

MIRACLE 油石 (Made in Japan)

MIRACLE EDM STONES

BLK (BLACK STONE)



#120 #180 #240 #320 #400 #600 #800
#1000 #1200 #1500 #2000 #3000

GC (GC STONE)



#120 #180 #240 #320 #400 #600 #800
#1000 #1200 #1500 #2000 #3000

品名	砥粒	硬度	結合劑	尺寸	用途
	Grain	Hardness	Bond	Size	application
BLK	C	中軟 (Medium Soft)	V	3x6x100 3x13x150 3x6x150 5x13x150	一般模具 硬質材料模具等 General mold for hard material mold

細緻、鋒利的研磨端，能迅速將模具細部完整加工。中軟硬度的 Sic 砥粒，不但可用於鑽石之成型，更適用於高標準要求的模具鏡面細部的修飾。同時也適用於硬質材料模具的研磨。

This stone is made of medium soft SIC grains with sharp points designed to swiftly fit to detail forms of mold. It is best suitable to operations before diamond paste processing and best for mold which needs fine finishing, such as mirror finishing. Also suitable for polishing hard material mold.

品名	砥粒	硬度	結合劑	尺寸	用途
	Grain	Hardness	Bond	Size	application
GC	GC	中軟 (Medium Soft)	V	3x6x100 3x13x150 3x6x150 5x13x150 3x13x100	一般模具及非鐵金屬，硬質工具等 For nonferrous metals and hard material tools

綠色 SIC 砥粒加上特殊結合劑的超完美結合所製作出專門針對細部修飾，拋光的 GC STONE，除了可以安穩的處理表層細微的紋路，更可用在超硬熱處理的鋼材修飾上。

With green SIC grains mixed among special bond. This stone does not damage surface and give stable finishing. It is suitable for carbide and quenched steels.

訂購範例： $\frac{PS}{\text{型號}} - \frac{BLK}{\text{產品代號}} - \frac{36100}{\text{尺寸}} - \frac{120}{\text{粒度}}$ Order Ex. : $\frac{PS}{\text{Model No.}} - \frac{BLK}{\text{Item}} - \frac{36100}{\text{Size}} - \frac{120}{\text{Grit}}$

EDM
(EDM STONE)



#120 #180 #240 #320 #400
#600 #800 #1000 #1200

品名	砥粒	硬度	結合劑	尺寸		用途
	Grain	Hardness	Bond	Size		application
EDM	WA	中硬 (Medium Hard)	V	1x10x100 3x6x100 3x6x150	3x13x150 5x13x150 6x6x150	一般模具及放電加工後的表面研磨 Surface polish after EDM processing for general mold

可輕易去除 EDM 後表面頑固的吸附粒子，卻又不傷及模具表層。銳角部分及角落的細部研磨有著非常顯著性能的發揮

This special stone has higher hardness and less abrasion. It shows high performance for detailed polish, such as corners of acute angles.

EDM-BR
(LAP MATE EDM STONE)



#120 #180 #240 #320 #400
#600 #800 #1000 #1200

品名	砥粒	硬度	結合劑	尺寸		用途
	Grain	Hardness	Bond	Size		application
EDM-BR	WA	中硬 (Medium Hard)	V	1x10x100 3x6x100 3x6x150 3x13x150	5x13x150 6x6x150 10x13x150	一般模具及放電加工後的表面研磨 Surface lapping after EDM processing for general mold

密度高且耐磨的 WA 砥粒，在研磨過程中，可抑制最小量的粒子脫落。加上使用特殊的樹脂加工，可讓油石本身，尤其是研磨的先端常保如新。適用於細部的研磨或中度的修飾。

The Lap Mate is manufactured for keeping new blade constantly with minimum bonds and maximum density of grains to prevent from falling out. Due to our special processed resin, the form of the edge lasts long and can be used for detail finishing as well as rough and medium finishing.

單一尺寸·粒度最小訂購量 Minimum order per size & grit

1x10x100	20pcs / box
3x3x150	
3x6x100	
3x6x150	
4x4x150	

單一尺寸·粒度最小訂購量 Minimum order per size & grit

3x13x100	10pcs / box
3x13x150	
5x13x150	
6x6x150	
6x13x150	

DIE
(DIE STONE)



#120 #180 #220
#320 #400 #600

品名	砥粒	硬度	結合劑	尺寸	用途
	Grain	Hardness	Bond	Size	application
DIE	A	中軟 (Medium Soft)	V	3x6x150 5x13x150 3x13x150 6x6x150	淬鋼合金之表面研磨 Surface polishing for quenched steel

在硬度範圍 HRC47~63 的鋼材表面研磨上會有最優秀並最適合的表現。超銳利的 A 級砥粒亦可用於切割，更適合硬質材料的研磨。

A best stone for quenched steel of HRC 47 to 63. Medium soft hardness of this stone give steel an excellent finishing and the sharp cutting of A grains enables polishing for hardened materials.

SO
(SUPER ORANGE STONE)



#120 #180 #220
#320 #400 #600

品名	砥粒	硬度	結合劑	尺寸	用途
	Grain	Hardness	Bond	Size	application
SO	WA	中硬 (Medium Hard)	V	3x6x150 6x6x150 3x13x150 6x13x150 5x13x 150	搭配使用往覆式氣動研磨機，超音波研磨機效果更佳 Surface lapping after EDM processig for gneral. Use with stroke air profiler-linear

特別設計用於往覆式氣動工具及超音波研磨機，特殊橘色 WA 砥粒除了不易折斷的特性，更可維持研磨先端的鋒利，最適合用在 EDM 後硬化層附著物的去除。

Best stone for removing hardned layer after EDM processing. You can use this stone with stroke air profiler-linear machine and ultrasonic machine because this stone is very hard break. You can always keep new and sharp blade by avoiding grains to drop out with using original special bond. This original new bound makes it possible to remove hardened layer after EDM processing.

VH (Made in USA)
(GOLDEN STONE)



#150 #180 #240 #400 #600
#1200 #1500 #2500

品名	砥粒	硬度	結合劑	尺寸	用途
	Grain	Hardness	Bond	Size	application
VH	VH	中硬 (Medium Hard)	V	3x3x150 3x13x150 4x4x150 6x6x150 3x6x 150 6x13x150	放電加工後的表面處理和銑刀加工痕跡更具優異的去除性。 Delivering exceptional performance on EDM surfaces, milling and machining marks.

從選擇優質氧化鋁顆粒和專有的處理過程中，VH 油石是中等硬度，具有快速去除工件表面紋路及保持油石低磨耗不變形，並留下了如絲般柔滑質感。VH 油石並不需要漫長加工的過程也不需使用潤滑油，是款高效能的 EDM 油石。

Made from select premium aluminum oxide grain and a proprietary treatment process, the VH stone is of medium hardness with a fast breakdown offering quick material removal while contouring quickly and leaving a silky smooth finish. The VH stone does not require a lengthy pre-lubrication process and is terrific when used during hand stoning as well as with profilers.