



### Safety Precautions

When using this product, observe the precautions regarding its specifications, functions, and use that are described in this document. Failure to do so may impair the safety of the product.

### Before Using This Product

In order to achieve the best performance of this product and to keep the product in its best condition so that it can be used for many years, read this document thoroughly before using this product. After reading, retain it in a safe place.

### Precautions regarding Transfers Outside Japan

This product is subject to the Foreign Exchange and Foreign Trade Act of Japan. If you intend to transfer products or technologies from a country other than Japan, please contact Mitutoyo in advance.

### Conventions Used in This Document

#### ■ Safety reminder conventions warning against potential hazards

<b>NOTICE</b>	Indicates a situation which, if not avoided, may result in property damage.
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#### ■ Conventions indicating referential information

<b>Tips</b>	Indicates further information and details relevant for the operating methods and procedures explained in that section.
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### Precautions for Use

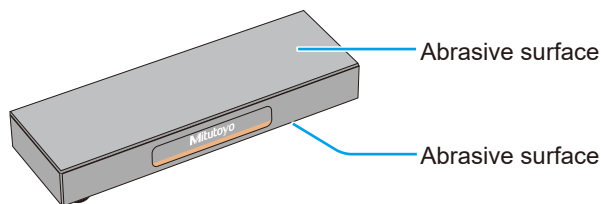
- This product must be carefully handled. Be careful not to apply excessive shock or force to any of the parts during storage or use.
- Before use, use a soft cloth soaked in solvent, etc., to wipe off any dirt or rust-proofing oil. Do not use organic solvents such as thinner or benzene.
- We recommend using this product in a location that is subject to little debris, dust, and vibration. Usage upon a surface plate is also recommended.

### Limited Warranty

This product has been manufactured under strict quality management, but should it develop problems within one year of the date of purchase in normal use, repair shall be performed free of charge. Please contact the agent where you purchased the product or a Mitutoyo sales office.

## 1. Overview

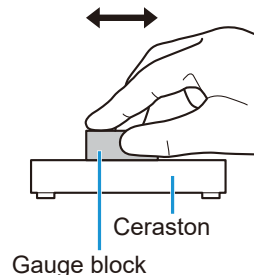
- Ceraston is an alumina-ceramic deburring stone that enables more efficient burr removal than conventional Arkansas stones.
- It can be used for deburring both steel gauge blocks and ceramic gauge blocks (CERA Blocks).
- Both sides can be used. Please attach the four included rubber feet to one side before use.



## 2. How to Use

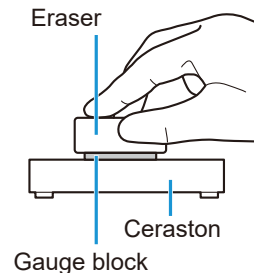
- 1 Wipe the Ceraston abrasive surface and the measuring surface of the gauge block from which you want to deburr with a solvent to clean them.
- 2 Place the gauge block on top of the Ceraston with the measuring surface, from which you want to deburr, facing down.

- 3 While gently pressing the gauge block, move it back and forth slowly about 10 times.



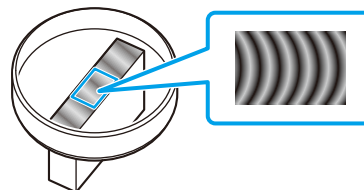
### Tips

- For thin gauge blocks, using a rubber piece such as an eraser helps apply uniform pressure and makes the work easier.



- Minor burrs such as those from scratches can be removed with about 10 back-and-forth strokes. For larger burrs such as those from impact marks, especially on hard CERA Blocks, press firmly and rub thoroughly. Even with firm rubbing, the dimensions will not change, so please use with confidence.

- 4 Check for the presence of burrs on the gauge block using an optical flat (code No. 158-117, 158-118, 158-119, 158-120, 158-121, 158-122, 158-123 or 158-124).



If burrs have not been fully removed, repeat Step 3. In some cases, it may be better to replace the gauge blocks with new ones.

### Tips

After deburring every 5 to 10 gauge blocks, wipe the abrasive surface of the Ceraston with a solvent.

## 3. Maintenance

- After use, make sure to dry it completely before storage.

### NOTICE

Storing it while still wet may cause cracks due to temperature changes.

- With prolonged use, deburring performance declines, so the surface needs to be reconditioned.
  - For surface correction, use wet lapping powder of approximately GC #2000. Place the Ceraston on a flat cast-iron surface plate and move it back and forth.
  - After correcting the surface, use a carbide plate or similar to dull the entire lapped surface of the Ceraston, ensuring that the measuring surface of the gauge block is not scratched.
  - We also offer surface reconditioning services. To request this service, please contact the agent where you purchased the product or a Mitutoyo sales office.

## 4. Specifications

Code No.	601644	601645
Dimensions (W) x (D) x (H)	150 mm x 50 mm x 20 mm	100 mm x 25 mm x 12 mm