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Version 2020-00

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

PLEASE VISIT [www.diprofil.com](http://www.diprofil.com)



# DIAMANTPRODUKTER AB



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## Company Presentation

Diprofil/Diamantprodukter AB has 70 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.

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# **DI-PRO<sup>®</sup>** POLISHING/FILING MACHINES - *MARK II* Maximum Efficiency – Minimal Vibrations



The Di-PRO<sup>®</sup> machine is the flagship of the DIPROFIL family. With its low levels of potentially harmful vibrations it is the natural choice when operating the machine for long hours. It is ideal for a wide variety of applications such as filing, lapping, honing, de-burring and polishing. With its reciprocating (back and forth) movement the Di-PRO<sup>®</sup> machines are an excellent alternative and complement to rotary handpieces.

#### **Advantages with the Di-PRO<sup>®</sup> machines:**

- Very low levels of potentially harmful vibrations
- Made in Sweden
- Worldwide service network
- Adjustable stroke length 0 – 6 mm
- Well-known and trusted design
- Available for/with a wide variety of drive sources

**With the new Mark II versions the operator will also be able to take advantage of the following attributes:**

- Improved ergonomics
- No moving parts on the tool-holder
- Even lower risk of sustaining vibration related injuries\*
- The same function as with the protective finger sleeve but without the cost
- More lightweight compared to previous versions
- Facilitates and reduces the cost for service and maintenance
- Includes an extension pipe for longer tools

*\*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. The new tool-holder will improve guidance of the tool and the risk of injuries as there is no longer any need for putting your fingers on moving tools and/or machine parts.*

"The same features as the old version but without the need of buying the Protective Finger Sleeve as an accessory. A great improvement to an already good product!"

– Kristian Nielsen, Mould polisher at Polérteknik ApS, Denmark

# Flexible Shaft-Driven Machine - FXK-N

Slip-joint connection (European Standard)



<b>Drive source:</b>	The FXK-N model is driven by an electrical 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.
<b>Speed (maximum):</b>	7.000 rpm.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 rpm</b>
<b>Stroke length:</b>	0 – 6 mm. (recommended 0,5 – 3 mm). <b>NOTE! At stroke lengths exceeding 4 mm we recommend a maximum speed of 5.000 rpm.</b>
<b>Tool holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum 34 g. Recommended 1-15 g
<b>Applied feed force:</b>	2-12N (depending on inserted tool type and dimension).
<b>Machine weight:</b>	Approx. 700 g. (depending on model)
<b>Noise level:</b>	Not exceeding 75 dB(A) at 7.000 rpm.
<b>Vibration levels:</b>	See information on next page.
<b>Item No:</b>	<b>FXK-N</b>

# Flexible Shaft-Driven Machines - FXH-N & FXS-N

Ball-joint connection (US standard, Square-Hole or Key-Hole)



<b>Drive source:</b>	The FXH-N and FXS-N models are driven by an electrical 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.
<b>Speed (maximum):</b>	7.000 rpm.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 rpm</b>
<b>Stroke length:</b>	0 – 6 mm. (recommended 0,5 – 3 mm). <b>NOTE! At stroke lengths exceeding 4 mm we recommend a maximum speed of 5.000 rpm.</b>
<b>Tool holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum 34 g. Recommended 1-15 g
<b>Applied feed force:</b>	2-12N (depending on inserted tool type and dimension).
<b>Machine weight:</b>	Approx. 700 g. (depending on model)
<b>Noise level:</b>	Not exceeding 75 dB(A) at 7.000 rpm.
<b>Vibration levels:</b>	See information on next page.
<b>Item No:</b>	<b>FXH-N (Square-Hole)</b> <b>FXS-N (Key-Hole)</b>

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

# Air-Driven Machine - FXL-N



<b>Drive source:</b>	The FXL-N model is driven by compressed and oil mist lubricated air. <b>PLEASE NOTE! The built-in air-motor may be damaged, if operated with un-lubricated air.</b>
<b>Connection:</b>	The Diprofil quick-coupling HSL-M and fog lubrication unit MFB should be used for connection to your compressed air system. <b>PLEASE NOTE! Protect the air inlet from dust and dirt, when not in operation.</b>
<b>Oil consumption:</b>	Minimum 30 mm <sup>3</sup> /min. at maximum speed (about 2 drops/min.).
<b>Air pressure:</b>	<b>4 bar (57 psi).</b>
<b>Air consumption:</b>	Approx. 60 l/min at 7.000 rpm
<b>Speed (maximum):</b>	7.000 rpm.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 rpm</b>
<b>Stroke length:</b>	0 – 6 mm (recommended 0,5 – 3 mm). <b>NOTE! At stroke lengths exceeding 4 mm we recommend a maximum speed of 5.000 rpm.</b>
<b>Tool-holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum 34 g. Recommended 1-15 g
<b>Applied feed force:</b>	2-12 N (depending on inserted tool type and dimension).
<b>Machine weight:</b>	Approx. 900 g.
<b>Noise level:</b>	Not exceeding 75 dB(A) at 7.000 rpm
<b>Vibration levels:</b>	See information below.
<b>Item No:</b>	<b>FXL-N</b>

# Micro Motor-Driven Machines - FXM-N (Diprofil connector) and FXM/EJ-N (Eneska 3-1 connector)

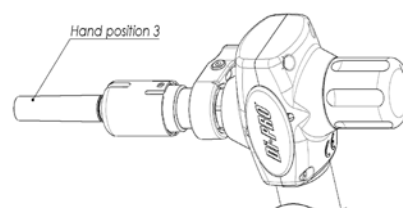
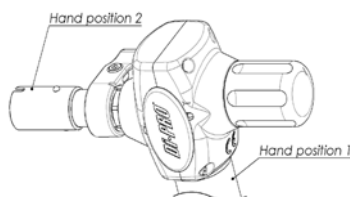


<b>Drive source:</b>	The FXM-N and FXM/EJ-N models are driven by a built-in micro-motor, which is connected to, and controlled by, the power unit DIPROFIL DPU-3 or TPU-20 or corresponding power units.
<b>Output:</b>	<b>DC 0-32V. (The needed voltage at a certain rpm is depending on the micro motor and the power unit).</b>
<b>Speed (maximum):</b>	7.000 rpm.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 rpm</b>
<b>Stroke length:</b>	0 – 6 mm (recommended 0,5 – 3 mm). <b>NOTE! At stroke lengths exceeding 4 mm we recommend a maximum speed of 5.000 rpm.</b>
<b>Tool-holder:</b>	Ø 6,4 mm (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum 34 g. Recommended 1-15 g
<b>Applied feed force:</b>	2-12 N (depending on inserted tool type and dimension).
<b>Machine weight:</b>	Approx. 860 g.
<b>Noise level:</b>	Not exceeding 75 dB(A) at 7.000 rpm.
<b>Vibration levels:</b>	See information below.
<b>Item No:</b>	<b>FXM-N (Diprofil connector)</b> <b>FXM/EJ-N (Eneska 3-1 connector)</b>

## Measured vibration emission values (m/s<sup>2</sup>):

The uncertainty value (K) is also expressed in m/s<sup>2</sup> and is intended to compensate for different batches, production variations etc.

Hand position 1:	1,55 m/s <sup>2</sup>	(K = 0,65 m/s <sup>2</sup> )
Hand position 2:	5,08 m/s <sup>2</sup>	(K = 1,00 m/s <sup>2</sup> )
Hand position 3:	3,64 m/s <sup>2</sup>	(K = 0,86 m/s <sup>2</sup> )



# **Di-PRO<sup>®</sup> MACHINE SETS - MARK II**

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

## **Di-PRO<sup>®</sup> SET LARGE**

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

Specifications	Item no.
Di-PRO machine type FXM-N 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 handpiece.

Specifications	Item No.
Di-PRO machine type FXM-N 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 6.4 mm tool-holder and the small power unit type DPU-3.

Specifications	Item No.
Di-PRO machine type FXM-N with 6.4 mm tool-holder and power unit type DPU-3.	FXM-SET-S



# CLASSIC DIPROFIL MACHINES - MARK II

## ORIGINAL RECIPROCATING POLISHING/FILING MACHINE



The Classic polishing/filing machines, which have been the preferred choice for tool and mould-makers for more than 60 years, are now available in Mark II editions incorporating a new tool-holder to improve ergonomics and flexibility.

The Classic machine, with its rigid and ergonomic design, facilitates any filing, lapping, honing or polishing application. With their reciprocating (back and forth) movement, the Classic machines are an excellent alternative and complement to rotary handpieces.

### Advantages with the Classic machines:

- Made in Sweden since 1950
- Worldwide service network
- Very simple handling/operation
- Adjustable stroke length 0 – 6 mm
- Well-known and trusted design
- Available for/with a wide variety of drive sources

### With the new Mark II versions the operator will also be able to take advantage of the following attributes:

- Improved ergonomics
- No moving parts on the tool-holder
- Lower risk of sustaining vibration related injuries\*
- The same function as with the protective finger sleeve but without the cost
- More lightweight compared to previous versions
- Facilitates and reduces the cost for service and maintenance
- Includes an extension pipe for longer tools

*\*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. The new tool-holder will improve guidance of the tool and the risk of injuries as there is no longer any need for putting your fingers on moving tools and/or machine parts.*

"The same features as the old version but without the need of buying the Protective Finger Sleeve as an accessory. A great improvement to an already good product!"

– Kristian Nielsen, Mould polisher at  
Polérteknik ApS, Denmark



## Air-Driven Machine - FPL/R



<b>Drive source:</b>	This model is driven by compressed and oil mist lubricated air. <b>PLEASE NOTE! The built-in air-motor may be damaged, if operated with un-lubricated air.</b>
<b>Connection:</b>	The Diprofil quick-coupling HSL-M and fog lubrication unit MFB should be used for connection to your compressed air system. <b>PLEASE NOTE! Protect the air inlet from dust and dirt, when not in operation.</b>
<b>Oil consumption:</b>	Minimum 30mm <sup>3</sup> /min at maximum speed (about 2 drops/min.)
<b>Air pressure:</b>	4bar (58psi).
<b>Air consumption:</b>	Approx. 65 l/min at 8.000 strokes/min.
<b>Speed (maximum):</b>	8.000 strokes/min.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 strokes/min</b>
<b>Stroke length:</b>	0 – 6mm.
<b>Stroke length (recommended):</b>	<b>0,5 - 3 mm.</b>
<b>Tool-holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum: 26 g. Recommended: 1-15 g.
<b>Applied feed force:</b>	2-12 N (Depending on inserted tool type and dimension.)
<b>Machine weight:</b>	Approx. 740g.
<b>Noise level:</b>	Not exceeding 70 dB(A) at 7.000 strokes/min. According to ISO 15744.
<b>Vibration levels:</b>	See information on next page.
<b>Item No:</b>	<b>FPL/R</b>

## Flexible Shaft-Driven Machine - FPK/R

Slip-joint connection (European Standard)



<b>Drive source:</b>	This model is driven by an electrical 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.
<b>Speed (maximum):</b>	8.000 strokes/min.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 strokes/min</b>
<b>Stroke length:</b>	0 – 6 mm.
<b>Stroke length (recommended):</b>	<b>0,5 - 3 mm.</b>
<b>Tool holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum: 26 g. Recommended: 1-15 g.
<b>Applied feed force:</b>	2-12 N (Depending on inserted tool type and dimension.)
<b>Machine weight:</b>	Approx. 575 g. (depending on model.)
<b>Noise level:</b>	Not exceeding 70 dB(A) at 7.000 strokes/min. According to ISO 15744.
<b>Vibration levels:</b>	See information on next page.
<b>Item No:</b>	<b>FPK/R</b>

## Flexible Shaft-Driven Machines - FPH/R & FPS/R

Ball-joint connection (US standard, Square-Hole or Key-Hole)



<b>Drive source:</b>	These models are driven by an electrical 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.
<b>Speed (maximum):</b>	8.000 strokes/min.
<b>Speed (recommended):</b>	<b>5.000 – 6.000 strokes/min</b>
<b>Stroke length:</b>	0 – 6 mm.
<b>Stroke length (recommended):</b>	<b>0,5 - 3 mm.</b>
<b>Tool holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum: 26 g. Recommended: 1-15 g.
<b>Applied feed force:</b>	2-12 N (Depending on inserted tool type and dimension.)
<b>Machine weight:</b>	Approx. 575 g. (depending on model.)
<b>Noise level:</b>	Not exceeding 70 dB(A) at 7.000 strokes/min. According to ISO 15744.
<b>Vibration levels:</b>	See information on next page.
<b>Item No:</b>	<b>FPH/R (Square-Hole)</b> <b>FPS/R (Key-Hole)</b>

## Micro Motor-Driven Machines - FPM/R & FPM/ERJ



<b>Drive source:</b>	These models are driven by a built-in micro-motor, which is connected to, and controlled by, the DIPROFIL DPU-3, TPU-20 or corresponding power unit.
<b>Output:</b>	<b>DC 0-32V</b>
<b>Speed (maximum):</b>	Approx. 7.000 strokes/min. (depending on the power unit)
<b>Speed (recommended):</b>	<b>5.000 – 6.500 strokes/min</b>
<b>Stroke length:</b>	0 – 6 mm.
<b>Stroke length (recommended):</b>	<b>0,5 - 3 mm.</b>
<b>Tool-holder:</b>	Ø 6,4 mm. (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum: 26 g. Recommended: 1-15 g.
<b>Applied feed force:</b>	2-12 N (Depending on inserted tool type and dimension.)
<b>Machine weight:</b>	715 g.
<b>Noise level:</b>	Not exceeding 70 dB(A) at 7.000 strokes/min. According to ISO 15744.
<b>Vibration levels:</b>	See information below.
<b>Item No:</b>	<b>FPM/R (Diprofil Connector)</b> <b>FPM/ERJ (Eneska 3-1 Connector)</b>

## Machines with Micro Motor Connection - FPT/ER & FPT/NR

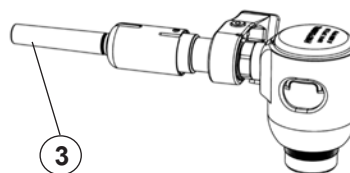
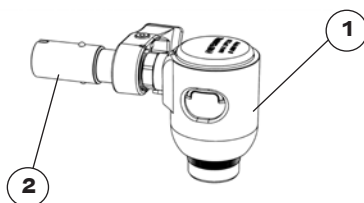


<b>Drive source:</b>	These models should be driven by motors with low maximum rpm and high torque only. Exceptions can be made for motors with high torque at low rpm.
<b>Speed (maximum):</b>	Approx. 7.000-8.000 strokes/min (depending on the power unit)
<b>Speed (recommended):</b>	<b>5.000 – 6.500 strokes/min</b>
<b>Stroke length:</b>	0 – 6 mm.
<b>Stroke length (recommended):</b>	<b>0,5 - 3 mm.</b>
<b>Tool-holder:</b>	Ø 6,4 mm (suitable for tool shanks Ø 2 - Ø 6,4 mm)
<b>Weight of inserted tool:</b>	Maximum: 26 g. Recommended: 1-15 g.
<b>Applied feed force:</b>	2-12 N (Depending on inserted tool type and dimension.)
<b>Machine weight:</b>	Approx. 560 g (without micro motor).
<b>Noise level:</b>	Not exceeding 70 dB(A) at 7.000 strokes/min. According to ISO 15744.
<b>Vibration levels:</b>	See information below.
<b>Item no:</b>	<b>FPT/ER (for Eneska 4-1 and NSK ESPERT)</b> <b>FPT/NR (for Eneska 3-1, 3-2 and NSK EMax-Evolution)</b>

## Measured vibration emission values (m/s<sup>2</sup>):

The uncertainty value (K) is also expressed in m/s<sup>2</sup> and is intended to compensate for different batches, production variations etc.

Hand position 1:	6,02 m/s <sup>2</sup>	(K = 1,09 m/s <sup>2</sup> )
Hand position 2:	5,79 m/s <sup>2</sup>	(K = 1,15 m/s <sup>2</sup> )
Hand position 3:	13,37 m/s <sup>2</sup>	(K = 1,82 m/s <sup>2</sup> )



# CLASSIC MACHINE SETS - MARK II

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

## CLASSIC SET LARGE

The largest and most versatile set consisting of the Classic machine with 6.4 mm tool-holder, Twin power unit type TPU-20 and the brushless rotary handpiece type C-HPM-BL2.

Specifications	Item no.
Classic machine type FPM/R with 6.4 mm tool-holder, TPU-20-220V power unit and brushless rotary handpiece type C-HPM-BL2.	FPM-SET-L



## CLASSIC SET MEDIUM

Same as the Classic set large but without the rotary handpiece.

Specifications	Item No.
Classic machine type FPM/R with 6.4 mm tool-holder and power unit type TPU-20-220V.	FPM-SET-M



## CLASSIC SET SMALL

The most basic set including the Classic machine with 6.4 mm tool-holder and the small power unit type DPU-3.

Specifications	Item No.
Classic machine type FPM/R with 6.4 mm tool-holder and power unit type DPU-3.	FPM-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 developed the Diprofil protective finger sleeves. The finger sleeves 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). **Please note that these finger sleeves do not fit the Mark II versions.** 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) FSH-3 (extension rod)
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## Protective Finger Sleeve for the Ø 6,4 mm tool holder

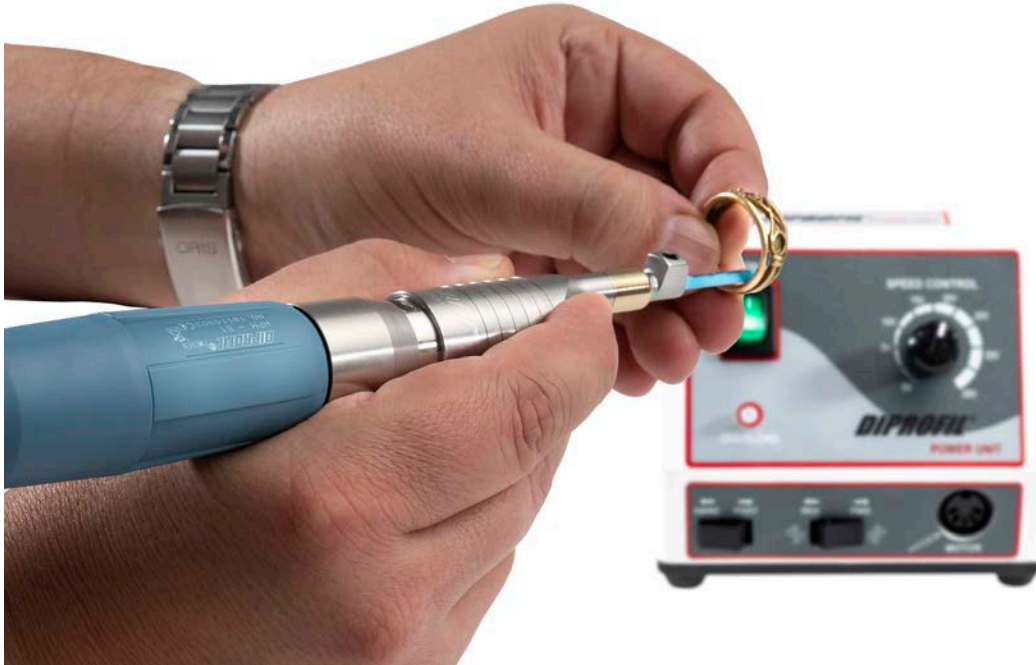
Outer Ø: 26 mm  
Length (without extension rod): 48 mm  
Length (including extension rod): 105 mm  
Maximum tool shank Ø: 6,4 mm  
Weight (without extension rod): 49 g  
Weight (including extension rod): 66 g



Item number:	PFS-6,4 (incl extension rod FSH-3) FSH-3 (extension rod)
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# 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 57).

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>,  
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



## 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

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/S5
1.0 mm	FMR/S10
1.5 mm	FMR/S15

## 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

## 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 Micro 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

## E-fit Standard Connection



### Technical data

Tool-holder: Max. Ø 3,6 mm  
 Stroke length: 1.0 mm  
 Speed: Max. 12.000 rpm (Recommended speed: 5.000 - 11.000 rpm)  
 Weight: Approx. 120 g  
 Dimensions: Ø 24 mm  
 Noise level: < 70 dB(A) at 9.000 rpm  
 Vibration levels: At stroke 0,5 mm: <2,5 m/s<sup>2</sup>  
 At stroke 1,0 mm: 1,5 - 3 m/s<sup>2</sup>  
 At 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
1.0 mm	FMR/I10

# DIPROMINI MACHINE SETS

**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



## POWER UNIT – ROTARY HANDPIECE SET

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

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





# ROTARY HANDPIECES

FOR EFFICIENT POLISHING AND FINISHING OPERATIONS



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

All rotary handpieces come with the necessary tools and accessories.

## Rotary Handpiece Type HPX



### Technical data

**Drive source:**

This hand-piece should be connected to a flexible-shaft of either European standard (Slip-joint) or US standard (Ball-joint, key-hole)

**Collet:**

Ø 3.0 and Ø 6.0 mm (Ø 2.35 mm (3/32") available as an accessory

**Speed:**

Max. 18.000 rpm

**Weight:**

300 g

**Dimensions:**

Ø 31 x 171 mm

**Noise level:**

< 70 dB(A) at 18.000 rpm

**Vibration levels:**

< 2,5 m/s<sup>2</sup>

**Item No:**

**HPX-S** (European standard slip-joint connection)

**HPX-B** (US standard ball-joint, key-hole connection)

## Flexible-Shaft Drive - Slip Joint Connection



**Straight Rotary Handpiece** supplied with collet  $\varnothing$  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
$\varnothing$ 3,0 mm	HSE/D3,0

---

## Rotary Handpiece - C-HPM-B1



**Micro-motor driven high speed rotary handpiece 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: L 159 x  $\varnothing$ 29,5 mm  
Noise: < 70 db(A) at 38.000 rpm  
Vibrations: < 2,5 m/s<sup>2</sup>

Item number: C-HPM-B1

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## Brushless Rotary Handpiece - C-HPM-BL1



**Micro-motor driven rotary handpiece 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: L 159 x  $\varnothing$ 27 mm  
Noise: < 70 db(A) at 40.000 rpm  
Vibrations: < 2,5 m/s<sup>2</sup>

Item number: C-HPM-BL1

## Brushless Rotary Handpiece - C-HPM-BL2



**Micro-motor driven high speed rotary handpiece 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 handpieces 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 handpiece 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 handpiece 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>

### 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-BL1

**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

*To be replaced with new one.*

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## 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
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## Suspension Stand

*To be replaced with new one.*

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## 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

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## 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 Handpiece for DUS-300 (DUS-300-HP)
- Handpiece 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)
- Handpiece 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 µm) 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 Electroplated 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 µm
Dimensions:	144(W) x 195 (D) x 95(H) mm
Weight:	658 g

#### Handpiece

Cord length:	1500 mm
Dimensions:	Ø 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

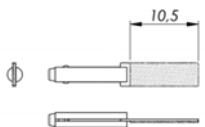
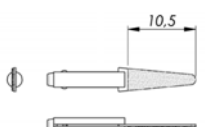
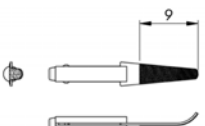
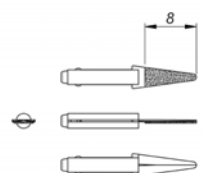


Diprofil Diamond Files are made from carefully selected diamonds, precisely bonded to obtain the best physical properties for added strength and resistance to wear. Diamond files are excellent for use on carbide, hardened steel, glass, ceramics and other similar materials.

Other shapes, dimensions and grit sizes available on request.

## DLT - LTA Filing Tips

All filing tips are sold in packages of 3 pcs.

Description		Grit size	Colour Code	Item No
Diamond Filing Tips, from 30 micron to FEPA D181. A thin tip with rectangular shape, for use on all surfaces.		D181 D151 D64 30 µm	Red Green Yellow White	DLT-10-150 DLT-10-100 DLT-10-50 DLT-10-30
Diamond Filing Tips, from 30 micron to FEPA D151. A thin tip with spatula shape, for use in narrow spaces.		D181 D151 D64 30 µm	Red Green Yellow White	DLT-20-150 DLT-20-100 DLT-20-50 DLT-20-30
Diamond Filing Tips, FEPA D64. For use on concave surfaces.		D64	Yellow	LTA-E50/3
Diamond Filing Tips, From 15 micron to FEPA D181. For use on concave surfaces.		D181 D151 D107 D64 30 µm 15 µm	Red Green Gold Yellow White Violet	LTA-S150/3 LTA-S100/3 LTA-S75/3 LTA-S50/3 LTA-S30/3 LTA-S15/3

## Filing Tip Holders

Tool-holder to be used together with diamond filing tips type DLT/LTA in the Dipromini polishing/filing machines.  
Length = 40 mm.

<b>Tool holder</b> 40 mm	<b>Item number</b> FMR-20
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# DLA® - Machine Files

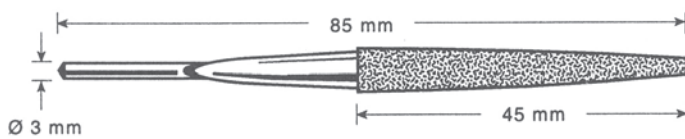


Standard Files		Item number		
Shape	Size (mm)	Grit D64	Grit D151	Grit D181
	2x1	DLA-2x1S-D64	DLA-2x1S-D151	DLA-2x1S-D181
	3x1	DLA-3x1S-D64	DLA-3x1S-D151	DLA-3x1S-D181
	4x1	DLA-4x1S-D64	DLA-4x1S-D151	DLA-4x1S-D181
	4x2	DLA-4x2S-D64	DLA-4x2S-D151	DLA-4x2S-D181
	5x2	DLA-5x2S-D64	DLA-5x2S-D151	DLA-5x2S-D181
	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



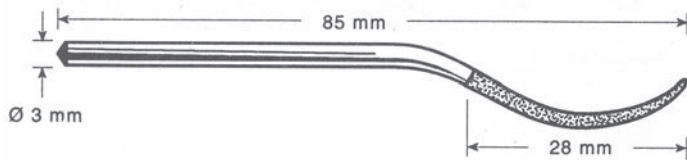
Standard Files		Item number
Shape	Size (mm)	Grit D151
	5x2	DLE-11-D151
	Ø 3	DLE-2-D151
	5x2	DLE-30-D151
	5x2	DLE-4-D151
	3,5x3,Sx3,5	DLE-5-D151
	2,5x2,5	DLE-6-D151

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

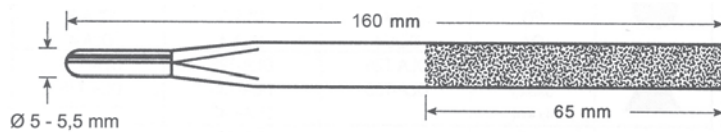


## DLF - Machine Files



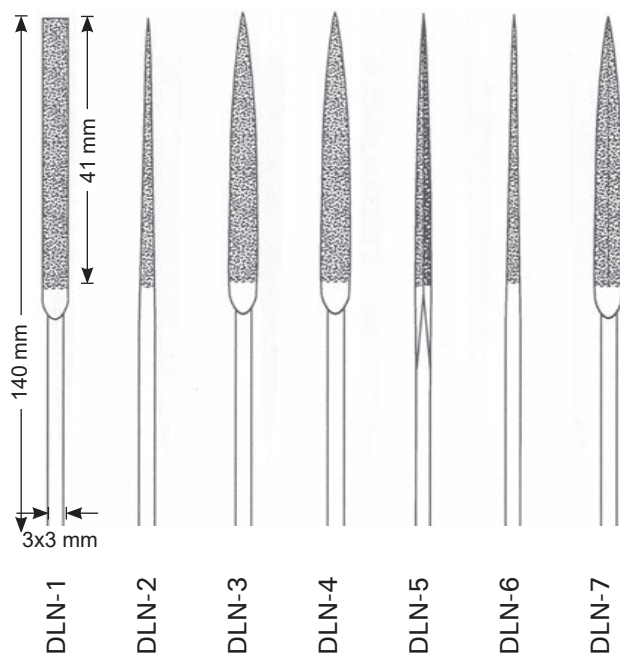
Shape	Size (mm)	Item number	
		Grit D151	
	4,5x2,5	DLF-1-D151	
	Ø 3	DLF-2-D151	
	5x2,5	DLF-4-D151	
	3x3	DLF-6-D151	

## DLK - Machine File



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

## DLN - Hand Files



Shape	Size (mm)	Item number	
		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

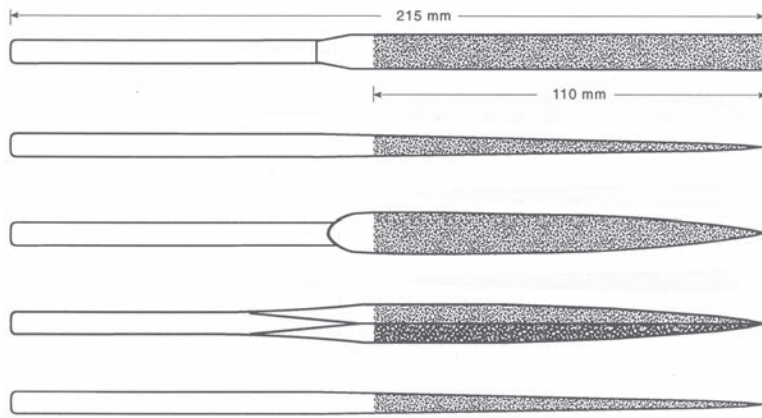
## DLN-Set

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



Type	Item number	
	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

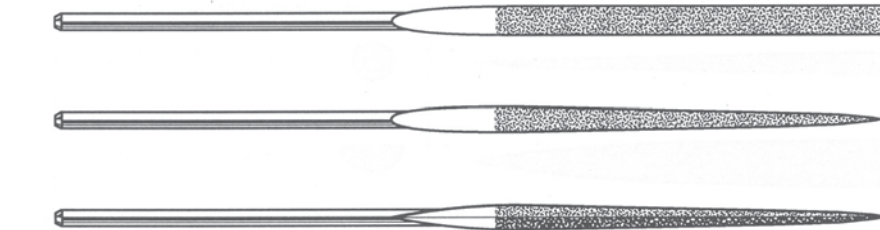
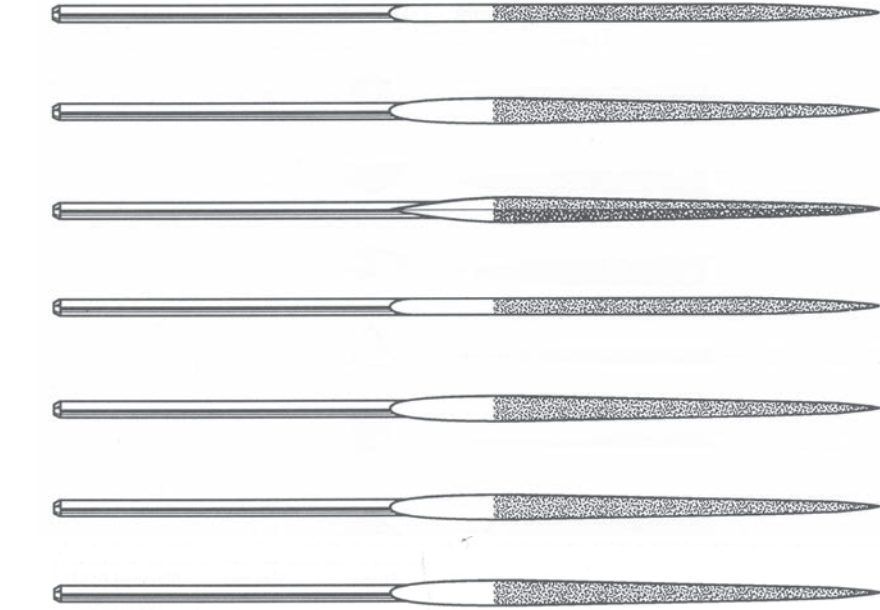
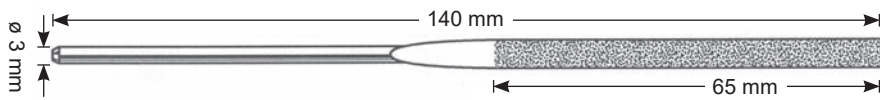
## FILE HANDLES

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



# 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.

Item number	
Type	Grit D151
DLH-Set	DLH/D151

# DIPRO® DIAMOND FILES

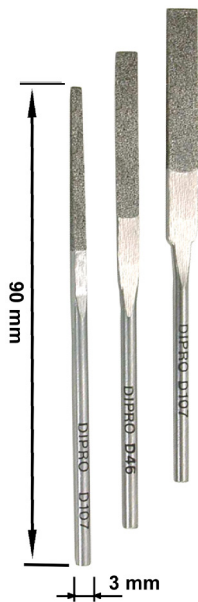
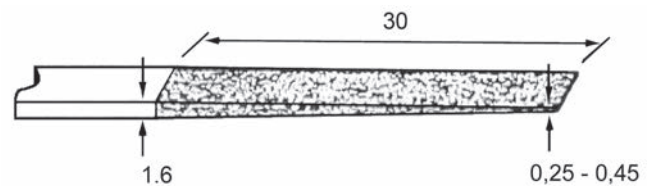
## DIPRO® PRECISION DIAMOND FILES

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 are 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

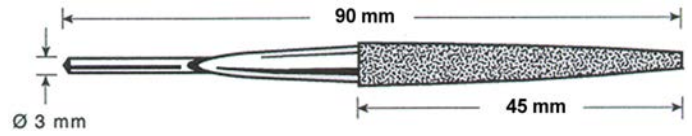
### DLM-Set







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



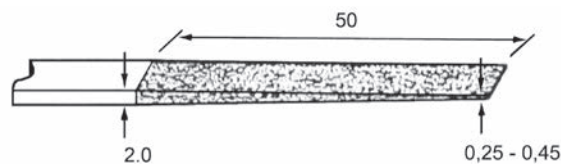
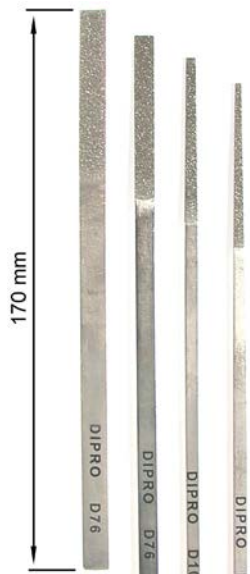
### DLB-Set

Set consisting of the above 6 different DLB files

#### Item number

DLB-SET-D107

# DLS - Conical Hand Files



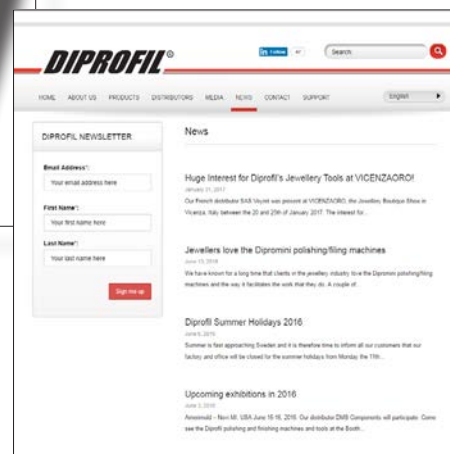
Shape	Size (mm)	Item number			
		Grit D30	Grit D46	Grit D76	Grit D107
	4 / 2	DLS-1-D30	DLS-1-D46	DLS-1-D76	DLS-1-D107
	4 / 3	DLS-2-D30	DLS-2-D46	DLS-2-D76	DLS-2-D107
	6 / 6	DLS-3-D30	DLS-3-D46	DLS-3-D76	DLS-3-D107
	8 / 8	DLS-4-D30	DLS-4-D46	DLS-4-D76	DLS-4-D107

## DLS-Set



Sets consisting of 10 different DLS-handfiles.

Type	Item number
DLS 2,3,4 in D46; DLS 1,2,3,4 in D76; DLS 2,3,4 in D107	DLS/1
DLS 1,2,3,4 in D30; DLS 1,2,3,4 in D46; DLS 1,2 in D76	DLS-SET-F













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## 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

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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## 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



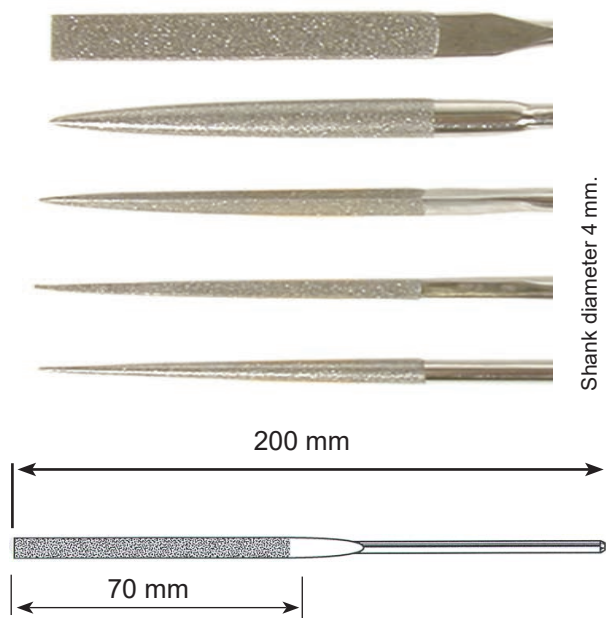
## DLD-Set

Set consisting of the above 10 different DLD-handfiles.

Item number
DLD-SET-D107



# 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.

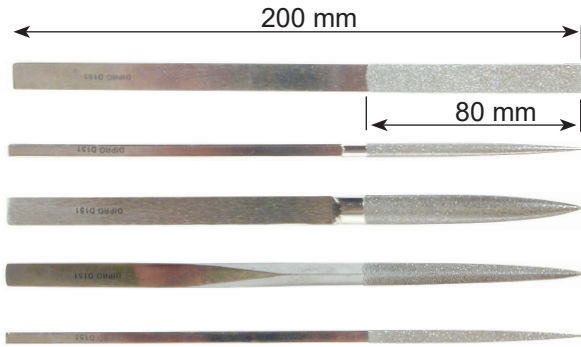
### Item number






DLQ-SET-D46  
DLQ-SET-D126

WE OFFER CUSTOMER SPECIFIC DIAMOND & CBN TOOLS  
ACCORDING TO CUSTOMER SPECIFICATIONS

Please send your inquires to [sales@diprofil.se](mailto:sales@diprofil.se)

## 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



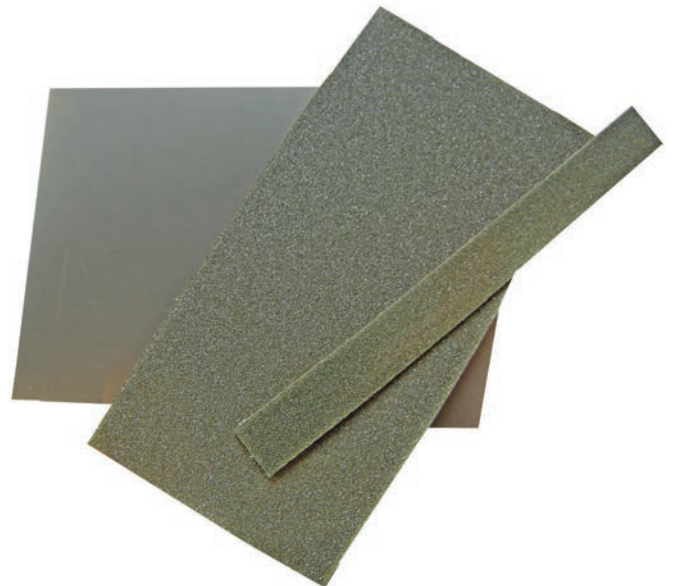
## DLX-Set

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



The 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

Recommended speed for wet cutting:

Diamond: 15 – 30 m/s

CBN: 20 – 45 m/s

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.

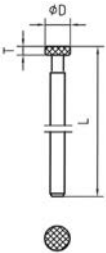
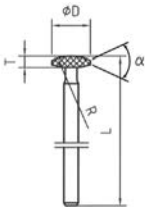
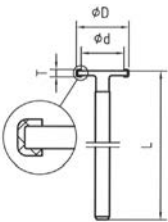
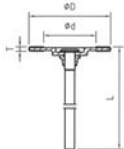
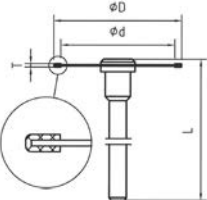
### Recommended speeds in RPM

Tool Ø (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

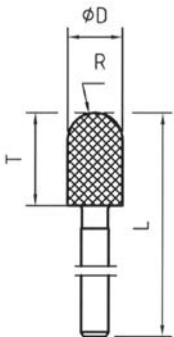
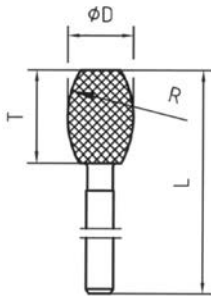
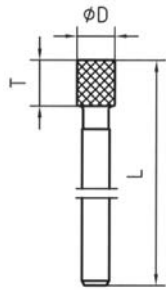
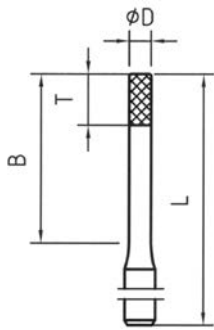
# Shank Diameter: Ø 2,35 mm

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

# Shank Diameter: Ø 2,35 mm

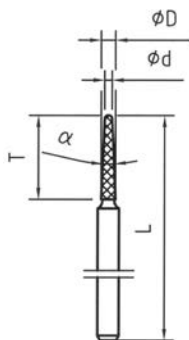
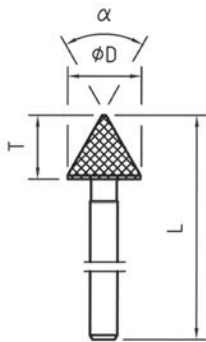
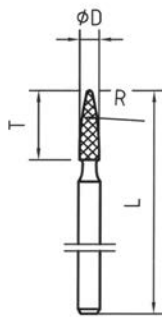
			Item number
Shape	Dimensions	Grit Size	
	Wheel D 6,3, T 0,5, L 40	D 151	DT-129P-HP
	Wheel D 9,3, a 16°, T 1,3, L 40,2	D 151	DT-109-HP
	Grinding wheel D 8,7, d 7,0, T 1,3, L 40 D 9,0, d 7,0, T 0,6, L 40 D 12,9, d 9,5, T 1,4, L 45,4	D 151 D 151 D 151	DT-56P-HP DT-128P-HP DT-55P-HP
	Grinding wheel D 20,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

# Shank Diameter: Ø 3,0 mm



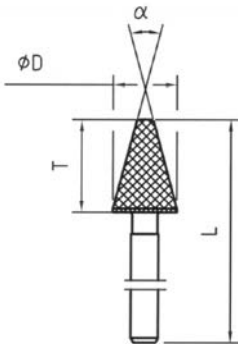
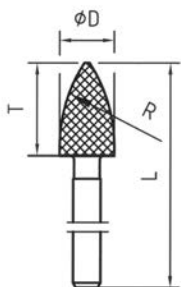
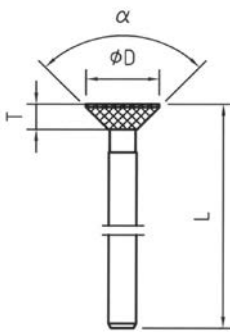
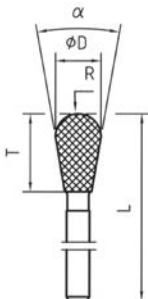
			Item number	
Shape	Dimensions	Grit Size		
Cylinder	D 0,8, T 4,0, B 7, L 46	D 107	D-0308L-H3	
	D 1,0, T 4,0, B 8, L 46	D 107	D-0310L-H3	
	D 1,5, T 4,0, B 10, L 46	D 107	D-0315L-H3	
	D 2,0, T 5,0, B 14, L 46	D 151	D-0320L-H3	
	D 2,0, T 5,0, B 14, L 46	D 64	D-0320L-H3-D64	
	D 2,5, T 5,0, B 19, L 46	D 151	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



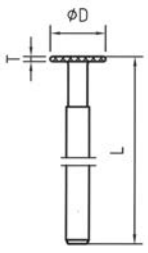
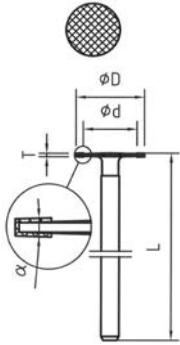
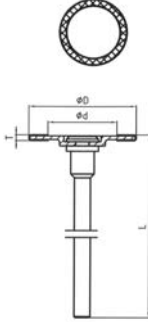
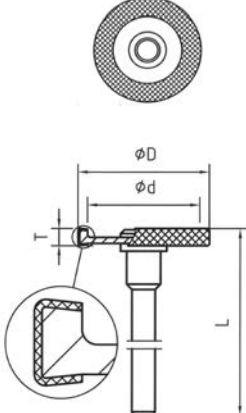
Shape	Dimensions	Grit Size	Item number	
Ball	D 1,7, L 46	D 151	D-0116-H3	
	D 1,7, L 46	D 64	D-0116-H3-D64	
	D 2,1, L 46	D 151	D-0120-H3	
	D 2,5, L 46	D 151	D-0124-H3	
	D 3,0, L 46	D 151	D-0130-H3	
	D 3,0, L 46	D 64	D-0130-H3-D64	
	D 4,1, L 46	D 151	D-0140-H3	
	D 5,0, L 46	D 151	D-0150-H3	
	D 6,0, L 46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

# Shank Diameter: Ø 3,0 mm

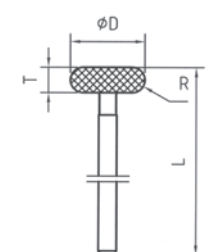
	Shape	Dimensions	Grit Size	Item number
	Cone flat end	D 1,6, d 0,9, a 4°, T 10, L 46 D 2,1, d 1,4, a 4°, T 10, L 46 D 2,1, d 1,4, a 4°, T 10, L 46 D 2,6, d 1,75, a 4°, T 7, L 46 D 7,0, d 2,0, a 30°, T 10, L 49 D 8,0, d 1,4, a 45°, T 8,5, L 47,5	D 151 D 151 D 64 D 151 D 151 D 151	D-0516L-H3 D-0521L-H3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



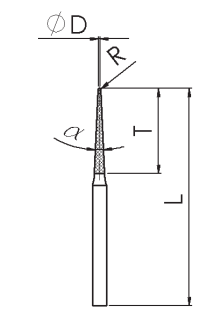
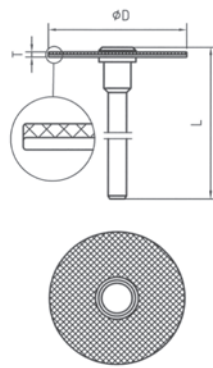
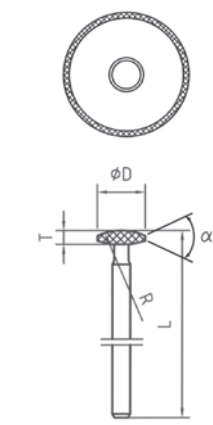
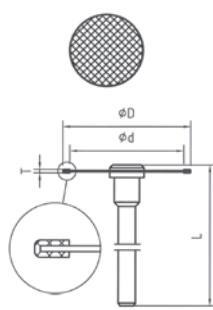
# Shank Diameter: Ø 3,0 mm

	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 0,7, 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



	Shape	Dimensions	Grit Size	Item number
	Grinding wheel	D 5,8, T 2,3, R 1, L 41 D 9,8, T 3,4, R 1,5, L 42,2	D 151 D 151	D-1422-H3 D-1430-H3
	Cutting wheel	D 15,0, d 13,0, T 0,6, L 48 D 18,0, d 16,0, T 0,6, L 48 D 22,0, d 20,0, T 0,6, L 48 D 36,0, d 34,0, T 1,0, L 48	D 151 D 151 D 151 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 D 9,3, a 7,5°, T 1,3, L 41	D 151 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, L 46	D151	S-067

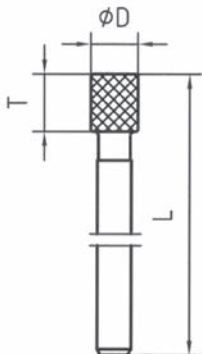


# Diamond Grinding Pin Sets - Shank Diameter Ø 3,0 mm



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 D-0130-H3 D-0320L-H3 D-0330L-H3 D-0720-H3 D-0521L-H3 D-5830-H3 D-0916L-H3 D-0924L-H3 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 D-0130-H3-D64 D-0320L-H3-D64 D-0330L-H3-D64 D-0720-H3-D64 D-0521L-H3-D64 D-5830-H3-D64 D-0916L-H3-D64 D-0924L-H3-D64 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) D-0310L-H3 (D 107) D-0315L-H3 (D 107) D-0320L-H3 D-0325L-H3 D-0330L-H3 D-0116-H3 D-0120-H3 D-0124-H3 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

# Diamond Cutting Discs



Other dimensions and grit sizes available on request

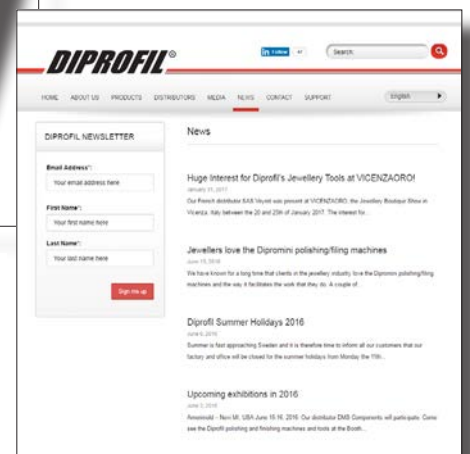
Dimensions (Ø x Width x Bore Ø)	Grit Size	Item number
20 x 0,4 x 2,5	D107	ASEA-20/040
20 x 0,6 x 2,5	D151	ASEA-20/060
20 x 0,8 x 2,5	D151	ASEA-20/080
20 x 1,0 x 2,5	D151	ASEA-20/100
22 x 0,6 x 2,5	D151	ASEA-22/060
25 x 0,8 x 2,5	D151	ASEA-25/080
30 x 0,8 x 6	D151	ASEA-30/080
36 x 1,0 x 2,5	D151	ASEA-36/100

# 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



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by visiting our website  
[www.diprofil.com](http://www.diprofil.com)

# DIAMOND COMPOUND



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

## Diamond Compound Type OWS - Oil/Water Doluble

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

## Diamond Compound Type Plus

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

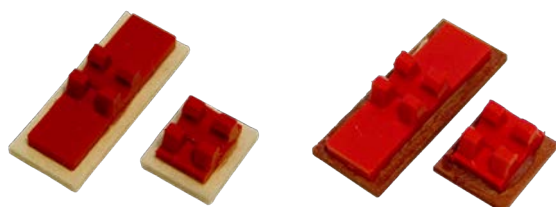
# POLISHING, LAPPING AND HONING TOOLS



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

## 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

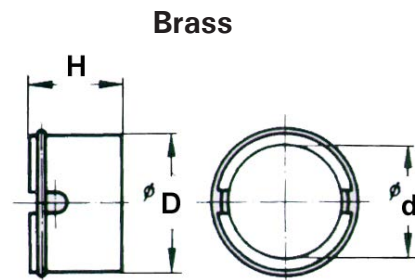
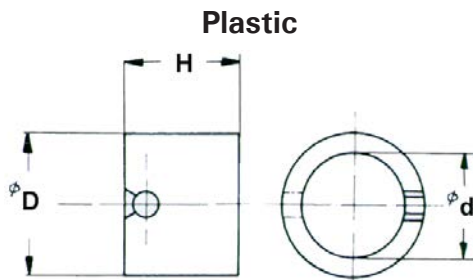


# Lapping Rings

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

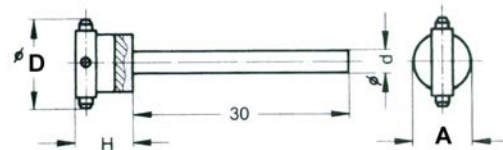


Material	Type	Ø D (mm)	Ø d (mm)	Height (mm)	Quantity	Item number
Plastic	8	9	6	6	10 pcs	LRP-8
Plastic	12	13	10	8	10 pcs	LRP-12
Plastic	20	21	17	14	10 pcs	LRP-20
Brass	8	8	6	6	10 pcs	LRB-8
Brass	12	12	10	8	10 pcs	LRB-12
Brass	20	20	17	14	10 pcs	LRB-20



# Mandrels

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



For use with:	Ø D (mm)	Shank Ø d (mm)	H (mm)	A (mm)	Item number
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

# Felt Polishing Sticks

Now even in wood.



(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

Assortment of 1 each of the above Felt Polishing Sticks (6 pcs)

## Item number

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
20x10	50 pcs	FP-2010

# Felt pad holder

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

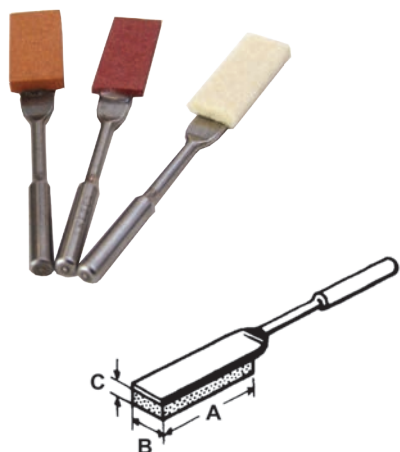


## Item number

FPH-385

# Lapping tools

Rectangular lapping tools on shank diameter 3,0 mm

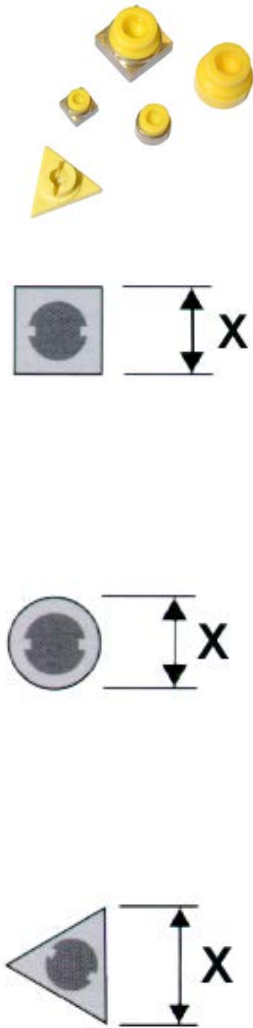


Type	Dimensions (AxBxC)	Item number
Copper	18 x 7 x 1 mm	LLB-2A
Fibre	18 x 7 x 1,5 mm	LLB-4A
Felt	18 x 7 x 3 mm	LLB-7A



# 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

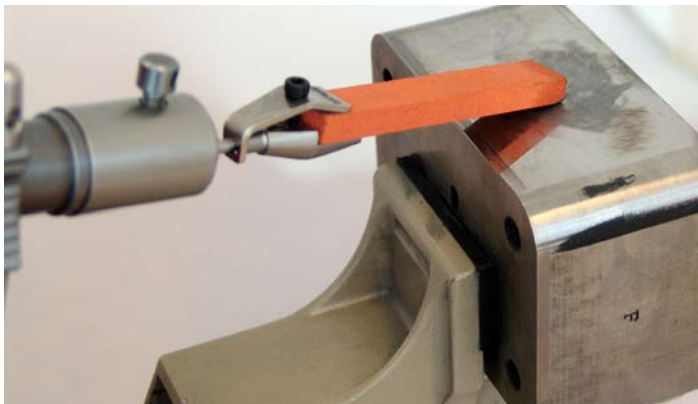
For use together with Lapping bits.



			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.



## 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 (EDM) 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.

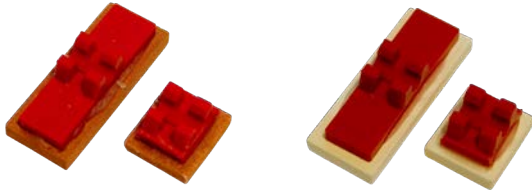


Size (mm)	Grit size	Item number
6x6x150	220	MOL-248
"	320	MOL-249
"	400	MOL-250
"	600	MOL-251
10x10x150	220	MOL-253
"	320	MOL-254
"	400	MOL-255
"	600	MOL-256
13x3x150	220	MOL-263
"	320	MOL-264
"	400	MOL-265
"	600	MOL-266
13x6x150	220	MOL-268
"	320	MOL-269
"	400	MOL-270
"	600	MOL-271
Ø 10x150	220	MOL-283
"	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 51 and 52.

Type	Dimension (mm)	Grit size	Quantity	Item number
EDM	33x13x3	G120	1 pc	EDM-33-120
EDM	33x13x3	G180	1 pc	EDM-33-180
EDM	33x13x3	G320	1 pc	EDM-33-320
MOL	33x13x3	G400	1 pc	MOL-33-400
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  $\varnothing$  3,5 mm  
Length 140 mm



**Item number**

TR-3140

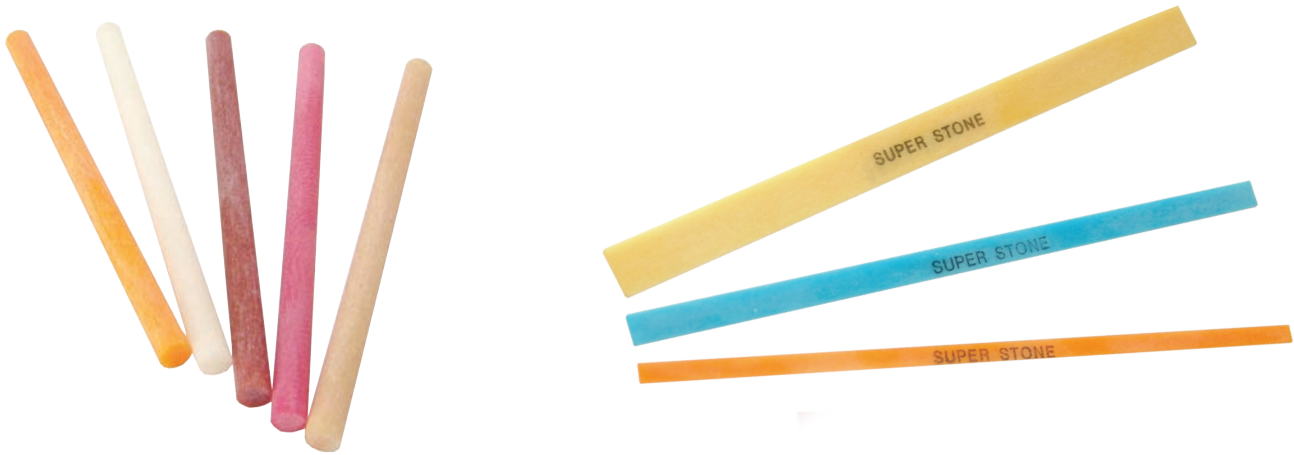
## Stoning Oil

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

POLISHING STONES OF OTHER DIMENSIONS  
AND GRIT SIZES ARE AVAILABLE ON REQUEST.

Please send your inquiries to [sales@diprofil.se](mailto:sales@diprofil.se)

# 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.



Dimension	Grit	Colour	Item number
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.



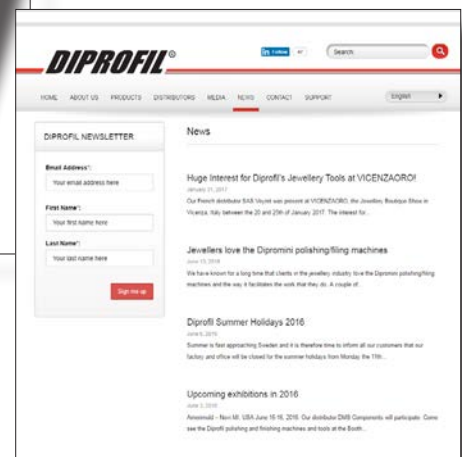
Dimension	Grit	Colour	Item number
Ø 3 x 50	120	Green	SED 3 A
Ø 3 x 50	180	Yellow	SGD 3 A
Ø 3 x 50	300	Light Brown	SLD 3 A
Ø 3 x 50	400	Orange	SOD 3 A
Ø 3 x 50	600	Brown	SPD 3 A
Ø 3 x 50	800	Blue	SBD 3 A
Ø 3 x 50	1000	White	SWD 3 A
Ø 3 x 50	1200	Red	SRD 3 A

# 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 with the latest news from Diprofil by visiting our website [www.diprofil.com](http://www.diprofil.com)

# TOOL HOLDERS

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



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## Polishing Stones Holder



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

**Item number**

BEA

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## 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  $\varnothing$  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.

### Item number

THFS-1

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

## Universal Tool Holder



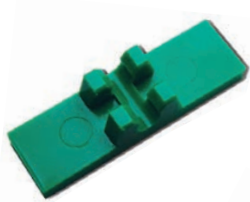
Tool-holder made of hardened steel for use together with polishing stones and lapping/polishing tools with a thickness of 3 mm.

### Item number

THPS-3

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

## Plastic shoes / Tool holders

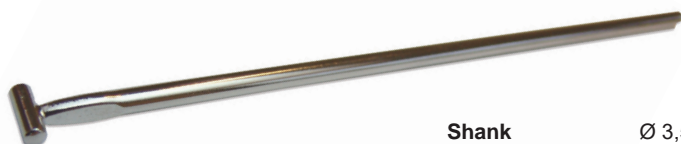


Plain plastic shoes for making your own special tools adapted to the specific application.

		Item number
Dimension (mm)	Quantity	
30x9x2	10 pcs	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.



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

Item number
SSH-2
SSH-4
SSH-6
SSH-10

## Reduction sleeve

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



	Item number
Length	
16,5 mm	RHB

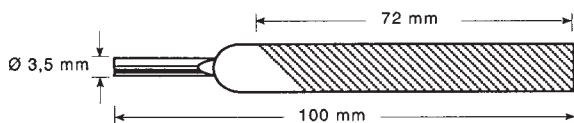
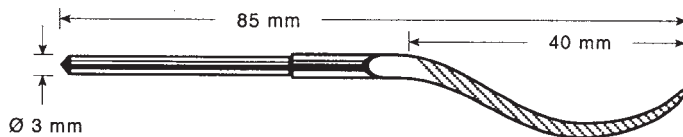
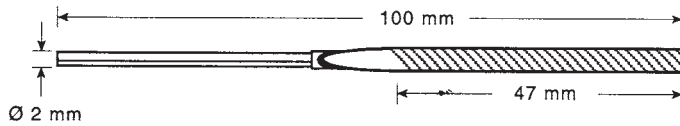
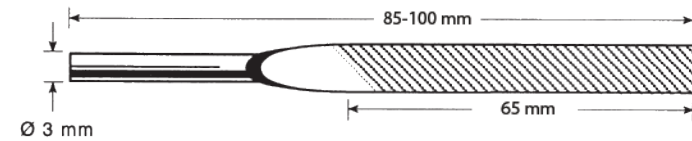
# PRECISION STEEL FILES

Diprofil precision steel files for use in soft and semi-hard steel as well as other materials 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

# DIPROFIL/VALLORBE STEEL FILES TYPE MINI

Steel files for use on soft to medium-hard steel as well as on other similar materials.

An excellent choice when working with the Dipromini polishing/filing machine.

Medium cut (-0) = 25 teeth/cm

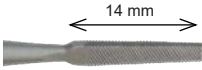
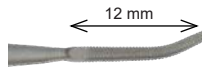

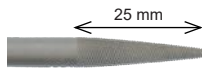
Fine cut (-4) = 56 teeth/cm

Total length = 40 mm

Shaft = aprox. Ø 3



## Steel Files

		Item number	
Shape	Size (mm)	Medium Cut-0	Fine Cut-4
	2 x 1,2	STL-910-0	STL-910-4
	2 x 1,2	STL-911-0	STL-911-4
	2,6 x 2,6 x 2,6	STL-941-0	STL-941-4
	Ø 3,1	STL-980-0	STL- 980-4



# 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

***DIPROFIL***<sup>®</sup>

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