | Purple      | OWS-45-MC/5 | OWS-45-MC/10 | OWS-45-MC/20 |
| 45          | Heavy         | Purple      | OWS-45-HC/5 | OWS-45-HC/10 | OWS-45-HC/20 |

## Type plus - *NEW 2013*

Diprofil Diamond Compound type PLUS is an enhancement of our standard type diamond compound especially developed for applications where extra heat stability and heat resistance is required.

As lubrication fluid for the type PLUS diamond compound we recommend using the Diprofil stoning oil type STO (page 58).

- Soluble in both oil and water
- Faster stock removal with better surface finish
- Better heat stability/resistance
- Creamier
- Softer
- Environmentally friendly
- Safe to use

| Micron size | Colour code | Net weight | Item number    |
|-------------|-------------|------------|----------------|
| 1           | Blue        | 10 g       | OWS-1-10-PLUS  |
| 3           | Green       | 10 g       | OWS-3-10-PLUS  |
| 6           | Yellow      | 10 g       | OWS-6-10-PLUS  |
| 8           | Red         | 10 g       | OWS-8-10-PLUS  |
| 14          | Brown       | 10 g       | OWS-14-10-PLUS |
| 25          | Mahogany    | 10 g       | OWS-25-10-PLUS |
| 45          | Purple      | 10 g       | OWS-45-10-PLUS |
| 60          | Orange      | 10 g       | OWS-60-10-PLUS |
| 90          | White       | 10 g       | OWS-90-10-PLUS |

## Lubricating fluids

| Solubility | Description          | Item number |
|------------|----------------------|-------------|
|            |                      |             |
| Oil        | 450 ml Trigger spray | LFO-0,45    |
| Oil        | 2,5 l bottle         | LFO-2,5     |

# POLISHING, LAPPING AND HONING TOOLS



Diprofil offer a wide range of Honing and Lapping Tools for all kinds of polishing and super finishing applications. All Lapping Tools are excellent as carriers for the Diprofil Diamond Compound.

## Polishing Tools on plastic shoes

Excellent for delicate polishing applications together with Polishing-/Filing machines and the Toggle rod type TR-3140.

|       |                |          | Item number |
|-------|----------------|----------|-------------|
| Type  | Dimension (mm) | Quantity |             |
| Brass | 15x13x1,5      | 1 pc     | MS-15x13    |
| Brass | 33x13x1,5      | 1 pc     | MS-33x13    |
| Fibre | 15x13x1,5      | 1 pc     | VF-15x13    |
| Fibre | 33x13x1,5      | 1 pc     | VF-33x13    |
| Felt  | 15x13x2        | 1 pc     | FF-15x13    |
| Felt  | 33x13x2        | 1 pc     | FF-33x13    |

## Di-PRO™ Polishing-kit

The low weight of the tools makes them especially suitable for use with the low-vibrating Di-Pro Polishing-/Filing machines. Using the tools included in this kit ensures that potentially harmful vibrations are kept at a minimum level. Also reduces the need for adding and removing counterweight inserts as all the included tools are within the same weight span.



Kit includes the following items:

- 1 Toggle rod TR-3140
- 2 pcs of MS-15x13
- 1 pc of MS-33x13
- 2 pcs of FF-15x13
- 1 pc of FF-33x13
- 2 pcs of VF-15x13
- 1 pc of VF-33x13
- 1 pc of PS-129
- 1 pc of PS-309

For more information about TR-3140, PS-129 and PS-309 see page 63.

| Item number |
|-------------|
| FX-PK       |

## Wood Bobs Shank Ø 3,0 mm

| (shank Ø 3,0x30 mm)                                                                 | Dimension Ø x T (mm) | Item number |           |
|-------------------------------------------------------------------------------------|----------------------|-------------|-----------|
|                                                                                     |                      | Hard Wood   | Soft Wood |
|    | Ø 20,0 x 30,0        | WB-2030/H   | WB-2030/S |
|    | Ø 15,0 x 25,0        | WB-1525/H   | WB-1525/S |
|    | Ø 10,0 x 20,0        | WB-1020/H   | WB-1020/S |
|    | Ø 6,0 x 15,0         | WB-615/H    | WB-615/S  |
|    | Ø 10,0               | WB-10/H     | WB-10/S   |
|  | Ø 10,0 x 30,0        | WB-1030/H   | WB-1030/S |

## Felt Bobs Shank Ø 3,0 mm

|                                                                                     | Dimension Ø x T (mm)                    | Item number                       |
|-------------------------------------------------------------------------------------|-----------------------------------------|-----------------------------------|
|                                                                                     |                                         |                                   |
|  | Ø 6,0x10,0<br>Ø 8,0x10,0<br>Ø 10,0x10,0 | FB-610-3<br>FB-810-3<br>FB-1010-3 |
|  | Ø 10,0x18,0                             | FB-1018-3                         |
|  | Ø 15,0/10,0x15,0                        | FB-1515-3                         |
|  | Ø 6,0x10,0<br>Ø 8,0x12,0                | FB-610R-3<br>FB-812R-3            |

## Felt Bobs Shank Ø 3,0 mm



| Dimension Ø x T (mm)                   | Item number                            |
|----------------------------------------|----------------------------------------|
| Ø 6,0x10,0<br>Ø 8,0x12,0               | FB-610P-3<br>FB-812P-3                 |
| Ø 6,0x10,0<br>Ø 8,0x12,0               | FB-610RC-3<br>FB-812RC-3               |
| Ø 6,0x10,0<br>Ø 8,0x12,0<br>Ø 7,0x15,0 | FB-610PC-3<br>FB-812PC-3<br>FB-715PC-3 |

### Felt Bob set - Shank Ø 3,0 mm

Assortment containing 1 each of the above 14 pcs of felt bobs

#### Item number

FB-SET-3

## Felt Bobs Shank Ø 6,0 mm



| Dimension Ø x T (mm)                                                                                                 | Item number                                                                                          |
|----------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|
| Ø 10,0x12,0<br>Ø 12,0x12,0<br>Ø 15,0x20,0<br>Ø 15,0x30,0<br>Ø 20,0x20,0<br>Ø 20,0x30,0<br>Ø 25,0x30,0<br>Ø 30,0x35,0 | FB-1012-6<br>FB-1212-6<br>FB-1520-6<br>FB-1530-6<br>FB-2020-6<br>FB-2030-6<br>FB-2530-6<br>FB-3035-6 |
| Ø 20,0x30,0                                                                                                          | FB-2030C-6                                                                                           |
| Ø 15,0x20,0                                                                                                          | FB-1520RC-6                                                                                          |
| Ø 30,0x20,0                                                                                                          | FB-3020R-6                                                                                           |
| Ø 20,0x70,0                                                                                                          | FB-2070-6                                                                                            |

### Felt Bob set - Shank Ø 6,0 mm

Assortment containing 1 each of the above 12 pcs of felt bobs

#### Item number

FB-SET-6

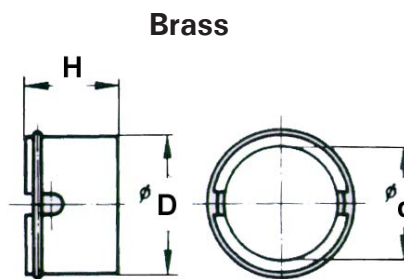
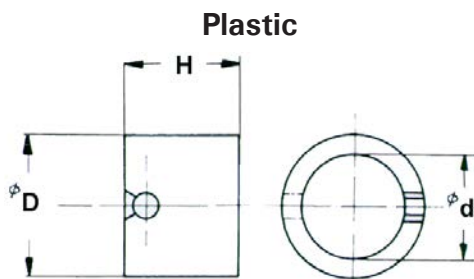


# Lapping Rings

Rotating tools for use together with Diamond Compound in various lapping and polishing applications.

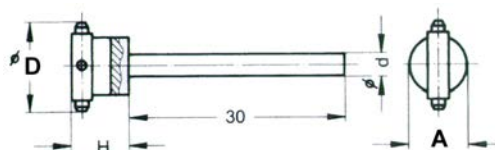


|          |      |          |          |             |          | Item number |
|----------|------|----------|----------|-------------|----------|-------------|
| Material | Type | Ø D (mm) | Ø d (mm) | Height (mm) | Quantity |             |
| Plastic  | 8    | 9        | 6        | 6           | 10 pcs   | LRP-8       |
| Plastic  | 12   | 13       | 10       | 8           | 20 pcs   | LRP-12      |
| Plastic  | 20   | 21       | 17       | 14          | 10 pcs   | LRP-20      |
| Brass    | 8    | 8        | 6        | 6           | 10 pcs   | LRB-8       |
| Brass    | 12   | 12       | 10       | 8           | 20 pcs   | LRB-12      |
| Brass    | 20   | 20       | 17       | 14          | 10 pcs   | LRB-20      |



## Mandrels

Mandrels for use together with Lapping rings. Snaps on and keeps rings flat against the work surface.



|               |          |                |        |        | Item number |
|---------------|----------|----------------|--------|--------|-------------|
| For use with: | Ø D (mm) | Shank Ø d (mm) | H (mm) | A (mm) |             |
| Type 8 rings  | 8        | 3,0            | 6      | 5      | M-8/3       |
| Type 12 rings | 12       | 3,0            | 7,5    | 8      | M-12/3      |
| Type 20 rings | 20       | 3,0            | 7,5    | 8      | M-20/3      |
| Type 20 rings | 20       | 6,0            | 11     | 9      | M-20/6      |

## Wood Lapping Ribs



(total length 150 mm)

| Dimension (mm) | Item number |             |
|----------------|-------------|-------------|
|                | Hard wood   | Soft wood   |
| 3,0 x 3,0      | WLR-3030/H  | WLR-3030/S  |
| 4,5 x 4,5      | WLR-4545/H  | WLR-4545/S  |
| 6,5 x 6,5      | WLR-6565/H  | WLR-6565/S  |
| 3,0 x 7,0      | WLR-3070/H  | WLR-3070/S  |
| 8,0 x 12,5     | WLR-80125/H | WLR-80125/S |
| 8,0 x 19,0     | WLR-80190/H | WLR-80190/S |
| Ø 3,0          | WLR-30/H    | WLR-30/S    |
| Ø 4,5          | WLR-45/H    | WLR-45/S    |
| Ø 6,5          | WLR-65/H    | WLR-65/S    |

| Description                                              | Item number |
|----------------------------------------------------------|-------------|
| Assortment of 1 each of the above Hard Wood Ribs (9 pcs) | WLR-H       |
| Assortment of 1 each of the above Soft Wood Ribs (9 pcs) | WLR-S       |

## Felt Polishing Ribs



(total length 150 mm)

| Dimension (mm) | Item number |            |
|----------------|-------------|------------|
|                | Hard felt   | Soft felt  |
| 6,0 x 6,0      | FPR-6060/H  | FPR-6060/S |
| 10,0 x 10,0    | FPR-1010/H  | FPR-1010/S |
| 12,0 x 12,0    | FPR-1212/H  | FPR-1212/S |

| Description                                                    | Item number |
|----------------------------------------------------------------|-------------|
| Assortment of 3 each of the above Felt Polishing Ribs (18 pcs) | FPR-SET     |

# Felt Polishing Sticks



(shank Ø 3,2 mm)

| Dimension (mm)     | Item number |            |
|--------------------|-------------|------------|
|                    | Hard felt   | Soft felt  |
| 6,0 x 6,0 x 37,0   | FPS-6060/H  | FPS-6060/S |
| 10,0 x 10,0 x 45,0 | FPS-1010/H  | FPS-1010/S |
| 12,0 x 12,0 x 45,0 | FPS-1212/H  | FPS-1212/S |

| Description                                                     | Item number |
|-----------------------------------------------------------------|-------------|
| Assortment of 1 each of the above Felt Polishing Sticks (6 pcs) | FPS-SET     |

# Felt pads

Self-adhesive felt pads for final finishing applications together with the Felt pad holder type FPH-385 and diamond compound. Can be used by hand or together with Polishing-/Filing machines.



| Dimension (mm) | Quantity | Item number |
|----------------|----------|-------------|
|                |          | FP-2010     |
| 20x10          | 50 pcs   |             |

# Felt pad holder

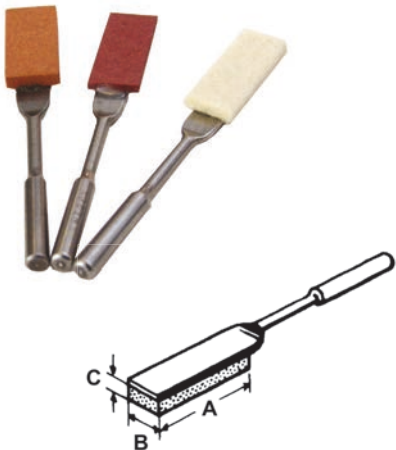
Holder for self-adhesive Felt pads. 180° swivel shank in Ø 3,0mm. Total length of the shank is 85mm.



| Item number |
|-------------|
| FPH-385     |

# Lapping tools

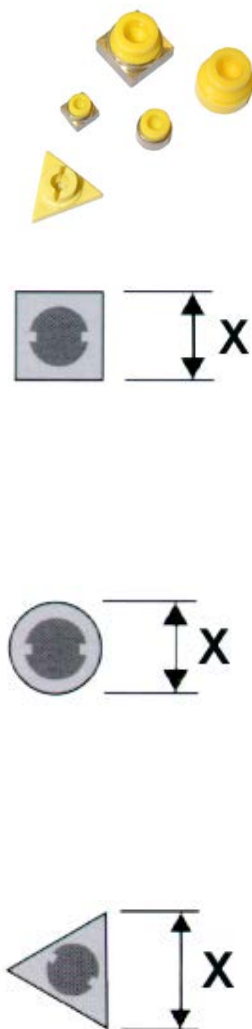
Rectangular lapping tools on shank diameter 3,0 mm



| Type       | Dimensions (AxBxC) | Item number |
|------------|--------------------|-------------|
| Cast Iron  | 18 x 7 x 1 mm      | LLB-1A      |
| Copper     | 18 x 7 x 1 mm      | LLB-2A      |
| Fibre      | 18 x 7 x 1,5 mm    | LLB-4A      |
| Balsa Wood | 18 x 7 x 1,5 mm    | LLB-5A      |
| Felt       | 18 x 7 x 3 mm      | LLB-7A      |

# Lapping Bits

Lapping tools for use together with Diamond Compound and the Diprofil Polishing/Filing machines.



|            |          |             |          | Item number |
|------------|----------|-------------|----------|-------------|
| Shape      | Material | Size X (mm) | Quantity |             |
| Square     | Plastic  | 4           | 50       | LBP-4S      |
| Square     | Plastic  | 6           | 50       | LBP-6S      |
| Square     | Plastic  | 8           | 50       | LBP-8S      |
| Square     | Brass    | 4           | 25       | LBB-4S      |
| Square     | Brass    | 6           | 25       | LBB-6S      |
| Square     | Brass    | 8           | 25       | LBB-8S      |
| Round      | Plastic  | 4           | 50       | LBP-4R      |
| Round      | Plastic  | 6           | 50       | LBP-6R      |
| Round      | Plastic  | 8           | 50       | LBP-8R      |
| Round      | Brass    | 4           | 25       | LBB-4R      |
| Round      | Brass    | 6           | 25       | LBB-6R      |
| Round      | Brass    | 8           | 25       | LBB-8R      |
| Triangular | Plastic  | 7           | 50       | LBP-4T      |
| Triangular | Plastic  | 10          | 50       | LBP-6T      |
| Triangular | Plastic  | 14          | 50       | LBP-8T      |
| Triangular | Brass    | 7           | 25       | LBB-4T      |
| Triangular | Brass    | 10          | 25       | LBB-6T      |
| Triangular | Brass    | 14          | 25       | LBB-8T      |

## Ball-rods

For use together with Lapping bits.

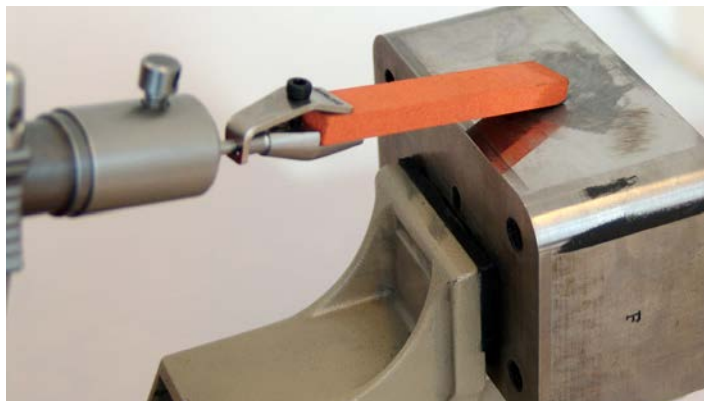
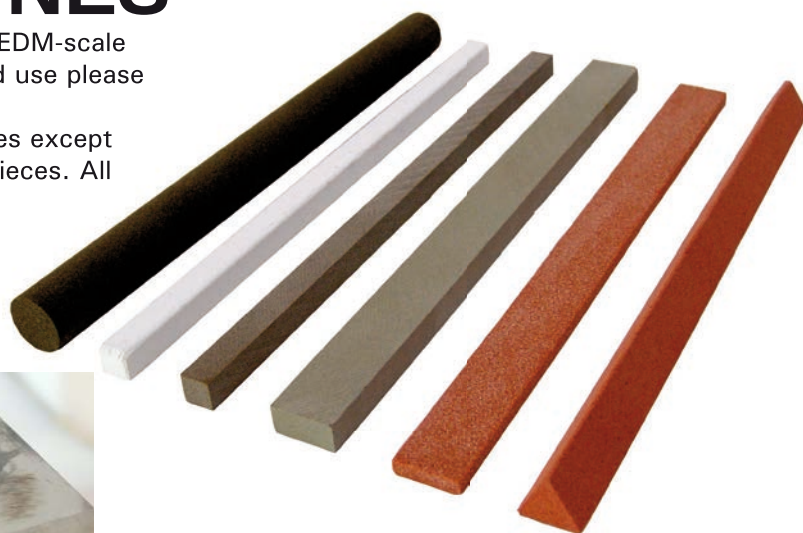


|             |                  |             | Item number |
|-------------|------------------|-------------|-------------|
| Description | For use with:    | Length (mm) |             |
| Straight    | Size 4 & 7 bits  | 140         | BRM-4S      |
| Straight    | Size 6 & 10 bits | 140         | BRM-6S      |
| Straight    | Size 8 & 14 bits | 140         | BRM-8S      |
| Angle 120°  | Size 4 & 7 bits  | 140         | BRM-4A      |
| Angle 120°  | Size 6 & 10 bits | 140         | BRM-6A      |
| Angle 120°  | Size 8 & 14 bits | 140         | BRM-8A      |

# POLISHING STONES

Polishing Stones for finishing applications such as EDM-scale removal. For more information about recommended use please see the respective series as stated below.

All Polishing Stones comes in packages of 12 pieces except the ones marked with\* that comes in boxes of 6 pieces. All grit sizes according to US Standard Mesh.



NOTE: Other dimensions and Grit sizes than standard available on request.

## SSC

SSC: Medium-soft Silicon Carbide for general mould and die polishing. Breaks down evenly and retains shape. Will not load. Very fast cutting. Recommended for heat-treated surfaces. Also good for milled and turned surfaces.



| Size (mm) | Grit size | Item number |
|-----------|-----------|-------------|
| 6x6x100   | 220       | SSC-089     |
| "         | 320       | SSC-090     |
| "         | 400       | SSC-091     |
| "         | 600       | SSC-092     |
| 13x3x100  | 220       | SSC-093     |
| "         | 320       | SSC-094     |
| "         | 400       | SSC-095     |
| "         | 600       | SSC-096     |
| 13x6x100  | 220       | SSC-097     |
| "         | 320       | SSC-098     |
| "         | 400       | SSC-099     |
| "         | 600       | SSC-100     |
| 13x13x100 | 220       | SSC-101*    |
| "         | 320       | SSC-102*    |
| "         | 400       | SSC-103*    |
| "         | 600       | SSC-104*    |

## FAO

FAO: Soft Aluminium Oxide. A very accurately graded aluminium oxide stone. Soft bonded with rapid breakdown for final finish work.



| Size (mm) | Grit size | Item number |
|-----------|-----------|-------------|
| 6x3x100   | 800       | FAO-130     |
| 6x6x100   | 800       | FAO-131     |
| 13x3x100  | 800       | FAO-132     |
| 13x6x100  | 800       | FAO-133     |
| 13x13x100 | 800       | FAO-134*    |
| 6x3x150   | 900       | FAO-135     |
| 6x6x150   | 900       | FAO-136     |
| 13x3x150  | 900       | FAO-137     |
| 13x6x150  | 900       | FAO-138     |

## SCM

SCM: Semi-hard Aluminium Oxide. Excellent for all mold and die surface finishing.  
Fast cutting. Breaks down slower than the SSC. Good for fine EDM surfaces.



| Size (mm) | Grit size | Item number |
|-----------|-----------|-------------|
| 4x4x100   | 220       | SCM-141     |
| "         | 320       | SCM-142     |
| "         | 400       | SCM-143     |
| "         | 600       | SCM-144     |
| 6x6x150   | 220       | SCM-158     |
| "         | 320       | SCM-159     |
| "         | 400       | SCM-160     |
| "         | 600       | SCM-161     |
| 10x10x150 | 220       | SCM-163     |
| "         | 320       | SCM-164     |
| "         | 400       | SCM-165     |
| "         | 600       | SCM-166     |
| 13x3x150  | 220       | SCM-173     |
| "         | 320       | SCM-174     |
| "         | 400       | SCM-175     |
| "         | 600       | SCM-176     |
| 13x6x150  | 220       | SCM-178     |
| "         | 320       | SCM-179     |
| "         | 400       | SCM-180     |
| "         | 600       | SCM-181     |
| Ø 10x150  | 220       | SCM-193     |
| "         | 320       | SCM-194     |
| "         | 400       | SCM-195     |
| "         | 600       | SCM-196     |
| Ø 13x150  | 220       | SCM-198*    |
| "         | 320       | SCM-199*    |
| "         | 400       | SCM-200*    |
| "         | 600       | SCM-201*    |

## EDM

EDM: Hard Aluminium Oxide. A hard structured stone, especially developed for the removal of the hard "scale" left by the Electrical Discharge Machining process.



| Size (mm)    | Grit size | Item number |
|--------------|-----------|-------------|
| 4x4x100      | 120       | EDM-001     |
| "            | 180       | EDM-002     |
| "            | 320       | EDM-003     |
| 6x3x150      | 120       | EDM-007     |
| "            | 180       | EDM-008     |
| "            | 320       | EDM-009     |
| 6x6x150      | 120       | EDM-010     |
| "            | 180       | EDM-011     |
| "            | 320       | EDM-012     |
| 13x3x150     | 120       | EDM-013     |
| "            | 180       | EDM-014     |
| "            | 320       | EDM-015     |
| 13x6x150     | 120       | EDM-016     |
| "            | 180       | EDM-017     |
| "            | 320       | EDM-018     |
| 10x10x150    | 120       | EDM-019     |
| "            | 180       | EDM-020     |
| "            | 320       | EDM-021     |
| 6x6x6x150    | 120       | EDM-100     |
| "            | 180       | EDM-101     |
| "            | 320       | EDM-102     |
| 10x10x10x150 | 120       | EDM-107     |
| "            | 180       | EDM-108     |
| "            | 320       | EDM-109     |
| 13x13x13x150 | 120       | EDM-114     |
| "            | 180       | EDM-115     |
| "            | 320       | EDM-116     |



# HCM

HCM: Resilient resin bonded stone. Extremely snap resistant. Does not scratch or load. The resin helps produce a silky finish.



| Size (mm) | Grit size | Item number |
|-----------|-----------|-------------|
| 4x4x100   | 180       | HCM-031     |
| "         | 220       | HCM-032     |
| "         | 320       | HCM-033     |
| "         | 600       | HCM-034     |
| Ø 4x100   | 320       | HCM-035     |
| 6x3x150   | 90        | HCM-042     |
| "         | 120       | HCM-043     |
| "         | 180       | HCM-044     |
| "         | 220       | HCM-045     |
| "         | 320       | HCM-046     |
| "         | 600       | HCM-047     |
| 6x6x150   | 90        | HCM-048     |
| "         | 120       | HCM-049     |
| "         | 180       | HCM-050     |
| "         | 220       | HCM-051     |
| "         | 320       | HCM-052     |
| "         | 600       | HCM-053     |
| 13x3x150  | 90        | HCM-054     |
| "         | 120       | HCM-055     |
| "         | 180       | HCM-056     |
| "         | 220       | HCM-057     |
| "         | 320       | HCM-058     |
| "         | 600       | HCM-059     |
| 13x6x150  | 90        | HCM-060     |
| "         | 120       | HCM-061     |
| "         | 180       | HCM-062     |
| "         | 220       | HCM-063     |
| "         | 320       | HCM-064     |
| "         | 600       | HCM-065     |

# MOL

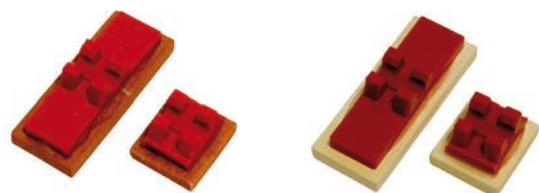
MOL: Semi-hard Aluminium Oxide. Widely used for removal of EDM surfaces and for finishing heat-treated moulds and dies. Especially good for slots and ribs. Stones are oil-filled to prevent loading. MOL Breaks down slowly and retains shape.



| Size (mm) | Grit size | Item number |
|-----------|-----------|-------------|
| 6x6x150   | 220       | MOL-248     |
| "         | 320       | MOL-249     |
| "         | 400       | MOL-250     |
| "         | 600       | MOL-251     |
| 10x10x150 | 220       | MOL-253     |
| "         | 320       | MOL-254     |
| "         | 400       | MOL-255     |
| "         | 600       | MOL-256     |
| 13x3x150  | 220       | MOL-263     |
| "         | 320       | MOL-264     |
| "         | 400       | MOL-265     |
| "         | 600       | MOL-266     |
| 13x6x150  | 220       | MOL-268     |
| "         | 320       | MOL-269     |
| "         | 400       | MOL-270     |
| "         | 600       | MOL-271     |
| Ø 10x150  | 220       | MOL-283     |
| "         | 320       | MOL-284     |
| "         | 400       | MOL-285     |
| "         | 600       | MOL-286     |
| Ø 13x150  | 220       | MOL-288*    |
| "         | 320       | MOL-289*    |
| "         | 400       | MOL-290*    |
| "         | 600       | MOL-291*    |

## Polishing Stones on plastic shoes

Excellent for delicate stoning applications together with Polishing-/Filing machines and the Toggle rod type TR-3140. For more information about the characteristics of the polishing stones type EDM and MOL please see pages 56 and 57.



| Type | Dimension (mm) | Grit size | Quantity | Item number |
|------|----------------|-----------|----------|-------------|
| EDM  | 15x13x3        | G120      | 1 pc     | EDM-15-120  |
| EDM  | 33x13x3        | G120      | 1 pc     | EDM-33-120  |
| EDM  | 15x13x3        | G180      | 1 pc     | EDM-15-180  |
| EDM  | 33x13x3        | G180      | 1 pc     | EDM-33-180  |
| EDM  | 15x13x3        | G320      | 1 pc     | EDM-15-320  |
| EDM  | 33x13x3        | G320      | 1 pc     | EDM-33-320  |
| MOL  | 15x13x3        | G400      | 1 pc     | MOL-15-400  |
| MOL  | 33x13x3        | G400      | 1 pc     | MOL-33-400  |
| MOL  | 15x13x3        | G600      | 1 pc     | MOL-15-600  |
| MOL  | 33x13x3        | G600      | 1 pc     | MOL-33-600  |

## Toggle rod

Toggle rod for plastic shoes. Can easily be bent to an angle if required.

Shank Ø 3,5 mm  
Length 140 mm



Item number

TR-3140

## Di-PRO™ Stoning-kit

The low weight of the tools makes them especially suitable for use with the low-vibrating Di-Pro Polishing-/Filing machines. Using the tools included in this kit ensures that potentially harmful vibrations are kept at a minimum level. Also reduces the need for adding and removing counterweight inserts as all the included tools are within the same weight span.

The kit includes the following items:

- 1 Toggle rod TR-3140
- 2 pcs of EDM-15-120
- 1 pc of EDM-33-120
- 2 pcs of EDM-15-180
- 1 pc of EDM-33-180
- 2 pcs of EDM-15-320
- 1 pc of EDM-33-320
- 2 pcs of MOL-15-400
- 1 pc of MOL-33-400
- 2 pcs of MOL-15-600
- 1 pcs of MOL-33-600



Item number

FX-SK

## Stoning Oil

| Description                | Item number |
|----------------------------|-------------|
| Stoning Oil 5 litre bottle | STO-5,0     |

# SUPER STONES AND GRINDERS



Ceramic stones for use together with all Diprofil filing and polishing machines, Diprosonic/Ultrasonic machines, or by hand. The Super Stones are recommended for general use when a thin tool is needed, especially on EDM surfaces.

## Super stones

Diprofil Super Stones are available in a length of 150mm. All grit sizes according to US mesh.



|           |      |             | Item number |
|-----------|------|-------------|-------------|
| Dimension | Grit | Colour      |             |
| 1 x 2     | 120  | Green       | SE 102 L    |
| 1 x 2     | 180  | Yellow      | SG 102 L    |
| 1 x 2     | 300  | Light Brown | SL102 L     |
| 1 x 2     | 400  | Orange      | SO 102 L    |
| 1 x 2     | 600  | Brown       | SP 102 L    |
| 1 x 2     | 800  | Blue        | SB 102 L    |
| 1 x 2     | 1000 | White       | SW 102 L    |
| 1 x 2     | 1200 | Red         | SR 102 L    |
| 1 x 4     | 120  | Green       | SE 104 L    |
| 1 x 4     | 180  | Yellow      | SG 104 L    |
| 1 x 4     | 300  | Light Brown | SL104 L     |
| 1 x 4     | 400  | Orange      | SO 104 L    |
| 1 x 4     | 600  | Brown       | SP 104 L    |
| 1 x 4     | 800  | Blue        | SB 104 L    |
| 1 x 4     | 1000 | White       | SW 104 L    |
| 1 x 4     | 1200 | Red         | SR 104 L    |
| 1 x 6     | 120  | Green       | SE 106 L    |
| 1 x 6     | 180  | Yellow      | SG 106 L    |
| 1 x 6     | 300  | Light Brown | SL106 L     |
| 1 x 6     | 400  | Orange      | SO 106 L    |
| 1 x 6     | 600  | Brown       | SP 106 L    |
| 1 x 6     | 800  | Blue        | SB 106 L    |
| 1 x 6     | 1000 | White       | SW 106 L    |
| 1 x 6     | 1200 | Red         | SR 106 L    |
| 1 x 10    | 120  | Green       | SE 110 L    |
| 1 x 10    | 180  | Yellow      | SG 110 L    |
| 1 x 10    | 300  | Light Brown | SL110 L     |
| 1 x 10    | 400  | Orange      | SO 110 L    |
| 1 x 10    | 600  | Brown       | SP 110 L    |
| 1 x 10    | 800  | Blue        | SB 110 L    |
| 1 x 10    | 1000 | White       | SW 110 L    |
| 1 x 10    | 1200 | Red         | SR 110 L    |

# Super grinders

For use together with rotary handpieces with 3 mm collets as well as all Diprofil filing and polishing machines. The Super Grinders are recommended for general use especially on EDM surfaces. Total length 50 mm.



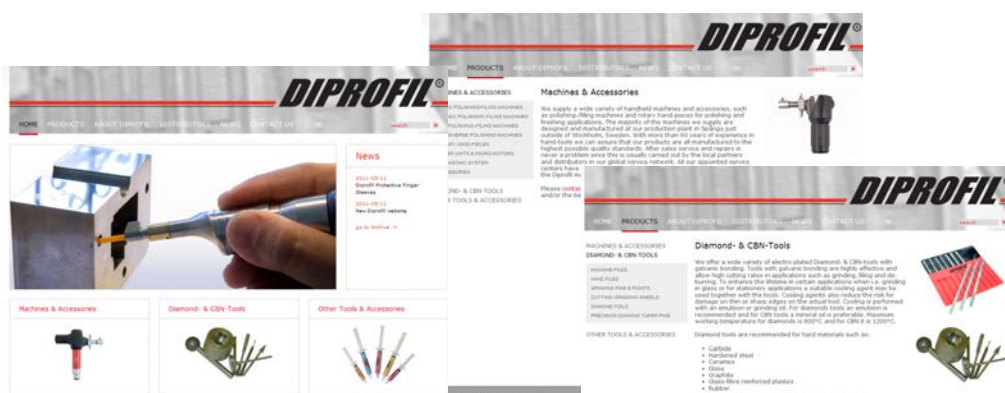
| Dimension | Grit | Colour      | Item number |
|-----------|------|-------------|-------------|
|           |      |             |             |
| Ø 3 x 50  | 120  | Green       | SED 3 A     |
| Ø 3 x 50  | 180  | Yellow      | SGD 3 A     |
| Ø 3 x 50  | 300  | Light Brown | SLD 3 A     |
| Ø 3 x 50  | 400  | Orange      | SOD 3 A     |
| Ø 3 x 50  | 600  | Brown       | SPD 3 A     |
| Ø 3 x 50  | 800  | Blue        | SBD 3 A     |
| Ø 3 x 50  | 1000 | White       | SWD 3 A     |
| Ø 3 x 50  | 1200 | Red         | SRD 3 A     |

# Diamond super stones and super grinders

For use together with all Diprofil filing and polishing machines, Diprosonic/Ultrasonic machines or by hand. The Super Stones are recommended for general use when a thin tool is needed especially on EDM surfaces.



| Dimension    | Grit | Colour | Item number |
|--------------|------|--------|-------------|
|              |      |        |             |
| 1 x 4 x 100  | 200  | Black  | SDS-142     |
| 1 x 4 x 100  | 400  | Grey   | SDS-144     |
| 1 x 4 x 100  | 600  | Green  | SDS-146     |
| 1 x 6 x 100  | 200  | Black  | SDS-162     |
| 1 x 6 x 100  | 400  | Grey   | SDS-164     |
| 1 x 6 x 100  | 600  | Green  | SDS-166     |
| 1 x 10 x 100 | 200  | Black  | SDS-112     |
| 1 x 10 x 100 | 400  | Grey   | SDS-114     |
| 1 x 10 x 100 | 600  | Green  | SDS-116     |
| Ø 3 x 50     | 200  | Black  | SDS 32 A    |
| Ø 3 x 50     | 400  | Grey   | SDS 34 A    |
| Ø 3 x 50     | 600  | Green  | SDS 36 A    |



Make sure to keep yourself updated about the latest news from Diprofil by visiting our website [www.diprofil.se](http://www.diprofil.se)

# TOOL HOLDERS



Tool holders for polishing stones, super stones, super grinders and lapping ribs.

## Polishing Stones holder



Tool holder for use with Polishing Stones or Lapping Ribs with maximum cross section area 6x6 mm or Ø 6 mm.

### Item number

BEA

## Polishing stones holder



Tool holder with pencil grip for Polishing Stones with maximum cross section area of 4x4 mm.

### Item number

BEB

## Universal tool holder



Tool holder for Super Stones, Super Grinders and Polishing Stones to be used together with the Diprofil Polishing/Filing Machines. Stainless hardened shank Ø 3,0 mm. Shank length approx. 35 mm. Maximum tool thickness 6 mm.

### Item number

FMR/VH

## Super Stone holder



Tool-holder made of hardened steel for use together with ceramic fibre stones (Super stones) and lapping-/polishing tools with a thickness of 1 mm.

Shank Ø: 3,0 mm  
Shank length: 18 mm  
Total length: 31,5 mm  
Width: 8 mm  
Weight: 4,3 g

### Item number

THFS-1

## Universal tool holder



Tool-holder made of hardened steel for use together with polishing stones and lapping-/polishing tools with a thickness of 3 mm.

Shank Ø: 3,0 mm  
Shank length: 18 mm  
Total length: 31,5 mm  
Width: 8 mm  
Weight: 3,9 g

### Item number

THPS-3

## Tool holder



Tool holder for use in the Diprofil Polishing/Filing Machines together with Polishing Stones and Lapping Ribs with maximum cross section area 13x13 mm or Ø 13 mm.  
Shank Ø 3,0 mm.

### Item number

QEA/3

## Tool holder



Same as QEA/3 but fitted with shank Ø 6,0 mm.

### Item number

QEA/6



## Tool holder

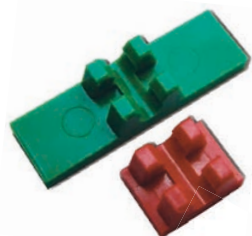


Hinged Tool holder for Polishing Stones and Lapping Ribs with maximum cross section area 11x13 mm or Ø 13 mm.  
Shank Ø 3,0 mm.

### Item number

VEA

## Plastic shoes / Tool holders



Plain plastic shoes for making your own special tools adapted to the specific application.

### Item number

| Dimension (mm) | Quantity |
|----------------|----------|
| 12x9x2         | 10 pcs   |
| 30x9x2         | 10 pcs   |

PS-129  
PS-309

## Toggle rod

Toggle rod for plastic shoes. Can easily be bent to an angle if required.



Shank  
Length

Ø 3,5 mm  
140 mm

### Item number

TR-3140

## Super Stone holders

Tool holders for use with Super Stones.



### Item number

For Super Stones, width 2 mm.  
For Super Stones, width 4 mm.  
For Super Stones, width 6 mm.  
For Super Stones, width 10 mm.

SSH-2  
SSH-4  
SSH-6  
SSH-10

## Reduction sleeves

Reduction sleeves for use of tools with Ø 2,35 mm shanks in Ø 3,0 mm collets.



### Length

14 mm  
28 mm

### Item number

RHA  
RHB

# PRECISION STEEL FILES

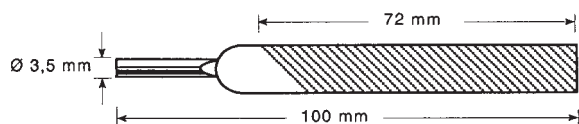
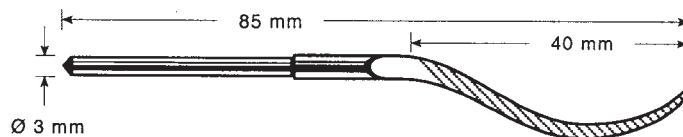
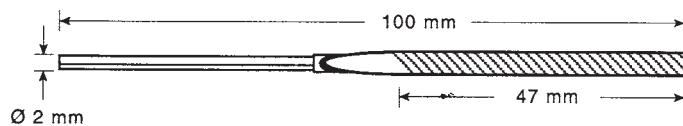
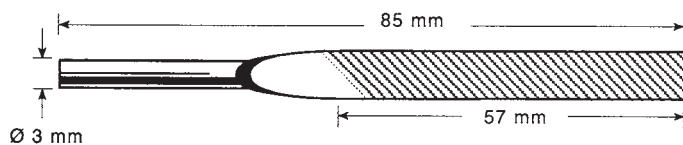
Diprofil precision steel files for use in soft and semi-hard steel as well as other materials of low to medium hardness.

Medium cut (-00) = 20 teeth/cm

Fine cut (-1) = 31 teeth/cm



## Steel files



| Shape | Size mm     | Item number    |             |
|-------|-------------|----------------|-------------|
|       |             | Medium Cut -00 | Fine Cut -1 |
|       | 5x1,5       | STL-1-00/P     | STL-1-1/P   |
|       | Ø3          | STL-2-00/P     | STL-2-1/P   |
|       | 5x2         | STL-3-00/P     | STL-3-1/P   |
|       | 5x2         | STL-4-00/P     | STL-4-1/P   |
|       | 3,5x3,5x3,5 | STL-5-00/P     | STL-5-1/P   |
|       | 2,5x2,5     | STL-6-00/P     | STL-6-1/P   |
|       | 3,3x1       | STL-21-00/P    | STL-21-1/P  |
|       | Ø2          | STL-22-00/P    | STL-22-1/P  |
|       | 3,2x1,1     | STL-23-00/P    | STL-23-1/P  |
|       | 3x1,3       | STL-24-00/P    | STL-24-1/P  |
|       | 2,2x2,2x2,2 | STL-25-00/P    | STL-25-1/P  |
|       | 1,7x1,7     | STL-26-00/P    | STL-26-1/P  |
|       | 4x2         | STL-11-00/P    | STL-11-1/P  |
|       | Ø3          | STL-12-00/P    | STL-12-1/P  |
|       | 4,7x2,5     | STL-14-00/P    | STL-14-1/P  |
|       | 3x3         | STL-16-00/P    | STL-16-1/P  |
|       | 10x2,5      | STL-101-00/P   | STL-101-1/P |

# DIAMOND & CBN GRIT SIZES COMPARISON TABLE

D = Synthetic Diamonds

B = CBN (Cubic Boron Nitride)

| FEPA standard |         | U.S. standard mesh |       | Grit size (microns) |
|---------------|---------|--------------------|-------|---------------------|
| dense         | wide    | dense              | wide  |                     |
| D 1181        |         | 16/18              |       | 1180 – 1000         |
|               | D 1182  |                    | 16/20 |                     |
| D 1001        |         | 18/20              |       | 1000 – 850          |
|               |         |                    |       |                     |
| D 851         |         | 20/25              |       | 850 – 710           |
|               | D 852   |                    | 20/30 |                     |
| D 711         |         | 25/30              |       | 710 – 600           |
|               |         |                    |       |                     |
| D 601         |         | 30/35              |       | 600 – 500           |
|               | D 602   |                    | 30/40 |                     |
| D 501         |         | 35/40              |       | 500 – 425           |
|               |         |                    |       |                     |
| D 426         |         | 40/45              |       | 425 – 355           |
|               | D 427   |                    | 40/50 |                     |
| D/B 356       |         | 45/50              |       | 355 – 300           |
|               |         |                    |       |                     |
| D/B 301       |         | 50/60              |       | 300 – 250           |
|               |         |                    |       |                     |
| D/B 251       |         | 60/70              |       | 250 – 212           |
|               | D/B 252 |                    | 60/80 |                     |
| D/B 213       |         | 70/80              |       | 212 – 180           |
|               |         |                    |       |                     |
| D/B 181       |         | 80/100             |       | 180 – 150           |
|               |         |                    |       |                     |
| D/B 151       |         | 100/120            |       | 150 – 125           |
|               |         |                    |       |                     |
| D/B 126       |         | 120/140            |       | 125 – 106           |
|               |         |                    |       |                     |
| D/B 107       |         | 140/170            |       | 106 – 90            |
|               |         |                    |       |                     |
| D/B 91        |         | 170/200            |       | 90 – 75             |
|               |         |                    |       |                     |
| D/B 76        |         | 200/230            |       | 75 – 63             |
|               |         |                    |       |                     |
| D/B 64        |         | 230/270            |       | 63 – 53             |
|               |         |                    |       |                     |
| D/B 54        |         | 270/325            |       | 53 – 45             |
|               |         |                    |       |                     |
| D/B 46        |         | 325/400            |       | 45 - 38             |

In addition to the grits included in the FEPA-standard, Diprofil also offers tools in the following grit sizes:

|      |                |
|------|----------------|
| D 30 | 36 - 22 micron |
| D 15 | 22 - 12 micron |

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