



خمیر Lapping :

خمیر N.G.S Lapping مناسب برای صاف و صیقل دادن سطح قطعات حساس فلزی بوده که در ساخت آن از سیلیکون کارباید در اندازه های مختلف استفاده شده است.

کاربردهای خمیر Lapping:

- ۱- Valve Seats
- ۲- Mechanical Seal Faces & Spacers
- ۳- Shaft Surface/ Bearing Races / machine ways
- ۴- Sharpening of shear-type cutters
- ۵- Clean surfaces & remove metal or material too hard

سایز بندی خمیر:

Grade and Grit Selector Guide

(1 lb. can)	GRIT	Descriptions	Average Particle Sizes of Abrasive Grains	
			1/1000 inches	Microns (0.001 mm)
	1200	EXTREMELY FINE Polishing, High Precision Lapping	0.12	3
	1000		0.20	5
	800		0.38	9
	600	VERY FINE For fine Polishing and Lapping	0.56	14
	500		0.68	17
	400		0.90	23
	320	FINE For Finishing, Valve Lapping, Bearings, Dies and Gauges	1.28	33
	280		1.75	44
	240	MEDIUM FINE For Cylinder Lapping	2.48	63
	220		2.6	66
	180	MEDIUM General Purpose for controlled Metal Removal	3.4	86
	150		4.8	122
	120	COARSE For the Initial "Cut" Fast Removal of Metal	5.6	142
	100		6.8	173
	80		15	267
	54	VERY COARSE For Fastest Metal Removal	18	463



N.G.S LAPPING COMPOUNDS

N.G.S LAPPING COMPOUNDS are abrasive pastes for the cutting, smoothing and finishing of metal surfaces, and for the precision mating of metal parts. For many years N.G.S Compounds have helped mechanics, tool and die makers, and machine builders create precision, silky-smooth fits in machine parts, valve seats and gear teeth.

N.G.S Compounds are formulated from silicon carbide abrasives. These compounds are classified by grit size; from very coarse to extremely fine. They are available in grease based formulations.

N.G.S Compounds are used to:

- **Produce an ultra flat surface** as in the lapping or gauges, valve seats, spacers and mechanical seal faces.
- **Smooth out surfaces** as in the lapping of tool marks from machine ways, bearing races and shaft surfaces.
- **Achieve precise dimensions while maintaining smooth surfaces** as in finishing gauges, tools and dies.
- **Achieve perfect mating of metal parts** as in lapping in of automotive and industrial valves, running-in gears, and sharpening of shear-type cutters.
- **Clean surfaces without changing the topography of the surfaces** as in cleaning mold cavities and die surfaces.
- **Remove metal or material too hard to remove in other ways** as in finishing hardened tool steel or stellite valve seats.

The Abrasives:

N.G.S compounds are available with the following abrasive grains and in a range of grit sizes. See the chart for availability of grit by size.

Silicon Carbide

The preferred abrasive for fast cutting of all but the hardest and toughest metals. It will produce a smooth flat surface but not a polished one.

The Carriers:

Grease Mix

The most widely used carrier for N.G.S abrasives. It retains its texture and lubrication properties during extended lapping and leaves a rust- preventing film on lapped surfaces.

N.G.S Lapping Compounds :

N.G.S Lapping Compounds are used on dies, molds, lapping plates, ceramic, electronic, carbide valve industry, precious & semiprecious stones, and many other applications that require a mirror finish and close tolerance.

PRODUCT DESCRIPTION :

Silicon Carbide Grease Mix provides the following product characteristics:

Technology	Grinding Compound
Chemical Type	Silicon carbide in a petroleum carrier
Appearance	Grey/ Black paste
Cure	Non-curing
Application	Grinding, Lapping and Honing
Specific Benefit	<ul style="list-style-type: none">• Sixteen (16) discrete particle sizes- 1200, 1000, 800, 600, 500, 400, 320, 280, 240, 220, 180, 150, 120, 100, 80, 54• Each grit is held within either ANSI or FEPA specifications for particle size distribution.

TYPICAL PROPERTIES

Specific Gravity @ 25°C 1.1 to 1.24

Hardness Value 9.5

Flash Point-See MSDS

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).



Material Safety Data Sheet

Section I - Chemical product and company Identification

Product name : Lapping Paste Item No : 77135

Company Identification:

Napht gostar co.
 Fax:041-33328952
 Mobile:09370658034
 Tel :041-34252985
www.naphtgostar.com

Section II - Hazard Ingredients/Identity Information

Hazardous Components(Specific Chemical Identity; Common Name(s))	OSHA PEL	ACGIH TLV	OTHER LIMITS RECOMMENDED	% (OPT)
14808-60-7 GROUND SILICA ABRASIVE	.19 mg/M3	.1 mg/M3	None	10-25%
1302-62-1 GROUND NATURAL ABRASIVE	15 mg/M3	10 mg/M3	None	50-70%
7727-43-7 BARIUM SULFATE	10 mg/M3	10 mg/M3	None	10-20%
25155-30-0 DETERGENT	15 mg/M3	10 mg/M3	None	5-20%

Section III – Physical/Chemical Characteristics

Boiling Point	N.A.	Specific Gravity (H ₂ O = 1) SILICA	2.3
Vapor Pressure (mm Hg.)	N.A.	Melting Point	N.A.
Vapor Density (AIR = 1)	N.A.	Evaporation Rate (Butyl Acetate = 1)	N.A.
Solubility in Water INSOLUBLE			
Appearance and Odor ODORLESS			

Section IV - Fire and Explosion Hazard Data

Flash point (Method used) N.A.	Flammable Limits N.A.	LEL N.A.	UEL N.A.
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Extinguishing Media: Water, Fog or Flood

Special Fire Fighting Procedures: Wear full body protective clothing and self contained breathing apparatus.

Unusual Fire and Explosion Hazards: Fume, vapor and dust may occur and are considered toxic. The product or dust can react with strong oxidizing agents.

Section V – Reactivity Data

Stability: Stable <input checked="" type="checkbox"/> Unstable	Conditions to Avoid: None		
Incompatibility (Materials to Avoid): Acids and Oxidizing Agents			
Hazardous Decomposition or Byproducts: When heated to decomposition compounds emit sulfur dioxide			
Hazardous Polymerization	May Occur	Will Not Occur <input checked="" type="checkbox"/>	Conditions to Avoid: None

Section VI – Health Hazard Data

Route(s) of Entry:	Inhalation? YES	Skin? NO	Ingestion? YES
Health Hazards (Acute and Chronic) Prolonged overexposure to respirable silica above the threshold limit may cause scarring of the lungs with coughing, shortness of breath or silcosis.			
Carcinogenicity: None	NTP? No	IARC Monographs? No	OSHA Regulated? No
Signs and Symptoms of Exposure: Silica – Coughing, Shortness of breath			
Medical Conditions Generally Aggravated by Exposure: Asthma, Emphysema, Gastroentitis			
Emergency and First Aid Procedures: None – Consult Physician			

Section VII – HMIS and NFPA Ratings

	HMIS	NFPA
Health	*	2
Flammability	0	0
Reactivity	0	0
Protective Equipment	E	-

Section VIII - Precautions for Safe Handling and Use

Steps to Be Taken in Case Material is Released or Spilled: Vacuum clean, do not broom sweep. Keep in closed container until disposal.
Waste Disposal Method: Industrial Waste Disposal according to Local, State and Federal Regulations or other EPA Method.
Precautions to Be Taken in Handling and Storing: Keep in closed container in a dry place. Do not permit contact with Acids, Alkalis or Strong Oxidizing Agents. Shelf Life - Indefinite
Other Precautions: None Known

Section IX – Control Measures

Respiratory Protection (<i>Specify Type</i>) When necessary, use a NIOSH approved dust respirator, HEPA filter.		
Ventilation	Local Exhaust In front of worker	Special OSHA approved if over TLV Limits
	Mechanical (<i>General</i>) Normal airborne dust removal	Other None Known
Protective Gloves: Desirable, not necessary		Eye Protection: Desirable, not necessary
Other Protective Clothing or Equipment: If prolonged exposure over TLV, disposable coveralls, gloves		
Work/Hygienic Practices: Avoid breathing dust. Wash hands before eating or smoking.		

Section X – Transportation Information

Timesaver Lapping Compounds are not a hazardous material for purposes of transportation .

