

<b>DIANAMIC® SUPERABRASIVE PARTICLE SIZE REFERENCE CHART</b>			
<b>MESH</b>	<b>SIZE</b>	<b>TOLERANCE</b>	<b>APPLICATION</b>
20/30	.0330"	+-.0030"	Extra Heavy Stock Removal
30/40	.0230"	+-.0025"	Very Heavy Stock Removal
40/60	.0160"	+-.0016"	Heavy Stock Removal Saw Grit
60/80	.0100"	+-.0015"	Coarse Roughing
80/100	.0070"	+-.0013"	Standard Roughing
100/120	.0060"	+-.0012"	General Purpose
120/140	.0050"	+-.0010"	General Purpose
140/170	.0040"	+-.0010"	General Purpose
170/200	.0035"	+-.0010"	General Purpose
200/230	.0029"	+-.0010"	General Finishing
230/270	.0025"	+-.0009"	Finishing
270/325	.0021"	+-.0007"	Fine Finishing
325/400	.0017"	+-.0005"	Fine Finishing

<b>DIANAMIC<sup>7</sup> SUPERABRASIVE MICRON SIZE REFERENCE CHART</b>			
<b>MICRON</b>	<b>SIZE</b>	<b>TOLERANCE</b>	<b>APPLICATION</b>
60	.0024"	+-.0009"	Finishing
45	.0018"	+-.0005"	Fine Finishing
30	.0012"	+-.0003"	Fine Finishing
15	.0006"	+-.0002"	Very Fine Finishing

The DIANAMIC Superabrasive (Diamond and cBN) Particle Size Chart should be used as a reference guide when manufacturing steel blanks for coating.

1. A MALE RADIUS should finish SMALLER than the required finish size. SUBTRACT the particle size from the finished size to achieve the correct pre coat dimension.
2. A FEMALE RADIUS should finish LARGER than the required finish size. ADD the particle size to the finished size to achieve the correct pre coat dimension.

DIANAMIC highly recommends that we are contacted for technical support and recommendations when manufacturing blanks.

Telephone 248 280 1185  
[www.dianamic.com](http://www.dianamic.com)

Facsimile 248 280 2733  
[info@dianamic.com](mailto:info@dianamic.com)