



**CRATEX ABRASIVE STICK  
APPLICATION INSTRUCTIONS FOR JEWELLING**

**Cratex Stick Diameters:**

Cratex abrasive sticks are available in the following diameters.  
3/16, 1/4, 5/16, 3/8, 1/2, 5/8, 3/4, 7/8 and 1" ( all sticks are 6" long )

**Spin Diameter:**

The diameter of the stick determines the diameter of your spin, therefore select the appropriate stick diameter that you desire your spin to be.

**Cratex Grit Selection:**

Cratex abrasive sticks are available in 4 different grit textures.  
Coarse (C), Medium (M), Fine (F), and Extra Fine (XF)

**Metal Types:**

Using the application guide below chose which grit is best suited for your application.

**Stainless Steel** ( harden metals) Medium ( M) or Fine (F)

**Aluminum** ( softer metals ) Fine ( F) or Extra Fine (XF)

\*\*\*\*\* INSTRUCTIONS \*\*\*\*\*

Cratex sticks need should be cut into 1-1/2 to 2" sections. Chuck the sticks into a drill press leaving only 1" or less exposed. The longer the exposed length the increased chance of developing a wiping type action, that will result in larger spins then desired.

Never over tighten the chuck when mounting the abrasive stick into the rotating devise ( dill press or other machine ) to avoid it from eventually snapping off. The best rotating speed is between 900 and 1400 rpm.

**Lubricant:** A very light mist of 25 water to 1 oil mixture is necessary. Any oil from cooking to motor oil can be used in a spray bottle. Mist where the abrasive sticks meets the metal to reduce any heat build up.

**Spinning:** First experiment on a scrap piece of metal until the desire spin depth is achieved. When doing so determine the cycle time ( how long the rotating abrasive stick is working against the metal). If that is 5 seconds, then your cycle time is 5 seconds per spin. .

**Cratex Rubberized Abrasives,**

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**Pressure:** When developing the spin cycle time make note of the pressure applied. Use the same amount of pressure ( which should be very light ) for each spin.

**Spin Cycle Time and Pressure:** You do not need to be precise to achieve a professional looking spin but try to be consistent.

**Spin Pattern:**

Simply slid the metal work piece  $\frac{1}{2}$  the distance as the spin diameter to achieve an over lap spin appearance. Follow this procedure until your metal work piece is complete.

**Stick Dressing:** From time to time the Cratex abrasive stick may become embedded with metal particles. The stick will need to be dressed back to expose fresh abrasive. You can place a standard dressing block or a fine grit sand paper block on the work rest and bring the stick down onto the dressing material. Keep the rotating stick with very light pressure for a few seconds against the dressing material. The abrasive stick will wear away slightly and expose all fresh abrasive.

**Warnings:** Always wear eye protection; never permit anyone to view the operation without proper eye protection. Always use caution and care with any rotating abrasive product.

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